










**PCD END MILL • ALCB • APPLICATION DATA**

														
	<b>Side Milling (A) and Slotting (B)</b>			<b>KD1410</b>			<b>Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.</b>							
<b>Material Group</b>	<b>A</b>		<b>B</b>	<b>Cutting Speed – vc SFM</b>			<b>frac. dec.</b>	<b>D1 – Diameter</b>						
	<b>ap</b>	<b>ae</b>	<b>ap</b>	<b>min</b>		<b>max</b>		<b>1/4</b>	<b>5/16</b>	<b>3/8</b>	<b>1/2</b>	<b>5/8</b>	<b>3/4</b>	
<b>N</b>	1	1 x D	0.25 x D	0.5 x D	660	–	9840	IPT	0.0029	0.0031	0.0034	0.0058	0.0063	0.0060
	2	1 x D	0.25 x D	0.5 x D	660	–	9840	IPT	0.0029	0.0031	0.0034	0.0058	0.0063	0.0060
	3	1 x D	0.25 x D	0.5 x D	590	–	4590	IPT	0.0025	0.0027	0.0030	0.0050	0.0055	0.0053
	4	1 x D	0.25 x D	0.5 x D	660	–	2620	IPT	0.0025	0.0027	0.0030	0.0042	0.0047	0.0045
	5	1 x D	0.25 x D	0.5 x D	660	–	3280	IPT	0.0021	0.0023	0.0026	0.0038	0.0039	0.0038
	6	1 x D	0.25 x D	0.5 x D	490	–	2620	IPT	0.0017	0.0020	0.0023	0.0025	0.0031	0.0030
	7	1 x D	0.25 x D	0.5 x D	820	–	1640	IPT	0.0025	0.0027	0.0030	0.0050	0.0055	0.0053

**PCD END MILL • ALCC • APPLICATION DATA**

													
	<b>Side Milling (A) and Slotting (B)</b>			<b>KD1410</b>			<b>Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.</b>						
<b>Material Group</b>	<b>A</b>		<b>B</b>	<b>Cutting Speed – vc SFM</b>			<b>frac. dec.</b>	<b>D1 – Diameter</b>					
	<b>ap</b>	<b>ae</b>	<b>ap</b>	<b>min</b>		<b>max</b>		<b>1/4</b>	<b>5/16</b>	<b>3/8</b>	<b>1/2</b>	<b>5/8</b>	
<b>N</b>	1	1.5 x D	0.15 x D	0.5 x D	660	–	9840	IPT	0.0029	0.0031	0.0034	0.0058	0.0063
	2	1.5 x D	0.15 x D	0.5 x D	660	–	9840	IPT	0.0029	0.0031	0.0034	0.0058	0.0063
	3	1.5 x D	0.15 x D	0.5 x D	590	–	4590	IPT	0.0025	0.0027	0.0030	0.0050	0.0055
	4	1.5 x D	0.15 x D	0.5 x D	660	–	2620	IPT	0.0025	0.0027	0.0030	0.0042	0.0047
	5	1.5 x D	0.15 x D	0.5 x D	660	–	3280	IPT	0.0021	0.0023	0.0026	0.0038	0.0039
	6	1.5 x D	0.15 x D	0.5 x D	490	–	2620	IPT	0.0017	0.0020	0.0023	0.0025	0.0031
	7	1.5 x D	0.15 x D	0.5 x D	820	–	1640	IPT	0.0025	0.0027	0.0030	0.0050	0.0055

**PCD HELICAL END MILL • ALCR • APPLICATION DATA**

												
	<b>Side Milling (A) and Slotting (B)</b>			<b>KD1410</b>			<b>Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.</b>					
<b>Material Group</b>	<b>A</b>		<b>B</b>	<b>Cutting Speed – vc SFM</b>			<b>frac. dec.</b>	<b>D1 – Diameter</b>				
	<b>ap</b>	<b>ae</b>	<b>ap</b>	<b>min</b>		<b>max</b>		<b>1/2</b>	<b>5/8</b>	<b>3/4</b>		
<b>N</b>	1	2 x D	0.2 x D	0.5 x D	660	–	9840	IPT	0.0058	0.0063	0.0060	
	2	2 x D	0.2 x D	0.5 x D	660	–	9840	IPT	0.0058	0.0063	0.0060	
	3	2 x D	0.2 x D	0.5 x D	590	–	4590	IPT	0.0050	0.0055	0.0053	
	4	2 x D	0.2 x D	0.5 x D	660	–	2620	IPT	0.0042	0.0047	0.0045	
	5	2 x D	0.2 x D	0.5 x D	660	–	3280	IPT	0.0038	0.0039	0.0038	
	6	2 x D	0.2 x D	0.5 x D	490	–	2620	IPT	0.0025	0.0031	0.0030	
	7	2 x D	0.2 x D	0.5 x D	820	–	1640	IPT	0.0050	0.0055	0.0053	