





PCD END MILL • ALSB • APPLICATION DATA

Material Group											
	Side Milling (A) and Slotting (B)			KD1410			Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.				
	A		B	Cutting Speed – vc SFM			frac. dec.	D1 – Diameter			
	ap	ae	ap	min		max		1	1 1/4	1 1/2	
N	1	L10	0.25 x D	0.5*L10	660	–	9840	IPT	0.0072	0.0078	0.0078
	2	L10	0.25 x D	0.5*L10	660	–	9840	IPT	0.0072	0.0078	0.0078
	3	L10	0.25 x D	0.5*L10	590	–	4590	IPT	0.0064	0.0070	0.0070
	4	L10	0.25 x D	0.5*L10	660	–	2620	IPT	0.0056	0.0063	0.0063
	5	L10	0.25 x D	0.5*L10	660	–	3280	IPT	0.0048	0.0047	0.0047
	6	L10	0.25 x D	0.5*L10	490	–	2620	IPT	0.0040	0.0039	0.0039
	7	L10	0.25 x D	0.5*L10	820	–	1640	IPT	0.0064	0.0070	0.0070

PCD HELICAL END MILL • ALSR • APPLICATION DATA

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	Side Milling (A) and Slotting (B)			KD1410			Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.				
	A		B	Cutting Speed – vc SFM			frac. dec.	D1 – Diameter			
	ap	ae	ap	min		max		1	1 1/4	1 1/2	
N	1	1.25 x D	0.2 x D	0.25 x D	660	–	9840	IPT	0.0072	0.0078	0.0078
	2	1.25 x D	0.2 x D	0.25 x D	660	–	9840	IPT	0.0072	0.0078	0.0078
	3	1.25 x D	0.2 x D	0.25 x D	590	–	4590	IPT	0.0064	0.0070	0.0070
	4	1.25 x D	0.2 x D	0.25 x D	660	–	2620	IPT	0.0056	0.0063	0.0063
	5	1.25 x D	0.2 x D	0.25 x D	660	–	3280	IPT	0.0048	0.0047	0.0047
	6	1.25 x D	0.2 x D	0.25 x D	490	–	2620	IPT	0.0040	0.0039	0.0039
	7	1.25 x D	0.2 x D	0.25 x D	820	–	1640	IPT	0.0064	0.0070	0.0070