

■ HPHV

Material Group	Side Milling (A) and Slotting (B)			KCPM15		KC635M		Feed per Tooth – fz information is for side milling (A). For slotting (B), reduce fz by 20%.												
	A		B	Cutting Speed – vc SFM				D1 – Diameter												
	ap	ae	ap	min	max	min	max	inch	1/8	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	1	1 1/4	
										0.125	0.188	0.250	0.313	0.375	0.438	0.500	0.625	0.750	1.000	1.250
P	1	1.25 x D	0.5 x D	1 x D	490	660	490	660	fz	0.0009	0.0014	0.0018	0.0023	0.0027	0.0031	0.0035	0.0039	0.0043	0.0050	0.0062
	2	1.25 x D	0.5 x D	1 x D	460	620	460	620	fz	0.0009	0.0014	0.0018	0.0023	0.0027	0.0031	0.0035	0.0039	0.0043	0.0050	0.0062
	3	1.25 x D	0.5 x D	1 x D	390	520	390	520	fz	0.0007	0.0011	0.0015	0.0020	0.0023	0.0026	0.0029	0.0034	0.0038	0.0046	0.0057
	4	1.25 x D	0.5 x D	0.75 x D	300	490	300	490	fz	0.0007	0.0010	0.0014	0.0018	0.0020	0.0023	0.0026	0.0030	0.0033	0.0039	0.0049
	5	1.25 x D	0.5 x D	1 x D	200	330	200	330	fz	0.0006	0.0009	0.0012	0.0016	0.0018	0.0021	0.0023	0.0027	0.0030	0.0036	0.0046
	6	1.25 x D	0.5 x D	0.75 x D	160	250	160	250	fz	0.0005	0.0008	0.0010	0.0013	0.0015	0.0017	0.0019	0.0022	0.0024	0.0028	0.0036
M	1	1.25 x D	0.5 x D	1 x D	260	330	260	330	fz	0.0007	0.0011	0.0015	0.0020	0.0023	0.0026	0.0029	0.0034	0.0038	0.0046	0.0057
	2	1.25 x D	0.5 x D	1 x D	200	260	200	260	fz	0.0006	0.0009	0.0012	0.0016	0.0018	0.0021	0.0023	0.0027	0.0030	0.0036	0.0046
	3	1.25 x D	0.5 x D	1 x D	200	260	200	260	fz	0.0005	0.0008	0.0010	0.0013	0.0015	0.0017	0.0019	0.0022	0.0024	0.0028	0.0036
K	1	1.25 x D	0.5 x D	1 x D	390	520	390	520	fz	0.0009	0.0014	0.0018	0.0023	0.0027	0.0031	0.0035	0.0039	0.0043	0.0050	0.0062
	2	1.25 x D	0.5 x D	1 x D	360	460	360	460	fz	0.0007	0.0011	0.0015	0.0020	0.0023	0.0026	0.0029	0.0034	0.0038	0.0046	0.0057
	3	1.25 x D	0.5 x D	1 x D	330	430	330	430	fz	0.0006	0.0009	0.0012	0.0016	0.0018	0.0021	0.0023	0.0027	0.0030	0.0036	0.0046
S	1	1.0 x D	0.3 x D	0.3 x D	—	—	160	300	fz	0.0007	0.0011	0.0015	0.0020	0.0023	0.0026	0.0029	0.0034	0.0038	0.0046	0.0057
	2	1.25 x D	0.5 x D	1 x D	—	—	160	260	fz	0.0006	0.0009	0.0012	0.0016	0.0018	0.0021	0.0023	0.0027	0.0030	0.0036	0.0046
	3	1.0 x D	0.3 x D	0.3 x D	—	—	70	130	fz	0.0004	0.0006	0.0008	0.0010	0.0012	0.0014	0.0016	0.0018	0.0020	0.0025	0.0031
	4	1.25 x D	0.5 x D	1 x D	—	—	150	210	fz	0.0005	0.0008	0.0011	0.0014	0.0017	0.0019	0.0022	0.0025	0.0028	0.0033	0.0042
H	1	1.25 x D	0.5 x D	0.75 x D	260	460	260	460	fz	0.0007	0.0010	0.0014	0.0018	0.0020	0.0023	0.0026	0.0030	0.0033	0.0039	0.0049

These guidelines may require variations to achieve optimum results.  
 Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.  
 Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.  
 Above parameters are based on ideal conditions. For smaller taper machining centers, please adjust parameters accordingly on >1/2" diameter.

■ UADE • Extended Neck

Material Group	Side Milling (A) and Slotting (B)			KCPM15		KC633M		Feed per Tooth – fz information is for side milling (A). For slotting (B), reduce fz by 20%.							
	A		B	Cutting Speed – vc SFM				D1 – Diameter							
	ap	ae	ap	min	max	min	max	inch	1/4	3/8	1/2	5/8	3/4	1	
										0.250	0.375	0.500	0.625	0.750	1.000
P	1	0.75 x D	0.5 x D	0.75 x D	500	650	500	650	fz	0.0018	0.0027	0.0035	0.0039	0.0043	0.0050
	2	0.75 x D	0.5 x D	0.75 x D	450	625	450	625	fz	0.0018	0.0027	0.0035	0.0039	0.0043	0.0050
	3	0.75 x D	0.5 x D	0.75 x D	400	525	400	525	fz	0.0015	0.0023	0.0029	0.0034	0.0038	0.0046
	4	0.75 x D	0.5 x D	0.5 x D	300	475	300	475	fz	0.0014	0.0020	0.0026	0.0030	0.0033	0.0039
	5	0.75 x D	0.5 x D	0.75 x D	200	325	200	325	fz	0.0012	0.0018	0.0023	0.0027	0.0030	0.0036
	6	0.75 x D	0.5 x D	0.5 x D	150	225	150	225	fz	0.0010	0.0015	0.0019	0.0022	0.0024	0.0028
M	1	0.75 x D	0.5 x D	0.75 x D	260	330	260	330	fz	0.0015	0.0023	0.0029	0.0034	0.0038	0.0046
	2	0.75 x D	0.5 x D	0.75 x D	200	260	200	260	fz	0.0012	0.0018	0.0023	0.0027	0.0030	0.0036
	3	0.75 x D	0.5 x D	0.75 x D	200	260	200	260	fz	0.0010	0.0015	0.0019	0.0022	0.0024	0.0028
K	1	0.75 x D	0.5 x D	0.75 x D	390	520	390	520	fz	0.0018	0.0027	0.0035	0.0039	0.0043	0.0050
	2	0.75 x D	0.5 x D	0.75 x D	360	460	360	460	fz	0.0015	0.0023	0.0029	0.0034	0.0038	0.0046
	3	0.75 x D	0.5 x D	0.75 x D	330	430	330	430	fz	0.0012	0.0018	0.0023	0.0027	0.0030	0.0036
S	1	0.75 x D	0.3 x D	0.3 x D	—	—	150	275	fz	0.0015	0.0023	0.0029	0.0034	0.0038	0.0046
	2	0.75 x D	0.5 x D	0.75 x D	—	—	160	260	fz	0.0012	0.0018	0.0023	0.0027	0.0030	0.0036
	3	0.75 x D	0.3 x D	0.3 x D	—	—	70	130	fz	0.0008	0.0012	0.0016	0.0018	0.0020	0.0025
	4	0.75 x D	0.5 x D	0.75 x D	—	—	150	210	fz	0.0011	0.0017	0.0022	0.0025	0.0028	0.0033
H	1	0.75 x D	0.5 x D	0.5 x D	260	450	260	450	fz	0.0014	0.0020	0.0026	0.0030	0.0033	0.0039

Side milling applications – For longest reach (L3) tools, reduce ae by 30%.  
 Slot milling applications – For longest reach (L3) tools, reduce ap by 30%.  
 Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.  
 Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.  
 Above parameters are based on ideal conditions. For smaller taper machining centers, please adjust parameters accordingly on >1/2" diameter.