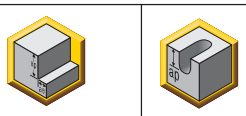
UEDE • 3-Flute

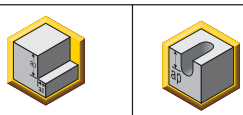
GOmill

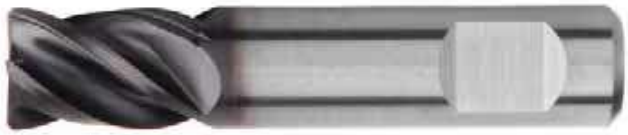


Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	KC643M Cutting Speed — vc SFM min	max	Feed per Tooth — fz information is for side milling (A). For slotting (B), reduce fz by 20%. D1 — Diameter inch	5/64 0.08	1/8 0.13	5/32 0.16	1/4 0.250	5/16 0.31	3/8 0.38	1/2 0.50
P	1	1.5 x D	0.5 x D	1 x D	495	660	fz	0.00054	0.00088	0.00111	0.00183	0.00234	0.00270	0.00345
	2	1.5 x D	0.5 x D	1 x D	462	627	fz	0.00054	0.00088	0.00111	0.00183	0.00234	0.00270	0.00345
	3	1.5 x D	0.5 x D	1 x D	396	528	fz	0.00044	0.00072	0.00091	0.00151	0.00195	0.00227	0.00293
	4	1.5 x D	0.5 x D	0.75 x D	297	495	fz	0.00041	0.00066	0.00084	0.00137	0.00175	0.00203	0.00260
	5	1.5 x D	0.5 x D	1 x D	198	330	fz	0.00037	0.00059	0.00075	0.00123	0.00156	0.00182	0.00234
	6	1.5 x D	0.5 x D	0.75 x D	165	248	fz	0.00031	0.00050	0.00063	0.00103	0.00131	0.00152	0.00194
M	1	1.5 x D	0.5 x D	1 x D	297	380	fz	0.00044	0.00072	0.00091	0.00151	0.00195	0.00227	0.00293
	2	1.5 x D	0.5 x D	1 x D	198	264	fz	0.00037	0.00059	0.00075	0.00123	0.00156	0.00182	0.00234
	3	1.5 x D	0.5 x D	1 x D	198	231	fz	0.00031	0.00050	0.00063	0.00103	0.00131	0.00152	0.00194
K	1	1.5 x D	0.5 x D	1 x D	396	495	fz	0.00054	0.00088	0.00111	0.00183	0.00234	0.00270	0.00345
	2	1.5 x D	0.5 x D	1 x D	363	429	fz	0.00044	0.00072	0.00091	0.00151	0.00195	0.00227	0.00293
	3	1.5 x D	0.5 x D	1 x D	330	429	fz	0.00037	0.00059	0.00075	0.00123	0.00156	0.00182	0.00234
S	1	1.5 x D	0.3 x D	0.3 x D	165	297	fz	0.00044	0.00072	0.00091	0.00151	0.00195	0.00227	0.00293
	2	1.5 x D	0.3 x D	0.3 x D	82,5	132	fz	0.00024	0.00039	0.00050	0.00081	0.00103	0.00120	0.00155
	3	1.5 x D	0.5 x D	1 x D	198	264	fz	0.00037	0.00059	0.00075	0.00123	0.00156	0.00182	0.00234
	4	1.5 x D	0.5 x D	1 x D	165	198	fz	0.00028	0.00048	0.00062	0.00107	0.00144	0.00167	0.00215
H	1	1.5 x D	0.5 x D	0.75 x D	264	140	fz	0.00041	0.00066	0.00084	0.00137	0.00175	0.00203	0.00260

UEDE • 4-Flute

GOmill





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	4	1.5 x D	0.5 x D	0.75 x D	297	495	fz	0.00084	0.00137	0.00175	0.00203	0.00260
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	4	1.5 x D	0.5 x D	1 x D	165	198	fz	0.00062	0.00107	0.00144	0.00167	0.00215
H	1	1.5 x D	0.5 x D	0.75 x D	264	140	fz	0.00084	0.00137	0.00175	0.00203	0.00260

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.