

■ UDDE

	Side Milling (A) and Slotting (B)			KC643M		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							
Material Group	ap	ae	ap	min	max	inch	1/4 0.250	3/8 0.375	1/2 0.500	5/8 0.625	3/4 0.750	1 1.000	
<b>P</b>	5	1.25 x D	0.5 x D	1 x D	200	325	fz	0.0012	0.0018	0.0023	0.0027	0.0003	0.0036
	6	1.25 x D	0.5 x D	0.75 x D	150	225	fz	0.0010	0.0015	0.0019	0.0022	0.0024	0.0028
	2	1.0 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
<b>S</b>	3	1.25 x D	0.5 x D	1 x D	160	260	fz	0.0012	0.0018	0.0023	0.0027	0.0030	0.0036
	4	1.25 x D	0.5 x D	1 x D	150	210	fz	0.0011	0.0017	0.0022	0.0025	0.0028	0.0033

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.



Solid End Milling