

■ KMDA • Steels with Hardness <52 HRC

				KC639M				D1 – Diameter				
		3D Milling/Profiling		Cutting Speed – vc SFM								
Material Group		ap	ae	min	max	inch	1/4 0.250	5/16 0.313	3/8 0.375	1/2 0.500	5/8 0.625	3/4 0.750
P	4	0.05 x D	0.55 x D	528	594	fz	0.0130	0.0160	0.0190	0.0250	0.0260	0.0280
H	1	0.05 x D	0.55 x D	462	528	fz	0.0130	0.0160	0.0190	0.0250	0.0260	0.0280
	2	0.05 x D	0.55 x D	330	396	fz	0.0080	0.0090	0.0110	0.0150	0.0190	0.0230

■ KHDA • Steels with Hardness >52 HRC

				KC639M				D1 – Diameter				
		3D Milling/Profiling		Cutting Speed – vc SFM								
Material Group		ap	ae	min	max	inch	1/4 0.250	5/16 0.313	3/8 0.375	1/2 0.500	5/8 0.625	3/4 0.750
H	2	0.03 x D	0.55 x D	330	396	fz	0.0080	0.0090	0.0110	0.0150	0.0190	0.0230
	3	0.03 x D	0.55 x D	265	330	fz	0.0080	0.0090	0.0110	0.0150	0.0190	0.0230
	4	0.03 x D	0.55 x D	165	230	fz	0.0060	0.0080	0.0090	0.0130	0.0160	0.0190

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