

■ HPBNDM

		3D Milling/Profiling		KC633M		Feed per Tooth — Finishing										
Material Group			Cutting Speed — vc SFM		D1 — Diameter											
	ap	ae	min	max	inch	1/8 0.125	5/32 0.156	3/16 0.188	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	3	0.04 x D	0.04 x D	1360	1540	fz	0.0033	0.0042	0.0052	0.0070	0.0090	0.0105	0.0135	0.0157	0.0175	
	4	0.04 x D	0.04 x D	1190	1360	fz	0.0031	0.0039	0.0047	0.0063	0.0081	0.0093	0.0120	0.0139	0.0152	
H	1	0.03 x D	0.03 x D	950	1330	fz	0.0033	0.0041	0.0050	0.0068	0.0086	0.0100	0.0128	0.0148	0.0163	
	2	0.03 x D	0.03 x D	670	1140	fz	0.0025	0.0031	0.0038	0.0051	0.0065	0.0075	0.0096	0.0110	0.0120	
	3	0.02 x D	0.02 x D	710	1060	fz	0.0021	0.0026	0.0032	0.0043	0.0054	0.0063	0.0082	0.0095	0.0107	
	4	0.02 x D	0.02 x D	590	830	fz	0.0014	0.0017	0.0021	0.0028	0.0036	0.0042	0.0054	0.0063	0.0070	

		3D Milling/Profiling		KC633M		Feed per Tooth — Semi-Finishing										
Material Group			Cutting Speed — vc SFM		D1 — Diameter											
	ap	ae	min	max	inch	1/8 0.125	5/32 0.156	3/16 0.188	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	3	0.01 x D	0.05 x D	890	1000	fz	0.0022	0.0027	0.0033	0.0045	0.0059	0.0068	0.0088	0.0102	0.0114	
	4	0.01 x D	0.05 x D	780	890	fz	0.0020	0.0025	0.0030	0.0041	0.0053	0.0061	0.0078	0.0090	0.0099	
H	1	0.07 x D	0.1 x D	660	920	fz	0.0025	0.0031	0.0038	0.0051	0.0066	0.0076	0.0098	0.0113	0.0124	
	2	0.05 x D	0.04 x D	530	910	fz	0.0022	0.0027	0.0033	0.0044	0.0057	0.0065	0.0084	0.0096	0.0105	
	3	0.03 x D	0.03 x D	570	860	fz	0.0019	0.0025	0.0030	0.0040	0.0051	0.0059	0.0076	0.0089	0.0100	
	4	0.03 x D	0.03 x D	480	670	fz	0.0013	0.0016	0.0020	0.0027	0.0034	0.0039	0.0051	0.0059	0.0066	

Solid End Milling

		3D Milling/Profiling		KC633M		Feed per Tooth — Roughing										
Material Group			Cutting Speed — vc SFM		D1 — Diameter											
	ap	ae	min	max	inch	1/8 0.125	5/32 0.156	3/16 0.188	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	3	0.02 x D	0.01 x D	680	770	fz	0.0010	0.0012	0.0015	0.0020	0.0026	0.0030	0.0039	0.0046	0.0051	
	4	0.02 x D	0.01 x D	600	680	fz	0.0009	0.0011	0.0014	0.0018	0.0023	0.0027	0.0035	0.0040	0.0044	
H	1	0.15 x D	0.01 x D	460	640	fz	0.0013	0.0017	0.0020	0.0028	0.0035	0.0041	0.0052	0.0060	0.0066	
	2	0.01 x D	0.75 x D	390	670	fz	0.0015	0.0019	0.0023	0.0031	0.0039	0.0045	0.0058	0.0067	0.0073	
	3	0.05 x D	0.05 x D	450	680	fz	0.0017	0.0021	0.0026	0.0035	0.0044	0.0052	0.0067	0.0078	0.0087	
	4	0.05 x D	0.05 x D	380	530	fz	0.0011	0.0014	0.0017	0.0023	0.0030	0.0034	0.0044	0.0052	0.0058	

These guidelines may require variations to achieve optimum results.