

### MDRHEC

						Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.										
Material Group		Side Milling (A) and Slotting (B)		KCPM15		D1 – Diameter										
		A		B		Cutting Speed – vc SFM		frac.								
		ap	ae	ap	min	max	dec.	1/4	5/16	3/8	1/2	5/8	3/4	1		
P	0	1.0 x D	0.5 x D	0.5 x D	490	660	IPT	.0016	.0020	.0023	.0029	.0034	.0037	.0042		
	1	1.0 x D	0.5 x D	0.5 x D	490	660	IPT	.0016	.0020	.0023	.0029	.0034	.0037	.0042		
	2	1.0 x D	0.4 x D	0.5 x D	460	620	IPT	.0016	.0020	.0023	.0029	.0034	.0037	.0042		
	3	1.0 x D	0.4 x D	0.5 x D	390	520	IPT	.0013	.0017	.0019	.0025	.0029	.0033	.0038		
	4	1.0 x D	0.3 x D	0.4 x D	300	490	IPT	.0012	.0015	.0017	.0022	.0026	.0029	.0033		
M	5	1.0 x D	0.4 x D	0.5 x D	200	330	IPT	.0010	.0013	.0016	.0020	.0023	.0026	.0031		
	1	1.0 x D	0.4 x D	0.5 x D	300	380	IPT	.0013	.0017	.0019	.0025	.0029	.0033	.0038		
	2	1.0 x D	0.4 x D	0.5 x D	200	260	IPT	.0010	.0013	.0016	.0020	.0023	.0026	.0031		
K	3	1.0 x D	0.4 x D	0.5 x D	200	230	IPT	.0009	.0011	.0013	.0016	.0019	.0021	.0024		
	1	1.0 x D	0.5 x D	0.5 x D	390	490	IPT	.0016	.0020	.0023	.0029	.0034	.0037	.0042		
	2	1.0 x D	0.4 x D	0.5 x D	360	460	IPT	.0013	.0017	.0019	.0025	.0029	.0033	.0038		
S	3	1.0 x D	0.4 x D	0.5 x D	360	430	IPT	.0010	.0013	.0016	.0020	.0023	.0026	.0031		
	1	1.0 x D	0.4 x D	0.5 x D	–	–	IPT	.0013	.0017	.0019	.0025	.0029	.0033	.0038		
H	2	1.0 x D	0.4 x D	0.5 x D	–	–	IPT	.0007	.0009	.0010	.0013	.0015	.0018	.0021		
	1	1.0 x D	0.3 x D	0.4 x D	260	460	IPT	.0012	.0015	.0017	.0022	.0026	.0029	.0033		

NOTE: 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.