MDRHEC

Material

Group

Ρ

Μ

K 2

0

1

2

3

4

5

1

2

3

1

3

1

2

1

Side Milling (A) and Slotting (B)

ae

0.5 x D

0.5 x D

0.4 x D

0.4 x D

0.3 x D

0.4 x D

0.4 x D

0.4 x D

0.4 x D

0.5 x D

0.4 x D

0.4 x D

0.4 x D

0.4 x D

0.3 x D

в

ар

0.5 x D

0.5 x D

0.5 x D

0.5 x D

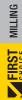
0.4 x D

0.5 x D

Α

ар

1.0 x D



0.4 x D 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.

frac.

dec.

IPT

1/4

.250

.0016

.0016

.0016

.0013

.0012

.0010

.0013

.0010

.0009

.0016

.0013

.0010

.0013

.0007

.0012

5/16

.313

.0020

.0020

.0020

.0017

.0015

.0013

.0017

.0013

.0011

.0020

.0017

.0013

.0017

.0009

.0015

KCPM15

Cutting Speed – vc SFM

max

660

660

620

520

490

330

380

260

230

490

460

430

_

460

min

490

490

460

390

300

200

300

200

200

390

360

360

260

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.

FIRST HOLEMAKING











3/4

.750

.0037

.0037

.0037

0033

.0029

.0026

.0033

.0026

.0021

.0037

.0033

0026

.0033

.0018

.0029

1

1.000

.0042

.0042

.0042

.0038

.0033

.0031

.0038

.0031

.0024

.0042

.0038

.0031

.0038

.0021

.0033

Recommended feed per tooth (IPT = inch/th) for side milling (A).

For slotting (B), reduce IPT by 20%.

3/8

.375

.0023

.0023

.0023

.0019

.0017

.0016

.0019

.0016

.0013

.0023

.0019

.0016

.0019

.0010

.0017

D1 - Diameter

1/2

.500

.0029

.0029

.0029

.0025

.0022

.0020

.0025

.0020

.0016

.0029

.0025

.0020

.0025

.0013

.0022

5/8

.625

.0034

.0034

.0034

.0029

.0026

.0023

.0029

.0023

.0019

.0034

.0029

.0023

.0029

.0015

.0026