



■ HARVI III • UJBE • Ball Nose • Unequal Flute Spacing • Roughing

Material Group													
		Side Milling (A)		KCSM15			Recommended feed per tooth (IPT = inch/th) for side milling (A).						
		A		Cutting Speed — vc SFM			frac.	D1 — Diameter					
		ap	ae	min		max		3/8	1/2	5/8	3/4	1	
P	0	Ap max	0.4 x D	490	—	660	IPT	.0027	.0034	.0039	.0044	.0049	
	1	Ap max	0.4 x D	490	—	660	IPT	.0027	.0034	.0039	.0044	.0049	
	2	Ap max	0.4 x D	460	—	620	IPT	.0027	.0034	.0039	.0044	.0049	
	3	Ap max	0.4 x D	390	—	520	IPT	.0023	.0029	.0034	.0039	.0045	
	4	Ap max	0.4 x D	300	—	490	IPT	.0020	.0026	.0030	.0034	.0039	
	5	Ap max	0.4 x D	200	—	330	IPT	.0018	.0023	.0027	.0031	.0036	
M	1	Ap max	0.4 x D	160	—	250	IPT	.0015	.0019	.0022	.0025	.0028	
	2	Ap max	0.4 x D	300	—	380	IPT	.0023	.0029	.0034	.0039	.0045	
	3	Ap max	0.4 x D	200	—	260	IPT	.0018	.0023	.0027	.0031	.0036	
S	1	Ap max	0.4 x D	200	—	230	IPT	.0015	.0019	.0022	.0025	.0028	
	2	Ap max	0.4 x D	160	—	300	IPT	.0023	.0029	.0034	.0039	.0045	
	3	Ap max	0.4 x D	80	—	130	IPT	.0012	.0015	.0018	.0021	.0024	
	4	Ap max	0.4 x D	80	—	130	IPT	.0012	.0015	.0018	.0021	.0024	
H	1	Ap max	0.4 x D	160	—	200	IPT	.0017	.0021	.0025	.0028	.0033	
	2	Ap max	0.4 x D	80	—	130	IPT	.0012	.0015	.0018	.0021	.0024	
H	3	Ap max	0.4 x D	80	—	130	IPT	.0012	.0015	.0018	.0021	.0024	
	4	Ap max	0.4 x D	160	—	200	IPT	.0017	.0021	.0025	.0028	.0033	
H	1	Ap max	0.4 x D	260	—	460	IPT	.0020	.0026	.0030	.0034	.0039	

NOTE: 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.