

■ HARVI III • UJDE • Unequal Flute Spacing • Roughing

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

■ HARVI III • UJDE • Unequal Flute Spacing • Finishing

		Side Milling (A)		KCSM15		Recommended feed per tooth (IPT = inch/th) for side milling (A).					
Material Group		A		Cutting Speed – vc SFM		frac. dec.	D1 – Diameter				
		ap	ae	min	max		3/8	1/2	5/8	3/4	1
P	4	Ap max	0.06 x D	560	940	IPT	.0025	.0031	.0036	.0040	.0046
	5	Ap max	0.06 x D	370	620	IPT	.0022	.0028	.0033	.0037	.0043
M	1	Ap max	0.06 x D	560	720	IPT	.0027	.0035	.0041	.0046	.0054
	2	Ap max	0.06 x D	370	500	IPT	.0022	.0028	.0033	.0037	.0043
S	3	Ap max	0.06 x D	370	440	IPT	.0018	.0023	.0027	.0030	.0034
	1	Ap max	0.06 x D	310	560	IPT	.0027	.0035	.0041	.0046	.0054
H	2	Ap max	0.06 x D	160	250	IPT	.0015	.0018	.0022	.0025	.0029
	3	Ap max	0.06 x D	160	250	IPT	.0015	.0018	.0022	.0025	.0029
H	4	Ap max	0.06 x D	310	370	IPT	.0020	.0026	.0030	.0034	.0040
	1	Ap max	0.06 x D	500	870	IPT	.0025	.0031	.0036	.0040	.0046

NOTE: Those 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.