

■ HARVI • UKDV • Asymmetrical Flute Spacing

Material Group														Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.						
	Side Milling (A) and Slotting (B)			short			medium			long				D1 – Diameter						
	A		B	adapter reach																
	ap		ae	KCPM15			KCPM15			KCPM15				frac.	3/8	1/2	5/8	3/4	1	1 1/4
	min		max	Cutting Speed – vc SFM			Cutting Speed – vc SFM			Cutting Speed – vc SFM				dec.	.3750	.5000	.6250	.7500	1.0000	1.2500
P	0	1.5 x D	0.5 x D	1 x D	490	-	660	441	-	594	441	-	594	IPT	.0023	.0029	.0034	.0037	.0042	.0042
	1	1.5 x D	0.5 x D	1 x D	490	-	660	441	-	594	441	-	594	IPT	.0023	.0029	.0034	.0037	.0042	.0042
	2	1.5 x D	0.5 x D	1 x D	460	-	620	414	-	558	414	-	558	IPT	.0023	.0029	.0034	.0037	.0042	.0042
	3	1.5 x D	0.5 x D	1 x D	390	-	520	351	-	468	351	-	468	IPT	.0019	.0025	.0029	.0033	.0041	.0041
	4	1.5 x D	0.4 x D	0.75 x D	300	-	490	270	-	441	270	-	441	IPT	.0017	.0022	.0026	.0029	.0034	.0034
	5	1.5 x D	0.4 x D	1 x D	200	-	330	170	-	280.5	160	-	264	IPT	.0016	.0020	.0023	.0026	.0033	.0033
M	1	1.5 x D	0.4 x D	1 x D	160	-	250	136	-	212.5	128	-	200	IPT	.0013	.0016	.0019	.0021	.0024	.0024
	2	1.5 x D	0.4 x D	1 x D	300	-	380	240	-	304	210	-	266	IPT	.0019	.0025	.0029	.0033	.0041	.0041
	3	1.5 x D	0.4 x D	1 x D	200	-	260	160	-	208	140	-	182	IPT	.0016	.0020	.0023	.0026	.0033	.0033
S	1	1.5 x D	0.3 x D	0.3 x D	160	-	300	128	-	240	96	-	180	IPT	.0019	.0025	.0029	.0033	.0041	.0041
	2	1.5 x D	0.3 x D	0.3 x D	80	-	130	64	-	104	48	-	78	IPT	.0010	.0013	.0015	.0018	.0022	.0022
	3	1.5 x D	0.3 x D	0.3 x D	80	-	130	64	-	104	48	-	78	IPT	.0010	.0013	.0015	.0018	.0022	.0022
	4	1.5 x D	0.4 x D	1 x D	160	-	200	128	-	160	96	-	120	IPT	.0014	.0018	.0021	.0024	.0030	.0030

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. Please adjust parameters according to system stability.
 For side milling with ap larger than 1 x D, reduce fz by 20%!
 Cylindrical shanks not recommended for full slotting.