

■ Series 4K02 4K03 • ArCut

Material Group																	
	Side Milling (A) and Slotting (B)			uncoated			Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.										
	A		B	Cutting Speed – vc SFM			D1 – Diameter										
	ap	ae	ap	min	–	max	frac.	1/8	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1	
N	1	Ap1 max	0.5 x D	1.0 x D	1640	–	6560	IPT	.0011	.0017	.0023	.0028	.0034	.0045	.0056	.0068	.0090
	2	Ap1 max	0.5 x D	1.0 x D	1640	–	4920	IPT	.0009	.0014	.0018	.0023	.0027	.0036	.0045	.0054	.0072
	3	Ap1 max	0.5 x D	1.0 x D	1640	–	4920	IPT	.0008	.0012	.0016	.0020	.0024	.0032	.0039	.0047	.0063
	4	Ap1 max	0.5 x D	1.0 x D	1310	–	2460	IPT	.0008	.0012	.0016	.0020	.0024	.0032	.0039	.0047	.0063
	5	Ap1 max	0.5 x D	1.0 x D	820	–	3280	IPT	.0010	.0015	.0020	.0025	.0030	.0041	.0051	.0061	.0081

NOTE: For cutting aluminum with high silicon, coating is recommended.
 For spindles with ceramic bearings, multiply ap by 0.5.
 For better surface finish, reduce feed per tooth.
 Above parameters are based on ideal conditions. For smaller taper machining centers, please adjust parameters accordingly on diameters >1/2".

High-Performance Solid Carbide End Mills