

■ Series 620W • WavCut I

Material Group									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.	3/4	1	1 1/4	1 1/2	2					
		ap	ae	ap	min		max	dec.	.7500	1.0000	1.2500	1.5000	2.0000					
P	5	1.5 x D	0.4 x D	1 x D	30	–	50	IPT	.0030	.0040	.0045	.0050	.0055					
M	1	1.5 x D	0.4 x D	1 x D	30	–	50	IPT	.0040	.0045	.0050	.0055	.0060					
	2	1.5 x D	0.4 x D	1 x D	30	–	40	IPT	.0035	.0040	.0045	.0050	.0055					
S	4	1.5 x D	0.4 x D	0.75 x D	50	–	70	IPT	.0033	.0040	.0050	.0055	.0060					

NOTE: Side milling applications – For longest length tools, reduce ae by 30%.
 Slot milling applications – For longest length tools, reduce ap by 30%.
 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 diameters >1/2".



High-Performance High-Speed Steel (HSS-E/PM)