

BNEC

			Reduce speed by 20% for slotting applications												
	Application		Vc	Vc	Vc	Recommended fz- Feed Per Tooth (Inch/th) for side cutting operations.									
	3D Milling		K600	KC610M	KC635M	For slotting operations, reduce fz by 20%. D1- Diameter (Inch)									
Group	ap	ae	SFM	SFM	SFM	1/16"	1/8"	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"
P2	0.2xD	0.5XD	200~300	300~400	350~450	.0004	.0006	.001	.0015	.0020	.0025	.0030	.0035	.0040	.0045
P3	0.2xD	0.5XD	175~300	175~300	250~350	.0003	.0005	.0007	.0010	.0015	.0020	.0024	.0028	.0030	.0035
P4	0.2xD	0.5XD	N/A	N/A	175~325	.0002	.0004	.0005	.0010	.0011	.0015	.0020	.0025	.0027	.0030
P5	0.2xD	0.5XD	N/A	200~350	250~450	.0002	.0004	.0006	.0010	.0015	.0020	.0024	.0026	.0030	.0035
M1	0.2xD	0.5XD	N/A	225~400	275~500	.0004	.0006	.0008	.0012	.0015	.0020	.0025	.0030	.0035	.0040
M2	0.2xD	0.5XD	N/A	N/A	200~450	.0002	.0003	.0004	.0007	.0010	.0015	.0017	.0025	.0030	.0035
M3	0.2xD	0.5XD	N/A	N/A	175~400	.0002	.0003	.0004	.0007	.0010	.0015	.0017	.0025	.0030	.0035
K1	0.2xD	0.5XD	300~550	N/A	425~725	.0005	.0007	.0015	.0020	.0025	.0030	.0040	.0050	.0060	.0070
K2	0.2xD	0.5XD	200~300	N/A	400~600	.0005	.0007	.0015	.0020	.0025	.0030	.0040	.0050	.0060	.0070
S1	0.2xD	0.5XD	N/A	N/A	65~125	.0002	.0004	.0006	.0009	.0012	.0015	.0018	.0020	.0024	.0027
S2	0.2xD	0.5XD	N/A	N/A	65~125	.0002	.0004	.0006	.0009	.0012	.0015	.0018	.0020	.0024	.0027
S3	0.2xD	0.5XD	N/A	N/A	65~125	.0002	.0004	.0006	.0009	.0012	.0015	.0018	.0020	.0024	.0027
S4	0.2xD	0.5XD	N/A	N/A	100~200	.0002	.0004	.0007	.0010	.0012	.0015	.0018	.0020	.0025	.0030

These guidelines may require variations to achieve optimum results.

DBNEC

			Reduce speed by 20% for slotting applications												
	Application		Vc			Recommended fz- Feed Per Tooth (Inch/th) for side cutting operations.									
	3D Milling		KC610M			For slotting operations, reduce fz by 20%. D1- Diameter (Inch)									
Group	ap	ae	SFM			1/16"	1/8"	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"
P2	0.2xD	0.5XD	300~400			.0004	.0006	.001	.0015	.0020	.0025	.0030	.0035	.0040	.0045
P3	0.2xD	0.5XD	175~300			.0003	.0005	.0007	.0010	.0015	.0020	.0024	.0028	.0030	.0035
P5	0.2xD	0.5XD	200~350			.0002	.0004	.0006	.0010	.0015	.0020	.0024	.0026	.0030	.0035
M1	0.2xD	0.5XD	225~400			.0004	.0006	.0008	.0012	.0015	.0020	.0025	.0030	.0035	.0040

These guidelines may require variations to achieve optimum results.

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HPHVBN

			Reduce speed by 20% for slotting applications									
	Application		Vc KC633M	Recommended fz- Feed Per Tooth (Inch/th) for side cutting operations. For slotting operations, reduce fz by 20%.								
	3D Milling			D1- Diameter (Inch)								
Group	ap	ae	SFM	1/8"	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"
P2	0.5xD	0.5XD	450~550	0.0010	0.0011	0.0014	0.0021	0.0023	0.0025	0.0027	0.0032	0.0034
P3	0.5XD	0.5XD	450~550	0.0010	0.0011	0.0014	0.0021	0.0023	0.0025	0.0027	0.0032	0.0034
M1	0.5XD	0.5XD	200~300	0.0010	0.0011	0.0014	0.0018	0.0021	0.0023	0.0025	0.0027	0.0029
M2	0.5XD	0.5XD	175~250	0.0008	0.0009	0.0012	0.0016	0.0018	0.0019	0.0021	0.0023	0.0025
M3	0.5XD	0.5XD	150~225	0.0008	0.0009	0.0012	0.0016	0.0018	0.0019	0.0021	0.0023	0.0025
K1	0.5XD	0.5XD	425~600	0.0010	0.0011	0.0014	0.0021	0.0023	0.0025	0.0027	0.0032	0.0034
K2	0.5XD	0.5XD	400~500	0.0010	0.0011	0.0014	0.0021	0.0023	0.0025	0.0027	0.0032	0.0034
S1	0.5XD	0.5XD	100~150	0.0008	0.0009	0.0012	0.0016	0.0018	0.0019	0.0021	0.0023	0.0025
S2	0.5XD	0.5XD	100~150	0.0005	0.0006	0.0007	0.0011	0.0015	0.0025	0.0027	0.0032	0.0034
S3	0.5XD	0.5XD	100~150	0.0005	0.0006	0.0007	0.0011	0.0015	0.0025	0.0027	0.0032	0.0034
S4	0.5XD	0.5XD	125~175	0.0005	0.0006	0.0007	0.0011	0.0015	0.0025	0.0027	0.0032	0.0034

These guidelines may require variations to achieve optimum results.

HPBNDM

			Reduce speed by 20% for slotting applications						
	Application		Vc KC633M	Recommended fz- Feed Per Tooth (Inch/th) for side cutting operations. For slotting operations, reduce fz by 20%.					
	3D Milling			D1- Diameter (Inch)					
Group	ap	ae	SFM	1/64"	1/32"	1/16"	1/8"	3/16"	1/4"
P4	0.01XD	0.01XD	825~850	.0024	.0031	.0040	.0055	.0063	.0071
P6	0.01XD	0.01XD	825~850	.0024	.0031	.0040	.0055	.0063	.0071
H1	0.01XD	0.01XD	825~850	.0024	.0031	.0040	.0055	.0063	.0071
H2	0.01XD	0.01XD	650~675	.0018	.0020	.0024	.0028	.0031	.0035
H3	0.01XD	0.01XD	450~500	.0012	.0016	.0020	.0024	.0028	.0031
H4	0.01XD	0.01XD	320~350	.0012	.0016	.0020	.0024	.0028	.0031

These guidelines may require variations to achieve optimum results.

BNEC-DIAMOND COATED

			Reduce speed by 20% for slotting applications									
	Application		Vc KDF300	Recommended fz- Feed Per Tooth (Inch/th) for side cutting operations. For slotting operations, reduce fz by 20%.								
	3D Milling			D1- Diameter (Inch)								
Group	ap	ae	SFM	1/64"	1/32"	1/16"	1/8"	3/16"	1/4"	5/16"	3/8"	1/2"
N1 - Aluminum alloys	.5XD	0.25XD	100~500			.0006	.0007	.0008	.0010	.0011	.0012	.0016
N1 - Graphite	.5XD	0.25XD	100~1200	.0002	.0004	.0007	.0009	.0012	.0013	.0015	.0017	.0019
N1 - Thermoset plastics	.5XD	0.25XD	50~750	.0003	.0005	.0007	.0011	.0012	.0013	.0015	.0017	.0019
N1 - Fiber-filled plastics	.5XD	0.25XD	75~400			.0007	.0011	.0012	.0013	.0015	.0017	.0021

These guidelines may require variations to achieve optimum results.