



ROCO BR
Application Data • Metric

Material Group		Side Milling		Slotting	KCC05A		Recommended Feed per Rev (Fn=mm/rev) is for Side Milling (A). For Slotting (B) Reduce Fn by 20%.							
		Side Milling		Slotting	Cutting Speed Vc		D1 - Diameter							
		Side Milling		Slotting	m/min									
		Ap	Ae	Ap	Min	Max	mm	3.0	4.0	5.0	6.0	8.0	10.0	12.0
N	N6	1.0xD	0.2xD	1.0xD	100	150	Fn	0.058	0.077	0.096	0.144	0.230	0.288	0.346
C	C1	1.0xD	0.2xD	1.0xD	100	150	Fn	0.058	0.077	0.096	0.144	0.230	0.288	0.346



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Material Group		Side Milling		Slotting	KCC05A		Recommended Feed per Tooth (Fz=mm/th) is for Side Milling (A). For Slotting (B) Reduce Fz by 20%.							
		Side Milling		Slotting	Cutting Speed Vc		D1 - Diameter							
		Side Milling		Slotting	m/min									
		Ap	Ae	Ap	Min	Max	mm	3.0	4.0	5.0	6.0	8.0	10.0	12.0
N	N6	1.0xD	0.5xD	1.0xD	100	150	Fz	0.009	0.012	0.015	0.018	0.024	0.030	0.036
C	C1	1.0xD	0.2xD	1.0xD	100	150	Fz	0.009	0.012	0.015	0.018	0.024	0.030	0.036



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Material Group		Side Milling		Slotting	KCC05A		Recommended Feed per Rev (Fn=in/rev) is for Side Milling (A). For Slotting (B) Reduce Fn by 20%.							
		Side Milling		Slotting	Cutting Speed Vc		D1 - Diameter							
		Side Milling		Slotting	SFM		Fraction	1/8	3/16	1/4	5/16	3/8	1/2	
		Ap	Ae	Ap	Min	Max	dec.	0.1250	0.1875	0.2500	0.3125	0.3750	0.5000	
N	N6	1.0xD	0.2xD	1.0xD	330	500	IPR	0.0024	0.0036	0.0060	0.0090	0.0108	0.0144	
C	C1	1.0xD	0.2xD	1.0xD	330	500	IPR	0.0024	0.0036	0.0060	0.0090	0.0108	0.0144	



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		Side Milling		Slotting	Cutting Speed Vc		D1 - Diameter							
		Side Milling		Slotting	SFM		Fraction	1/8	3/16	1/4	5/16	3/8	1/2	
		Ap	Ae	Ap	Min	Max	dec.	0.1250	0.1875	0.2500	0.3125	0.3750	0.5000	
N	N6	1.0xD	0.2xD	1.0xD	330	500	IPT	0.0096	0.0143	0.0191	0.0238	0.0286	0.0381	
C	C1	1.0xD	0.2xD	1.0xD	330	500	IPT	0.0096	0.0143	0.0191	0.0238	0.0286	0.0381	