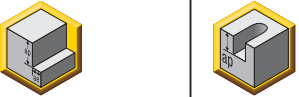



DUO-LOCK™ • FGDF • 3 FLUTES • APPLICATION DATA

Material Group																		
	Side Milling (A) and Slotting (B)			straight short			conical medium			conical long			Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.					
	A		B	KCPM15 Cutting Speed – vc m/min			KCPM15 Cutting Speed – vc m/min			KCPM15 Cutting Speed – vc m/min			D1 – Diameter					
	ap	ae	ap	min		max	min		max	min		max	mm	10,0	12,0	16,0	20,0	
P	0	0,75 x D	0,5 x D	0,5 x D	150	–	200	135	–	180	135	–	180	fz	0,061	0,070	0,086	0,097
	1	0,75 x D	0,5 x D	0,5 x D	150	–	200	135	–	180	135	–	180	fz	0,061	0,070	0,086	0,097
	2	0,75 x D	0,5 x D	0,5 x D	140	–	190	126	–	171	126	–	171	fz	0,061	0,070	0,086	0,097
	3	0,75 x D	0,4 x D	0,5 x D	120	–	160	108	–	144	108	–	144	fz	0,051	0,060	0,074	0,086
	4	0,75 x D	0,3 x D	0,5 x D	90	–	150	81	–	135	81	–	135	fz	0,046	0,053	0,065	0,075
	5	0,75 x D	0,4 x D	0,5 x D	60	–	100	51	–	85	48	–	80	fz	0,041	0,048	0,059	0,069
M	1	0,75 x D	0,4 x D	0,5 x D	90	–	115	72	–	92	63	–	81	fz	0,051	0,060	0,074	0,086
	2	0,75 x D	0,4 x D	0,5 x D	60	–	80	48	–	64	42	–	56	fz	0,041	0,048	0,059	0,069
	3	0,75 x D	0,4 x D	0,5 x D	60	–	70	48	–	56	42	–	49	fz	0,034	0,040	0,048	0,055
K	1	0,75 x D	0,5 x D	0,5 x D	120	–	150	108	–	135	108	–	135	fz	0,061	0,070	0,086	0,097
	2	0,75 x D	0,5 x D	0,5 x D	110	–	140	99	–	126	99	–	126	fz	0,051	0,060	0,074	0,086
	3	0,75 x D	0,4 x D	0,5 x D	110	–	130	99	–	117	99	–	117	fz	0,041	0,048	0,059	0,069
S	1	0,3 x D	0,3 x D	0,5 x D	50	–	90	40	–	72	30	–	54	fz	0,051	0,060	0,074	0,086
	2	0,3 x D	0,3 x D	0,5 x D	25	–	40	20	–	32	15	–	24	fz	0,027	0,032	0,039	0,046
	3	0,75 x D	0,3 x D	0,5 x D	25	–	40	20	–	32	15	–	24	fz	0,027	0,032	0,039	0,046
	4	0,75 x D	0,3 x D	0,5 x D	50	–	60	40	–	48	30	–	36	fz	0,038	0,044	0,055	0,063
H	1	0,75 x D	0,2 x D	0,3 x D	80	–	140	64	–	112	48	–	84	fz	0,046	0,053	0,065	0,075

NOTE: These 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. For smaller taper machining centres, please adjust parameters accordingly on diameters >12mm.

For tools with reach > 3 x D, reduce fz by 20%.

For tools with reach >5 x D, reduce fz by 30%.

For tools with reach >10 x D, reduce Vc and fz by 30%.