HARVI II • UDDV • Unequal Flute Spacing

Material Group		Side Milling (A) and Slotting (B)			short			medium			long			Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.						
		A		B	adaptor reach									D1 — Diameter						
					KC643M			KC643M			KC643M									
					Cutting Speed — vc m/min			Cutting Speed — vc m/min			Cutting Speed — vc m/min									
		ap	ae	ap	min		max	min		max	min		max	mm	10,0	12,0	16,0	20,0	25,0	32,0
P	5	1,5 x D	0,4 x D	1 x D	60	–	100	51	–	85	48	–	80	fz	0,041	0,048	0,059	0,069	0,077	0,084
P	6	1,5 x D	0,4 x D	0,75 x D	50	–	75	42,5	–	63,75	40	–	60	fz	0,034	0,040	0,048	0,055	0,060	0,062
S	1	1,5 x D	0,3 x D	0,3 x D	50	–	90	40	–	72	30	–	54	fz	0,051	0,060	0,074	0,086	0,097	0,105
S	2	1,5 x D	0,3 x D	0,3 x D	25	–	40	20	–	32	15	–	24	fz	0,027	0,032	0,039	0,046	0,052	0,057
S	3	1,5 x D	0,3 x D	0,3 x D	25	–	40	20	–	32	15	–	24	fz	0,027	0,032	0,039	0,046	0,052	0,057
S	4	1,5 x D	0,4 x D	1 x D	50	–	60	40	–	48	30	–	36	fz	0,038	0,044	0,055	0,063	0,071	0,077
H	1	1,5 x D	0,4 x D	0,75 x D	80	–	140	64	–	112	48	–	84	fz	0,046	0,053	0,065	0,075	0,083	0,087
H	2	1,5 x D	0,2 x D	0,5 x D	70	–	120	56	–	96	42	–	72	fz	0,034	0,040	0,048	0,055	0,060	0,062

NOTE: 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. Please adjust parameters according to system stability.
For side milling with ap larger than 1 x D, reduce fz by 20%!
Cylindrical shanks not recommended for full slotting.