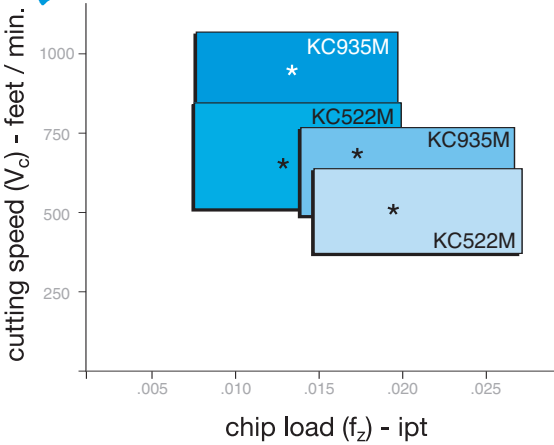
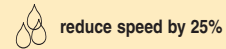
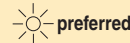


Steel Milling Grades

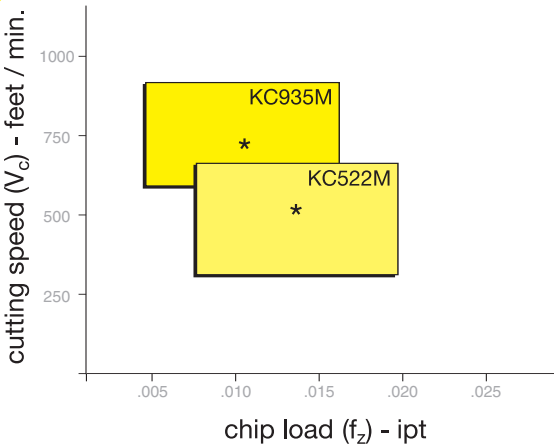


starting operating conditions	* SFM / IPT	SFM / IPT	SFM / IPT
KC522M ▼ S	500 / .018	450 / .016	650 / .022
KC935M ▼ S	750 / .015	650 / .012	850 / .018
KC522M ▼ E	600 / .012	550 / .010	750 / .014
KC935M ▼ E	900 / .010	800 / .008	1000 / .012
	240-350 HB or moderate alloy content (8620, 4140, ...)	>350 HB or high alloy content (15-5, 17-4 stainless, P20, ...)	<240 HB or low alloy content (1018, A36, ...)

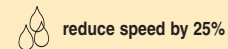
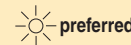


* Recommended starting point
For programmed feed rate divide IPT by .707

Stainless Steel Milling Grades



starting operating conditions	* SFM / IPT	SFM / IPT	SFM / IPT
KC522M ▼ E	650 / .014	550 / .012	400 / .012
KC935M ▼ E	800 / .010	700 / .008	–
	austenitic (304, 316, ...)	ferritic/martensitic, PH 135-330 BHN (400, 500, 15-5, 17-4, ...)	ferritic/martensitic, PH 330-450 BHN (400, 500, 17-4, 13-8, ...)



* Recommended starting point
For programmed feed rate divide IPT by .707

Edge Preparations

- S – hone + T-land (heavy)
- E – hone (medium)
- F – sharp (extra light)

Coolant Requirements



Operating Conditions

- ▼ extra heavy – heavy interruption, continuous forging/casting skin, long tool extension
- ▼▼ heavy – moderate interruption, intermittent skin, moderate tool extension
- ▼▼▼ medium – light interruption, minimal/limited skin, moderate tool extension
- ▼▼▼▼ light – no interruption, premachined - no skin, shortest extension

Inserts

Face Mills

End Mills

Die and Mold

Slotting

Thread Milling

Widia Cutters

Vintage Cutters

Accessories

Technical Data

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Index



Inserts

Face Mills

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Widia Cutters

Vintage Cutters

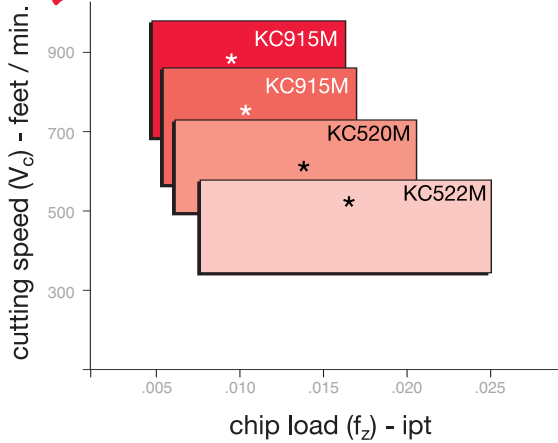
Accessories

Technical Data

Mat'l Database

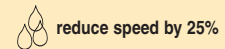
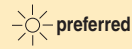
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Cast Iron Milling Grades

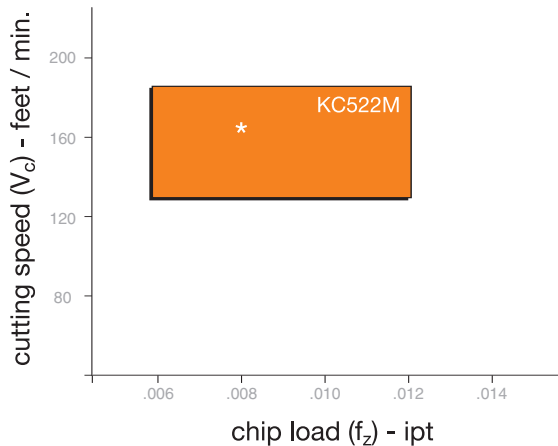


starting operating conditions	* SFM / IPT	SFM / IPT
/ KC522M ▼▼ E	400 / .016	350 / .012
 KC520M ▼▼▼ E	600 / .013	500 / .010
 KC915M ▼▼▼▼ S	800 / .012	700 / .010
 KC915M ▼▼▼▼ E	900 / .010	800 / .008
	< 320 HB or gray cast iron	< 350 HB or ductile cast iron

* Recommended starting point.
For programmed feed rate divide IPT by .707



High-Temp Alloy Milling Grades



starting operating conditions	* SFM / IPT	SFM / IPT	SFM / IPT
 KC522M ▼▼▼▼ E	160 / .0085	145 / .008	240 / .0085
	titanium (Ti6Al4V, ...)	nickel, cobalt alloys (inconel, hastelloy, monel, nimonic, ...)	iron alloys (X12NiCrSi 36 16, X2NiCrAlTi 32 20, ...)



* Recommended starting point.
For programmed feed rate divide IPT by .707

Edge Preparations

- S – hone + T-land (heavy)
- E – hone (medium)
- F – sharp (extra light)

Coolant Requirements



Operating Conditions

- ▼ extra heavy – heavy interruption, continuous forging/casting skin, long tool extension
- ▼▼ heavy – moderate interruption, intermittent skin, moderate tool extension
- ▼▼▼ medium – light interruption, minimal/limited skin, moderate tool extension
- ▼▼▼▼ light – no interruption, premachined - no skin, shortest extension