

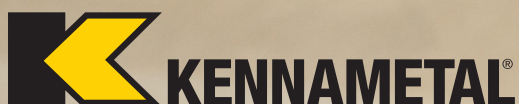
DODEKA™ MINI

Licensed to Mill

The Dodeka Mini face milling platform is one of the most comprehensive face milling boosters on the market today. Twelve true cutting edges per insert mean low cost-per-edge and high productivity. With Beyond™ premium milling grades, achieve up to 30% higher MRR, 25% lower cutting forces due to soft cutting action and up to 35% better tool life in light to heavy machining.

Machinists can expect

- 12 true cutting edges per insert
- Low cutting forces, soft cutting action
- Enhanced chip formation and evacuation
- Excellent floor finish
- **NEW!** High positive geometries
- AP MAX LP .126 IN
- AP MAX GM .110 IN



**WATCH THE
DODEKA MINI
IN ACTION!**

Speed Information Dodeka™ Series • Inch

Chip Thickness h _{ex} Inch	K313		KC410M			KC522M			KC725M			KCK15			KCPK30			KCKP10			
	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max			
Cutting Speed (ft/min)	Max	Start	Min	Max	Start	Min	Max	Start	Min	Max	Start	Min	Max	Start	Min	Max	Start	Min			
P																					
1	-	-	-	-	-	-	1295	1115	1065	1015	900	855	-	-	-	1790	1560	1460	1215	1115	1015
2	-	-	-	-	-	-	1085	950	785	870	755	625	-	-	-	1100	1000	900	1150	1035	920
3	-	-	-	-	-	-	1000	855	690	785	675	560	-	-	-	1000	900	805	1085	920	805
4	-	-	-	-	-	-	885	720	590	705	590	475	-	-	-	885	720	625	920	805	625
5	-	-	-	-	-	-	720	675	590	590	525	475	-	-	-	740	655	590	820	625	490
6	-	-	-	-	-	-	655	490	395	510	395	310	-	-	-	625	525	425	625	490	425
M																					
1	-	-	-	-	-	-	805	705	655	675	590	525	-	-	-	805	720	605	-	-	-
2	-	-	-	-	-	-	720	625	590	605	510	425	-	-	-	720	625	560	-	-	-
3	-	-	-	-	-	-	590	525	475	460	395	310	-	-	-	575	510	460	-	-	-
K																					
1	625	540	460	-	-	-	900	805	720	-	-	-	1655	1510	1345	1165	1050	950	1610	1280	920
2	-	-	-	-	-	-	705	625	590	-	-	-	1310	1165	1085	920	820	755	1100	950	740
3	-	-	-	-	-	-	590	525	475	-	-	-	1100	985	900	700	690	625	920	755	625
N																					
1	2870	2510	2165	4380	3890	3575	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
2	-	-	-	3890	3575	3115	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
3	-	-	-	3890	3575	3115	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S																					
1	-	-	-	-	-	-	130	115	80	115	100	80	-	-	-	-	-	-	-	-	-
2	-	-	-	-	-	-	130	115	80	115	100	80	-	-	-	-	-	-	-	-	-
3	-	-	-	-	-	-	165	130	80	150	115	80	-	-	-	-	-	-	-	-	-
4	-	-	-	-	-	-	165	150	115	165	150	115	-	-	-	195	165	130	-	-	-
H																					
1	-	-	-	-	-	-	475	360	280	-	-	-	-	-	-	-	-	-	525	395	310

Recommended starting speeds are in bold type. As the average chip thickness increases, speed should be decreased.
 Material groups P, M, K, and H show recommended starting speeds for dry machining. For wet machining, reduce speed by 20%.
 Material groups N and S show recommended starting speeds for wet machining. Not recommended for dry machining.

Dodeka Mini 45° • Feed Rates [IPT]

Insert Geometry	Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)					
	30%			40-100%		
	L	M	H	L	M	H
.F..LDJ	0.003	0.009	0.015	0.003	0.008	0.014
.E..LD	0.003	0.011	0.019	0.003	0.010	0.017
.E..LM	0.003	0.009	0.015	0.003	0.009	0.014
.E..LP	0.003	0.011	0.017	0.003	0.010	0.016
.E..GM	0.003	0.009	0.015	0.003	0.009	0.014
.E..GP	0.003	0.011	0.017	0.003	0.010	0.016
.S..GD	0.006	0.014	0.022	0.006	0.013	0.020
.S..HD	0.006	0.015	0.025	0.006	0.014	0.023

L = Light Machining; M = Medium Machining; H = Heavy Machining.



**VIEW
THE FULL
PORFOLIO**