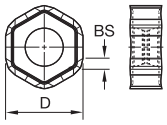
✦✦ first choice with coolant
✧✧ first choice without coolant
✦ alternate choice with coolant
✧ alternate choice without coolant

	KC410M	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
P1–P2			✧/✦	✦✦		✧✧		
P3–P4			✧/✦	✦✦		✧	✧✧	
P5–P6			✧/✦	✦✦		✧	✧✧	
M1–M2			✧/✦	✦			✦	✦✦
M3			✧/✦	✦				✦✦
K1–K2		✧			✧✧			
K3		✧				✧✧		
N1	✦✦							
N2	✦✦							
S1				✦				✦✦
S2				✦				✦✦
S3			✦	✦				✦✦
S4			✦	✦				✦✦



ISO catalog number	ANSI catalog number	D mm	D in	BS mm	BS in	KC410M	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
Light Machining													
HNGJ0604ANFNLDJ	HNGJ43ANFNLDJ	12	.472	1,54	.060	4121575	–	–	–	–	–	–	–
HNGJ0604ANENLD	HNGJ43ANENLD	12	.472	1,54	.060	–	4121576	4121578	–	4119227	4119190	5550701	6165862
General Machining													
HNPJ0604ANSNGD	HNPJ43ANSNGD	12	.472	1,45	.057	–	–	4119697	4119701	4119699	4119700	5550703	6165759
Heavy Machining													
HNGJ0604ANSNHD	HNGJ43ANSNHD	12	.472	1,45	.057	–	–	–	–	–	–	6039659	–
HNPJ0604ANSNHD	HNPJ43ANSNHD	12	.472	1,45	.057	–	–	–	4119229	–	4119228	5550702	–
HNPJ060432ANSNHD	HNPJ438ANSNHD	12	.472	—	—	–	–	–	–	–	–	–	6165861

Recommended Starting Feeds

Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LDJ	.018	**.051**	.089	.013	**.036**	.063	.010	**.027**	.047	.008	**.024**	.041	.008	**.022**	.037	.F..LDJ
.E..LD	.020	**.066**	.112	.015	**.047**	.079	.011	**.035**	.058	.010	**.030**	.051	.009	**.028**	.046	.E..LD
.S..GD	.036	**.086**	.132	.026	**.061**	.092	.019	**.045**	.068	.017	**.039**	.059	.015	**.036**	.054	.S..GD
.S..HD	.036	**.093**	.153	.026	**.066**	.106	.019	**.049**	.078	.017	**.042**	.068	.015	**.039**	.062	.S..HD

HNG….: Ground inserts; high versatility for all medium applications and difficult-to-machine stainless steels and high-temp alloys.
HNP….: Pressed inserts; lower cost per edge for roughing operations with high feed rates.

Material Group		KC410M*			KC510M			KC522M			KC725M		
P	1	–	–	–	–	–	–	1295	**1115**	1065	1015	**900**	855
	2	–	–	–	–	–	–	1085	**950**	785	870	**755**	625
	3	–	–	–	–	–	–	1000	**855**	690	785	**675**	560
	4	–	–	–	970	**785**	675	885	**720**	590	705	**590**	475
	5	–	–	–	–	–	–	720	**675**	590	590	**525**	475
	6	–	–	–	–	–	–	655	**490**	395	510	**395**	310
M	1	–	–	–	–	–	–	805	**705**	655	675	**590**	525
	2	–	–	–	–	–	–	720	**625**	510	605	**510**	425
	3	–	–	–	–	–	–	560	**475**	375	460	**395**	310
K	1	–	–	–	1165	**1050**	950	900	**805**	720	–	–	–
	2	–	–	–	900	**805**	755	705	**625**	590	–	–	–
	3	–	–	–	770	**690**	625	590	**525**	475	–	–	–
N	1	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–
S	1	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–
H	1	–	–	–	625	**510**	360	475	**360**	280	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–

Material Group		KCK15			KCPK30			KCPM40			KCSM40		
P	1	–	–	–	1790	**1560**	1460	1165	**1015**	970	–	–	–
	2	–	–	–	1100	**1000**	900	985	**855**	705	–	–	–
	3	–	–	–	1000	**900**	805	900	**770**	625	–	–	–
	4	–	–	–	755	**690**	625	805	**675**	525	–	–	–
	5	–	–	–	1015	**900**	820	675	**605**	525	675	**575**	475
	6	–	–	–	625	**525**	475	590	**460**	360	590	**425**	310
M	1	–	–	–	805	**720**	605	770	**675**	605	820	**675**	560
	2	–	–	–	720	**625**	560	690	**590**	490	705	**575**	475
	3	–	–	–	575	**510**	460	510	**460**	360	575	**425**	330
K	1	1655	**1510**	1345	1165	**1050**	950	–	–	–	–	–	–
	2	1310	**1165**	1085	920	**820**	755	–	–	–	–	–	–
	3	1100	**985**	900	770	**690**	625	–	–	–	–	–	–
N	1	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–
S	1	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–
H	1	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–

*Recommended for wet machining only.
NOTE: FIRST choice starting speeds are in **bold** type.
As the average chip thickness increases, the speed should be decreased.

Dry

Wet

Material Group		KC410M			KC510M			KC522M			KC725M		
P	1	–	–	–	–	–	–	1035	**890**	850	410	**380**	315
	2	–	–	–	–	–	–	870	**760**	630	380	**340**	330
	3	–	–	–	–	–	–	800	**685**	550	340	**315**	290
	4	–	–	–	775	**630**	540	710	**575**	470	315	**290**	250
	5	–	–	–	–	–	–	575	**540**	470	290	**250**	235
	6	–	–	–	–	–	–	525	**390**	315	250	**235**	225
M	1	–	–	–	–	–	–	645	**565**	525	330	**290**	250
	2	–	–	–	–	–	–	575	**500**	410	300	**265**	235
	3	–	–	–	–	–	–	450	**380**	300	225	**185**	170
K	1	–	–	–	930	**840**	760	720	**645**	575	–	–	–
	2	–	–	–	720	**645**	605	565	**500**	470	–	–	–
	3	–	–	–	615	**550**	500	470	**420**	380	–	–	–
N	1	3830	**3400**	3135	2020	**1795**	1650	–	–	–	–	–	–
	2	3400	**3135**	2890	1825	**1680**	1550	–	–	–	–	–	–
	3	3400	**3135**	2890	1825	**1680**	1550	–	–	–	–	–	–
S	1	–	–	–	–	–	–	130	**105**	80	–	–	–
	2	–	–	–	–	–	–	130	**105**	80	–	–	–
	3	–	–	–	–	–	–	155	**130**	80	–	–	–
	4	–	–	–	–	–	–	225	**155**	105	–	–	–
H	1	–	–	–	500	**410**	290	380	**290**	225	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–

Material Group		KCK15			KCPK30			KCPM40			KCSM40		
P	1	–	–	–	1430	**1250**	1170	930	**810**	775	–	–	–
	2	–	–	–	880	**800**	720	790	**685**	565	–	–	–
	3	–	–	–	800	**720**	645	720	**615**	500	–	–	–
	4	–	–	–	605	**550**	500	645	**540**	420	–	–	–
	5	–	–	–	810	**720**	655	540	**485**	420	540	**460**	380
	6	–	–	–	500	**420**	385	470	**370**	290	470	**340**	250
M	1	–	–	–	645	**575**	485	615	**540**	485	655	**540**	450
	2	–	–	–	575	**500**	450	550	**470**	390	565	**460**	380
	3	–	–	–	460	**410**	370	410	**370**	290	460	**340**	265
K	1	1325	**1210**	1075	930	**840**	760	–	–	–	–	–	–
	2	1050	**930**	870	735	**655**	605	–	–	–	–	–	–
	3	880	**790**	720	615	**550**	500	–	–	–	–	–	–
N	1	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–
S	1	–	–	–	–	–	–	130	**105**	90	130	**105**	80
	2	–	–	–	–	–	–	130	**105**	90	130	**105**	80
	3	–	–	–	–	–	–	155	**130**	90	155	**130**	80
	4	–	–	–	210	**155**	105	210	**155**	105	185	**155**	90
H	1	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–

NOTE: FIRST choice starting speeds are in **bold** type.
As the average chip thickness increases, the speed should be decreased.

Dry

Wet