

■ Recommended Starting Speeds [SFM]

Material Group		KC522M			KC725M			KCPK30			KCSM30		
P	1	-	-	-	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-
	4	-	-	-	-	-	-	-	-	-	-	-	-
	5	-	-	-	-	-	-	-	-	-	-	-	-
	6	650	490	400	520	400	310	-	-	-	-	-	-
M	1	800	710	650	670	590	540	-	-	-	-	-	-
	2	730	620	520	610	520	430	-	-	-	-	-	-
	3	550	480	370	460	400	310	-	-	-	-	-	-
K	1	-	-	-	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-
N	1-2	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-
S	1	160	140	110	120	100	-	-	-	-	-	-	-
	2	160	140	110	100	100	-	-	-	-	-	-	-
	3	200	160	110	130	130	-	-	-	-	-	-	-
	4	280	200	140	170	150	-	-	-	-	-	-	-
H	1	-	-	-	-	-	-	-	-	-	-	-	-

Indexable Milling

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

Recommended Starting Feeds

■ Recommended Starting Feeds [IPT]

Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)			Insert Geometry
	50-100%			
	Light Machining	General Purpose	Heavy Machining	
All Inserts	.004	.010	.016	All Inserts

NOTE: Use "Light Machining" values as starting feed rate.
% = $ae/DC \times 100$ (ae=radial depth of cut, DC=cutting diameter)