Recommended Starting Speeds [SFM]

Material Group		KC422M			KC522M			KC725M			KCPK30		
P	1	–	–	–	1300	**1130**	1060	1030	**900**	840	1780	**1560**	1450
	2	–	–	–	1080	**950**	790	860	**760**	640	1100	**1000**	900
	3	–	–	–	1000	**840**	700	790	**670**	550	1000	**900**	820
	4	–	–	–	890	**730**	590	710	**590**	470	740	**690**	620
	5	–	–	–	730	**660**	590	590	**530**	470	1020	**910**	830
	6	–	–	–	650	**490**	400	520	**400**	310	620	**540**	–
M	1	–	–	–	800	**710**	650	670	**590**	540	820	**720**	620
	2	–	–	–	730	**620**	520	610	**520**	430	730	**640**	550
	3	–	–	–	550	**480**	370	460	**400**	310	570	**520**	460
K	1	–	–	–	900	**820**	720	–	–	–	1160	**1050**	940
	2	–	–	–	710	**640**	590	–	–	–	920	**830**	760
	3	–	–	–	590	**530**	480	–	–	–	770	**690**	640
N	1–2	4220	**3720**	3440	–	–	–	–	–	–	–	–	–
	3	3720	**3440**	3000	–	–	–	–	–	–	–	–	–
S	1	–	–	–	160	**140**	110	140	**120**	100	–	–	–
	2	–	–	–	160	**140**	110	140	**120**	100	–	–	–
	3	–	–	–	200	**160**	110	180	**140**	100	–	–	–
	4	–	–	–	280	**200**	140	240	**180**	120	–	–	–
H	1	–	–	–	470	**360**	280	–	–	–	–	–	–

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

Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining

At .250 Axial Depth of Cut (ap)

Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LEJ	.003	**.005**	.007	.003	**.004**	.005	.002	**.003**	.005	.002	**.003**	.004	.002	**.003**	.004	.E..LEJ
.E..GE	.006	**.010**	.015	.004	**.008**	.011	.004	**.007**	.010	.004	**.006**	.009	.004	**.006**	.009	.E..GE
.S..GEJ	.007	**.017**	.023	.005	**.013**	.017	.004	**.011**	.015	.004	**.010**	.014	.004	**.010**	.014	.S..GEJ
.S..GE	.007	**.017**	.023	.005	**.013**	.017	.004	**.011**	.015	.004	**.010**	.014	.004	**.010**	.014	.S..GE

At .125 Axial Depth of Cut (ap)

Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LEJ	.004	**.006**	.008	.003	**.004**	.006	.003	**.004**	.005	.002	**.003**	.005	.002	**.003**	.005	.E..LEJ
.E..GE	.007	**.012**	.017	.005	**.009**	.013	.004	**.008**	.011	.004	**.007**	.010	.004	**.007**	.010	.E..GE
.S..GEJ	.008	**.020**	.027	.006	**.015**	.020	.005	**.013**	.017	.005	**.012**	.016	.005	**.012**	.016	.S..GEJ
.S..GE	.008	**.020**	.027	.006	**.015**	.020	.005	**.013**	.017	.005	**.012**	.016	.005	**.012**	.016	.S..GE

At .063 Axial Depth of Cut (ap)

Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LEJ	.005	**.007**	.011	.004	**.005**	.008	.003	**.005**	.007	.003	**.004**	.006	.003	**.004**	.006	.E..LEJ
.E..GE	.009	**.015**	.023	.007	**.011**	.017	.006	**.010**	.014	.005	**.009**	.014	.005	**.009**	.013	.E..GE
.S..GEJ	.010	**.026**	.035	.008	**.019**	.026	.007	**.017**	.022	.006	**.015**	.021	.006	**.015**	.020	.S..GEJ
.S..GE	.010	**.026**	.035	.008	**.019**	.026	.007	**.017**	.022	.006	**.015**	.021	.006	**.015**	.020	.S..GE

At .031 Axial Depth of Cut (ap)

Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LEJ	.007	**.010**	.015	.005	**.007**	.011	.005	**.006**	.009	.004	**.006**	.009	.004	**.006**	.009	.E..LEJ
.E..GE	.012	**.021**	.031	.009	**.016**	.023	.008	**.014**	.020	.007	**.013**	.018	.007	**.012**	.018	.E..GE
.S..GEJ	.014	**.036**	.049	.010	**.026**	.035	.009	**.023**	.031	.008	**.021**	.028	.008	**.021**	.028	.S..GEJ
.S..GE	.014	**.036**	.049	.010	**.026**	.035	.009	**.023**	.031	.008	**.021**	.028	.008	**.021**	.028	.S..GE

NOTE: Use “Light Machining” values as starting feed rate.