Recommended Starting Speeds [SFM]

Material Group		KC520M			KC725M			KCK15			KCPK30			KCPM40		
P	1	–	–	–	1030	**900**	840	–	–	–	1790	**1560**	1440	1030	**900**	840
	2	–	–	–	850	**750**	640	–	–	–	1100	**1000**	900	850	**750**	640
	3	–	–	–	790	**670**	560	–	–	–	1000	**900**	820	790	**670**	560
	4	–	–	–	710	**590**	480	–	–	–	740	**690**	620	710	**590**	480
	5	–	–	–	590	**520**	480	–	–	–	1020	**900**	840	590	**520**	480
	6	–	–	–	520	**390**	310	–	–	–	620	**540**	–	520	**390**	310
M	1	–	–	–	670	**590**	540	–	–	–	820	**720**	620	670	**590**	540
	2	–	–	–	610	**520**	430	–	–	–	740	**640**	560	610	**520**	430
	3	–	–	–	460	**390**	310	–	–	–	570	**520**	460	460	**390**	310
K	1	1070	**970**	850	–	–	–	1660	**1510**	1350	1160	**1050**	940	–	–	–
	2	840	**740**	710	–	–	–	1310	**1160**	1080	920	**840**	750	–	–	–
	3	710	**620**	560	–	–	–	1100	**980**	900	770	**690**	640	–	–	–
N	1–2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
S	1	–	–	–	150	**110**	100	–	–	–	–	–	–	150	**110**	100
	2	–	–	–	150	**110**	100	–	–	–	–	–	–	150	**110**	100
	3	–	–	–	180	**150**	100	–	–	–	–	–	–	180	**150**	100
	4	–	–	–	250	**180**	110	–	–	–	–	–	–	250	**180**	110
H	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

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]

Light Machining	General Purpose	Heavy Machining

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

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