

■ 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	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—



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]

Light Machining	General Purpose	Heavy Machining
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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.