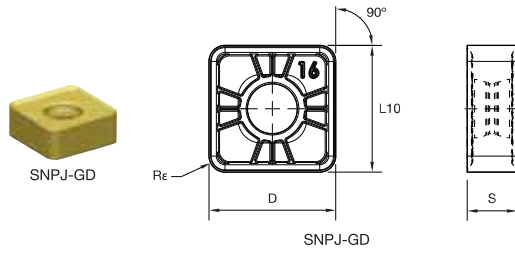


• First choice for regular roughing.



P	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
M	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
K	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
N	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
S	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
H	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

● first choice
○ alternate choice

■ SNPJ-GD

catalog number	D	S	L10	Re	hm	cutting edges	KC520M	KC522M	KC725M	KCK15	KCK20	KCPK30	KCPM40	KCSM40
SNPJ442SNGD	.500	.178	.500	.031	.005	8	●	-	-	-	●	●	●	-
SNPJ444SNGD	.500	.178	.500	.063	.005	8	-	-	-	●	-	●	●	-

Recommended Starting Feeds

■ Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining
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Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)													Insert Geometry		
	5%			10%			20%			30%			40-100%			
.E..LD	.007	.018	.033	.005	.013	.024	.004	.010	.018	.003	.009	.015	.003	.008	.014	.E..LD
.S..GD	.009	.023	.036	.007	.017	.026	.005	.013	.019	.004	.011	.017	.004	.010	.016	.S..GD

NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.



Face Milling