

■ Recommended Starting Speeds [m/min]

Material Group	TN2510			TN450			TN5515			TN6510			TN6520			TN6525			TN6540			TN7525			KY3500		
P1				250	215	200										410	325	280	360	280	240	410	325	280			
P2				180	150	140										325	250	215	250	190	165	325	250	215			
P3				160	140	130										280	215	185	215	165	140	280	215	185			
P4				130	110	100										235	170	145	180	130	110	235	170	145			
P5				180	150	140										315	235	195	240	180	150	315	235	195			
P6				120	100	90										210	160	130	160	120	100	210	160	130			
M1																											
M2																											
M3																											
K1	420	360	300	490	360	300	360	300	240	360	300	240	240	180	160							380	280	240	800	730	650
K2	360	300	250	380	300	250	300	240	200	300	240	200	180	160	140							320	240	200	630	570	530
K3	300	250	200	320	250	200	240	200	160	240	200	160	160	140	120							240	200	170	530	470	430
N1																											
N2																											
S1																											
S2																											
S3																											
S4																											
H1																											

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

84° Approach Angle Feed-per-Tooth Compensation
(Radial Width-of-Cut Dependent)

