Recommended Starting Speeds [m/min]

Material Group	KC522M			KC525M			KC725M			KCPK30		
P1	250	**230**	210	220	**200**	180	260	230	210	390	340	320
P2	210	**200**	190	180	**160**	150	160	150	130	240	220	200
P3	190	**180**	170	160	**150**	140	150	130	120	220	200	180
P4	170	**160**	150	140	**130**	120	110	100	90	160	150	140
P5	180	**170**	160	150	**140**	130	125	110	100	225	200	180
P6	160	**150**	140	130	**120**	110	90	80		140	120	
M1	220	**210**	200	150	**140**	130	170	150	140	250	220	210
M2	190	**170**	150	130	**120**	110	150	140	130	230	210	190
M3	130	**120**	110	90	**80**	70	120	100		170	150	
N1												
N2												
S1	60	**60**	50	60	**50**	50	40	30				
S2	60	**60**	50	60	**50**	50	30	30				
S3	50	**40**	40	50	**50**	40	40	40				
S4	**60**	50	40	**60**	50	40	50	50				
H1	160	120	80									

*FIRST choice starting speeds are in **bold** type.*
As the average chip thickness goes higher the speed should be decreased.

Recommended Starting Feeds [mm]

End Mills

cutter dia.	number	size	feed p/tooth fz	max Ap	max ramp angle
16	3519052	WP..0302..	0,25–0,75	0,75	1,0°
20	2622213	WP..05X3..	0,3–0,8	1	2,0°
20	2622214	WP..05X3..	0,3–0,8	1	1,5°
25	3651445	WP..06X4..	0,5–1,5	1,5	2,5°
25	2622215	WP..05X3..	0,3–0,8	1	2,5°
25	2622216	WP..06X4..	0,5–1,5	1,5	1,5°
32	2622217	WP..06X4..	0,5–1,5	1,5	3,0°
32	2622218	WP..06X4..	0,5–1,5	1,5	1,5°
35	2622219	WP..06X4..	0,5–1,5	1,5	2,0°
35	2426593	WP..0806..	0,75–2,0	1,5	3,0°

Shell Mills

dia.	number	size	fz	Ap	ramp angle
42	3651446	WP..06X4..	0,5–,5	1,5	2,5°
42	2622220	WP..05X3..	0,3–0,8	1	2,0°
50	3053342	WP..06X4..	0,5–1,5	1,5	3,0°
52	2246732	WP..0806..	0,75–2,0	1,5	2,5°
52	2622229	WP..0806..	0,75–2,0	1,5	2,5°
52	2622221	WP..06X4..	0,5–1,5	1,5	2,0°
66	2403211	WP..0806..	0,75–2,0	1,5	2,0°
66	2622222	WP..06X4..	0,5–1,5	1,5	1,0°
80	2418256	WP..0806..	0,75–2,0	1,5	1,5°
80	2622223	WP..06X4..	0,5–1,5	1,5	1,0°
100	3346947	WP..0806..	0,75–2,0	1,5	1,0°
125	2639686	WP..0806..	0,75–2,0	1,5	1,0°

(continued)