Recommended Starting Speeds [m/min]

Material Group		KC510M			KC522M			KC725M			KCPM20			KCPK30		
P	1	–	–	–	395	**345**	325	315	**275**	255	660	**580**	535	545	**475**	440
	2	–	–	–	330	**290**	240	260	**230**	195	410	**370**	330	335	**305**	275
	3	–	–	–	305	**255**	215	240	**205**	170	370	**330**	305	305	**275**	250
	4	295	**240**	200	270	**225**	180	215	**180**	145	275	**255**	230	225	**210**	190
	5	–	–	–	225	**200**	180	180	**160**	145	330	**300**	275	310	**275**	255
	6	–	–	–	200	**150**	120	160	**120**	95	230	**200**	175	190	**165**	–
M	1	–	–	–	245	**215**	200	205	**180**	165	270	**240**	205	250	**220**	190
	2	–	–	–	225	**190**	160	185	**160**	130	245	**215**	190	225	**195**	170
	3	–	–	–	170	**145**	115	140	**120**	95	195	**175**	150	175	**160**	140
K	1	350	**315**	285	275	**250**	220	–	–	–	435	**390**	350	355	**320**	285
	2	275	**250**	230	215	**195**	180	–	–	–	345	**310**	280	280	**255**	230
	3	235	**205**	190	180	**160**	145	–	–	–	290	**255**	240	235	**210**	195
N	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
S	1	–	–	–	50	**45**	35	45	**35**	30	–	–	–	–	–	–
	2	–	–	–	50	**45**	35	45	**35**	30	–	–	–	–	–	–
	3	–	–	–	60	**50**	35	55	**45**	30	–	–	–	–	–	–
	4	–	–	–	85	**60**	45	75	**55**	35	–	–	–	–	–	–
H	1	190	**155**	110	145	**110**	85	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

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

Recommended Starting Feeds [mm]

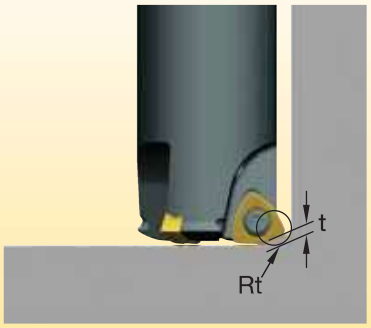
Light Machining	General Purpose	Heavy Machining

Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)																Insert Geometry
	10%			20%			30%			40%			50–100%				
.LD..	0,66	**1,67**	2,70	0,49	**1,23**	1,98	0,43	**1,07**	1,72	0,40	**1,00**	1,60	0,39	**0,98**	1,57		.LD..
.LN..	0,66	**1,67**	2,70	0,49	**1,23**	1,98	0,43	**1,07**	1,72	0,40	**1,00**	1,60	0,39	**0,98**	1,57		.LN..

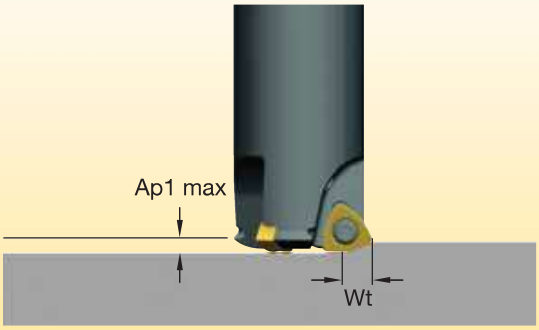
NOTE: Use “Light Machining” values as starting feed rate.

General Programming Information for Applying KenFeed Mini

Rt	Wt	t
1.00	2.40	0.40



For CAM programming, the loads can be programmed as a toroidal tool type by using the Rt value as the insert radius.



Small Ap1 values and higher feed rates generate lower cutting forces versus traditional milling strategies.