

Recommended Starting Speeds (sfm)

0° approach angle

Material Group	K313			KC410M		
P1						
P2						
P3						
P4						
P5						
P6						
M1						
M2						
M3						
K1						
K2						
K3						
N1	2500	2000	1500	3990	3550	3270
N2						
S1						
S2						
S3						
S4						
H1						

FIRST choice starting speeds are in bold type.

As the average chip thickness goes higher the speed should be decreased.

Recommended Starting Feeds

0° Approach Angle Feed-Per-Tooth Compensation
(Radial Width-of-Cut Dependent)

