THREAD MILLS



## Recommended Starting Speeds (sfm)

0° approach angle

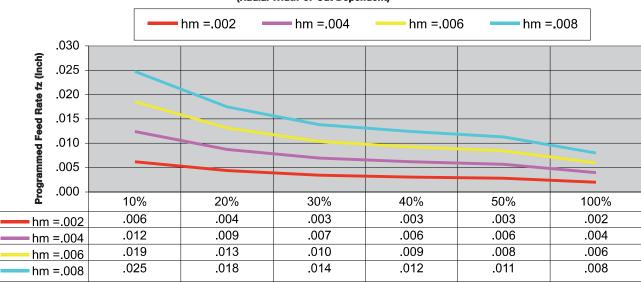
| Material<br>Group | K313 |      |      | KC410M |      |      |
|-------------------|------|------|------|--------|------|------|
| P1                |      |      |      |        |      |      |
| P2                |      |      |      |        |      |      |
| P3                |      |      |      |        |      |      |
| P4                |      |      |      |        |      |      |
| P5                |      |      |      |        |      |      |
| P6                |      |      |      |        |      |      |
| M1                |      |      |      |        |      |      |
| M2                |      |      |      |        |      |      |
| M3                |      |      |      |        |      |      |
| K1                |      |      |      |        |      |      |
| K2                |      |      |      |        |      |      |
| КЗ                |      |      |      |        |      |      |
| N1                | 2500 | 2000 | 1500 | 3990   | 3550 | 3270 |
| N2                |      |      |      |        |      |      |
| S1                |      |      |      |        |      |      |
| <b>S2</b>         |      |      |      |        |      |      |
| S3                |      |      |      |        |      |      |
| <b>S4</b>         |      |      |      |        |      |      |
| 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)



Percentage of the Cutter Diameter in Cut