■ Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining

At .200 Axial Depth of Cut (ap)

Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)

Insert Geometry	5%			10%			20%			30%			40–100%			Insert Geometry
.F..LDJ	.005	.016	.028	.004	.011	.020	.003	.008	.015	.002	.007	.013	.002	.007	.012	.F..LDJ
.E..LDJ	.005	.017	.030	.004	.013	.021	.003	.009	.016	.002	.008	.014	.002	.008	.013	.E..LDJ
.E..LD	.005	.017	.030	.004	.013	.021	.003	.009	.016	.002	.008	.014	.002	.008	.013	.E..LD
.S..GDJ	.009	.021	.032	.007	.015	.023	.005	.011	.017	.004	.010	.015	.004	.009	.014	.S..GDJ
.S..GD	.009	.021	.032	.007	.015	.023	.005	.011	.017	.004	.010	.015	.004	.009	.014	.S..GD
.S..HD	.009	.021	.033	.007	.015	.023	.005	.011	.017	.004	.010	.015	.004	.009	.014	.S..HD

At .070 Axial Depth of Cut (ap)

Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)

Insert Geometry	5%			10%			20%			30%			40–100%			Insert Geometry
.F..LDJ	.006	.021	.037	.005	.015	.027	.003	.011	.020	.003	.010	.017	.003	.009	.016	.F..LDJ
.E..LDJ	.006	.023	.040	.005	.016	.028	.003	.012	.021	.003	.011	.018	.003	.010	.017	.E..LDJ
.E..LD	.006	.023	.040	.005	.016	.028	.003	.012	.021	.003	.011	.018	.003	.010	.017	.E..LD
.S..GDJ	.012	.027	.043	.009	.019	.030	.007	.014	.022	.006	.013	.019	.005	.012	.018	.S..GDJ
.S..GD	.012	.027	.043	.009	.019	.030	.007	.014	.022	.006	.013	.019	.005	.012	.018	.S..GD
.S..HD	.012	.028	.043	.009	.020	.031	.007	.015	.023	.006	.013	.020	.005	.012	.018	.S..HD

At .040 Axial Depth of Cut (ap)

Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)

Insert Geometry	5%			10%			20%			30%			40–100%			Insert Geometry
.F..LDJ	.008	.026	.048	.006	.019	.034	.004	.014	.025	.004	.012	.022	.004	.011	.020	.F..LDJ
.E..LDJ	.008	.029	.051	.006	.021	.036	.004	.016	.027	.004	.014	.023	.004	.012	.021	.E..LDJ
.E..LD	.008	.029	.051	.006	.021	.036	.004	.016	.027	.004	.014	.023	.004	.012	.021	.E..LD
.S..GDJ	.015	.035	.054	.011	.025	.038	.008	.018	.028	.007	.016	.025	.007	.015	.023	.S..GDJ
.S..GD	.015	.035	.054	.011	.025	.038	.008	.018	.028	.007	.016	.025	.007	.015	.023	.S..GD
.S..HD	.015	.035	.055	.011	.025	.039	.008	.019	.029	.007	.016	.025	.007	.015	.023	.S..HD

At .020 Axial Depth of Cut (ap)

Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)

Insert Geometry	5%			10%			20%			30%			40–100%			Insert Geometry
.F..LDJ	.011	.037	.067	.008	.026	.047	.006	.019	.034	.005	.017	.030	.005	.015	.027	.F..LDJ
.E..LDJ	.011	.041	.072	.008	.029	.050	.006	.021	.037	.005	.019	.032	.005	.017	.029	.E..LDJ
.E..LD	.011	.041	.072	.008	.029	.050	.006	.021	.037	.005	.019	.032	.005	.017	.029	.E..LD
.S..GDJ	.021	.048	.077	.015	.034	.053	.011	.025	.039	.010	.022	.034	.009	.020	.031	.S..GDJ
.S..GD	.021	.048	.077	.015	.034	.053	.011	.025	.039	.010	.022	.034	.009	.020	.031	.S..GD
.S..HD	.021	.049	.078	.015	.035	.054	.011	.026	.040	.010	.022	.034	.009	.020	.031	.S..HD

NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Copy Milling