■ Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining

At .240 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)														Insert Geometry
	5%			10%			20%			30%			40–100%		
.F..LDJ	.005	.016	.030	.004	.011	.021	.003	.008	.016	.002	.007	.014	.002	.007	.013	.F..LDJ
.E..LDJ	.005	.017	.032	.004	.013	.023	.003	.009	.017	.002	.008	.015	.002	.008	.014	.E..LDJ
.E..LD	.005	.017	.032	.004	.013	.023	.003	.009	.017	.002	.008	.015	.002	.008	.014	.E..LD
.S..GDJ	.009	.023	.035	.007	.017	.025	.005	.013	.019	.004	.011	.016	.004	.010	.015	.S..GDJ
.S..GD	.009	.023	.035	.007	.017	.025	.005	.013	.019	.004	.011	.016	.004	.010	.015	.S..GD
.S..HD	.009	.023	.035	.007	.017	.025	.005	.013	.019	.004	.011	.016	.004	.010	.015	.S..HD

At .080 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)														Insert Geometry
	5%			10%			20%			30%			40–100%		
.F..LDJ	.007	.021	.040	.005	.015	.029	.004	.011	.021	.003	.010	.019	.003	.009	.017	.F..LDJ
.E..LDJ	.007	.023	.043	.005	.017	.030	.004	.013	.023	.003	.011	.020	.003	.010	.018	.E..LDJ
.E..LD	.007	.023	.043	.005	.017	.030	.004	.013	.023	.003	.011	.020	.003	.010	.018	.E..LD
.S..GDJ	.012	.031	.048	.009	.022	.034	.007	.017	.025	.006	.015	.022	.005	.013	.020	.S..GDJ
.S..GD	.012	.031	.048	.009	.022	.034	.007	.017	.025	.006	.015	.022	.005	.013	.020	.S..GD
.S..HD	.012	.031	.048	.009	.022	.034	.007	.017	.025	.006	.015	.022	.005	.013	.020	.S..HD

At .050 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)														Insert Geometry
	5%			10%			20%			30%			40–100%		
.F..LDJ	.008	.026	.049	.006	.018	.035	.004	.014	.026	.004	.012	.023	.003	.011	.021	.F..LDJ
.E..LDJ	.008	.029	.052	.006	.020	.037	.004	.015	.028	.004	.013	.024	.003	.012	.022	.E..LDJ
.E..LD	.008	.029	.052	.006	.020	.037	.004	.015	.028	.004	.013	.024	.003	.012	.022	.E..LD
.S..GDJ	.015	.038	.059	.011	.027	.041	.008	.020	.031	.007	.018	.027	.007	.016	.024	.S..GDJ
.S..GD	.015	.038	.059	.011	.027	.041	.008	.020	.031	.007	.018	.027	.007	.016	.024	.S..GD
.S..HD	.015	.038	.059	.011	.027	.041	.008	.020	.031	.007	.018	.027	.007	.016	.024	.S..HD

At .030 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)														Insert Geometry
	5%			10%			20%			30%			40–100%		
.F..LDJ	.010	.033	.063	.007	.023	.044	.005	.017	.033	.005	.015	.029	.004	.014	.026	.F..LDJ
.E..LDJ	.010	.036	.067	.007	.026	.047	.005	.019	.035	.005	.017	.030	.004	.015	.028	.E..LDJ
.E..LD	.010	.036	.067	.007	.026	.047	.005	.019	.035	.005	.017	.030	.004	.015	.028	.E..LD
.S..GDJ	.019	.049	.075	.014	.035	.052	.010	.026	.039	.009	.022	.034	.008	.021	.031	.S..GDJ
.S..GD	.019	.049	.075	.014	.035	.052	.010	.026	.039	.009	.022	.034	.008	.021	.031	.S..GD
.S..HD	.019	.049	.075	.014	.035	.052	.010	.026	.039	.009	.022	.034	.008	.021	.031	.S..HD

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

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