

■ Recommended Starting Feeds [IPT]

| Light Machining | General Purpose | Heavy Machining |
|--------------------|--------------------|--------------------|
|--------------------|--------------------|--------------------|

At .320 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% | | | |
| .E..LDJ | .005 | .017 | .031 | .004 | .013 | .023 | .003 | .009 | .017 | .002 | .008 | .015 | .002 | .008 | .014 | .E..LDJ |
| .E..LD | .005 | .017 | .031 | .004 | .013 | .023 | .003 | .009 | .017 | .002 | .008 | .015 | .002 | .008 | .014 | .E..LD |
| .S..GD | .009 | .020 | .035 | .007 | .014 | .025 | .005 | .011 | .019 | .004 | .009 | .016 | .004 | .009 | .015 | .S..GD |
| .S..HD | .009 | .023 | .037 | .007 | .017 | .027 | .005 | .013 | .020 | .004 | .011 | .017 | .004 | .010 | .016 | .S..HD |

At .100 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% | | | |
| .E..LDJ | .007 | .024 | .043 | .005 | .017 | .031 | .004 | .013 | .023 | .003 | .011 | .020 | .003 | .010 | .018 | .E..LDJ |
| .E..LD | .007 | .024 | .043 | .005 | .017 | .031 | .004 | .013 | .023 | .003 | .011 | .020 | .003 | .010 | .018 | .E..LD |
| .S..GD | .013 | .027 | .048 | .009 | .019 | .034 | .007 | .015 | .026 | .006 | .013 | .022 | .005 | .012 | .020 | .S..GD |
| .S..HD | .013 | .032 | .051 | .009 | .023 | .037 | .007 | .017 | .027 | .006 | .015 | .024 | .005 | .014 | .022 | .S..HD |

At .060 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% | | | |
| .E..LDJ | .008 | .030 | .054 | .006 | .021 | .039 | .005 | .016 | .029 | .004 | .014 | .025 | .004 | .013 | .023 | .E..LDJ |
| .E..LD | .008 | .030 | .054 | .006 | .021 | .039 | .005 | .016 | .029 | .004 | .014 | .025 | .004 | .013 | .023 | .E..LD |
| .S..GD | .016 | .034 | .060 | .011 | .024 | .043 | .009 | .018 | .032 | .007 | .016 | .028 | .007 | .014 | .025 | .S..GD |
| .S..HD | .016 | .040 | .064 | .011 | .029 | .046 | .009 | .021 | .034 | .007 | .019 | .030 | .007 | .017 | .027 | .S..HD |

At .040 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% | | | |
| .E..LDJ | .010 | .036 | .066 | .007 | .026 | .047 | .005 | .019 | .035 | .005 | .017 | .030 | .004 | .015 | .028 | .E..LDJ |
| .E..LD | .010 | .036 | .066 | .007 | .026 | .047 | .005 | .019 | .035 | .005 | .017 | .030 | .004 | .015 | .028 | .E..LD |
| .S..GD | .019 | .041 | .073 | .014 | .029 | .052 | .010 | .022 | .039 | .009 | .019 | .034 | .008 | .017 | .031 | .S..GD |
| .S..HD | .019 | .048 | .078 | .014 | .034 | .056 | .010 | .026 | .041 | .009 | .022 | .036 | .008 | .021 | .033 | .S..HD |

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



Copy Milling