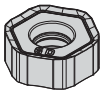
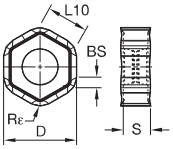
- First choice for general purpose.

● first choice
○ alternate choice

	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
P					○	●		●	●	○
M					●	●		●	○	●
K			●	●	○		●	○		
N	●	●	○							
S					●	●				●
H										


HNPJ-GD

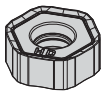


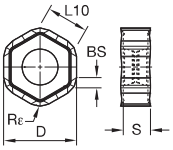
HNPJ-GD

HNPJ-GD

catalogue number	D	BS	L10	Rε	S	hm	cutting edges	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNPJ0604ANSNGD	12	1,45	6,44	1,0	4,45	0,08	12	–	–	–	●	●	●	●	●	●	●

- First choice for heavy roughing.


HNPJ-HD



HNPJ-HD

HNPJ-HD

catalogue number	D	BS	L10	Rε	S	hm	cutting edges	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNPJ0604ANSNHD	12	1,45	6,44	1,0	4,40	0,14	12	–	–	–	●	●	●	●	●	●	●
HNPJ060432ANSNHD	12	—	6,43	3,2	4,42	0,10	12	–	–	–	–	●	●	●	●	●	●

Recommended Starting Feeds

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

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	0,17	**0,46**	0,79	0,12	**0,33**	0,57	0,09	**0,25**	0,43	0,08	**0,22**	0,37	0,07	**0,20**	0,34	.F..LDJ
.E..LD	0,18	**0,59**	0,99	0,13	**0,43**	0,71	0,10	**0,32**	0,53	0,09	**0,28**	0,46	0,08	**0,25**	0,42	.E..LD
.S..GD	0,33	**0,79**	1,19	0,24	**0,57**	0,86	0,18	**0,43**	0,64	0,16	**0,37**	0,56	0,14	**0,34**	0,51	.S..GD
.S..HD	0,33	**0,84**	1,35	0,24	**0,60**	0,97	0,18	**0,45**	0,72	0,16	**0,39**	0,63	0,14	**0,36**	0,57	.S..HD

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