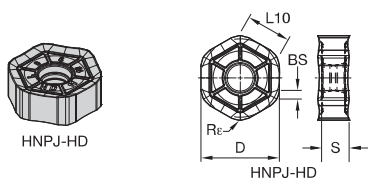


beyond

- First choice for heavy roughing.



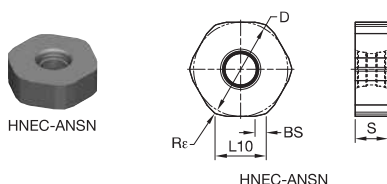
HNPJ-HD

catalog number	D	S	L10	BS	Re	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
HNPJ535ANSNHD	.625	.215	.338	.065	.047	.007	12	—	•	•	•	•	•	•	•	—
HNPJ53511ANSNHD	.625	.214	.334	—	.171	.005	12	—	•	•	•	•	•	•	•	—

- first choice
- alternate choice

P	M	K	N	S	H
•	•	•	•	•	•
•	•	•	•	•	•
•	•	•	•	•	•
•	•	•	•	•	•
•	•	•	•	•	•

- Ceramic KYON 3500 for machining gray cast iron with high cutting speed.



HNEC-ANSN Ceramic Insert

catalog number	D	S	L10	BS	Re	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
HNEC535ANSN	.625	.219	.361	.077	.047	.008	12	—	•	•	•	•	•	•	•	—

Recommended Starting Feeds

Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining
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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	.018	.032	.005	.013	.023	.004	.010	.017	.003	.009	.015	.003	.008	.014	.F..LDJ
.E..LD	.009	.026	.040	.007	.019	.029	.005	.014	.021	.004	.012	.019	.004	.011	.017	.E..LD
.S..GD	.013	.028	.045	.009	.020	.032	.007	.015	.024	.006	.013	.021	.006	.012	.019	.S..GD
.S..HD	.013	.033	.053	.009	.024	.038	.007	.018	.028	.006	.015	.025	.006	.014	.023	.S..HD

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

Face Milling