KENNAMETAL

SEPT-GB2

SEPT-GB2

● first choice
○ alternate choice

	KC725M	KCK15	KCPK30		
P	●	●	○	●	
M	●	○	○	●	○
K	●	●	○	○	●
N	●				
S	●		●	●	
H					

■ SEPT-GB2

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPK30	KCSM30	KC522M	KCPM40	KY3500
SEPT443AEEN7GB2	.551	.188	.551	.104	.039	.003	4	–	–	●	●	●	–	–	–	–
SEPT443AESN7GB2	.551	.188	.551	.104	.039	.005	4	–	–	●	●	●	–	–	–	–

SECW-GNW   SECW-GN
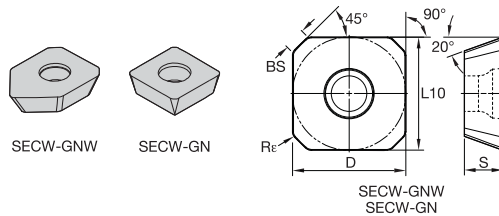
SECW-GNW
SECW-GN

■ SECW-GN

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPK30	KCSM30	KC522M	KCPM40	KY3500
SECW443AESN7GN	.551	.188	.551	.104	.039	.006	4	–	–	–	–	–	–	–	–	●

■ SECW-GNW

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPK30	KCSM30	KC522M	KCPM40	KY3500
SECW443AEEN22GNW	.551	.188	.325	.325	.063	.002	2	–	–	●	–	–	–	–	–	–

Recommended Starting Feeds

Face Milling

■ Recommended Starting Feeds [IPT]

	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..LE	.007	**.024**	.040	.005	**.017**	.029	.004	**.013**	.021	.003	**.011**	.019	.003	**.010**	.017	.F..LE
.E..LD2	.007	**.025**	.045	.005	**.018**	.032	.004	**.013**	.024	.003	**.012**	.021	.003	**.011**	.019	.E..LD2
.E..LD	.009	**.026**	.046	.007	**.019**	.033	.005	**.014**	.024	.004	**.012**	.021	.004	**.011**	.020	.E..LD
.E..GP	.007	**.025**	.050	.005	**.018**	.036	.004	**.013**	.027	.003	**.012**	.023	.003	**.011**	.021	.E..GP
.E..GP2	.009	**.029**	.050	.007	**.021**	.036	.005	**.016**	.027	.004	**.014**	.023	.004	**.012**	.021	.E..GP2
.E..GB2	.013	**.033**	.053	.009	**.024**	.038	.007	**.018**	.028	.006	**.015**	.025	.006	**.014**	.023	.E..GB2
.S..GP2	.013	**.033**	.053	.009	**.024**	.038	.007	**.018**	.028	.006	**.015**	.025	.006	**.014**	.023	.S..GP2
.S..GB2	.013	**.033**	.053	.009	**.024**	.038	.007	**.018**	.028	.006	**.015**	.025	.006	**.014**	.023	.S..GB2
.S..GN	.013	**.033**	.053	.009	**.024**	.038	.007	**.018**	.028	.006	**.015**	.025	.006	**.014**	.023	.S..GN

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