Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining

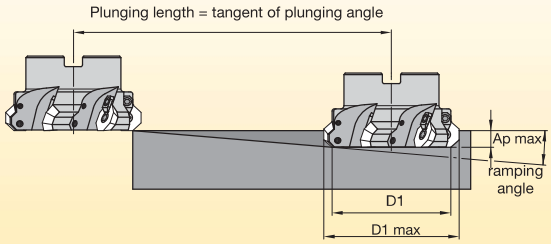
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LNJ	.007	**.027**	.048	.005	**.019**	.035	.004	**.015**	.026	.003	**.013**	.022	.003	**.012**	.021	.F..LNJ
.E..LB	.014	**.029**	.047	.010	**.021**	.034	.007	**.016**	.025	.006	**.014**	.022	.006	**.013**	.020	.E..LB
.S..LB	.014	**.029**	.053	.010	**.021**	.038	.007	**.016**	.028	.006	**.014**	.025	.006	**.012**	.022	.S..LB
.E..GB	.014	**.034**	.055	.010	**.025**	.039	.007	**.018**	.029	.006	**.016**	.026	.006	**.015**	.023	.E..GB
.S..HB	.014	**.034**	.059	.010	**.025**	.042	.007	**.018**	.031	.006	**.016**	.027	.006	**.015**	.025	.S..HB

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

Application • OF.T07L6

KSOM Application • OF.T07L6

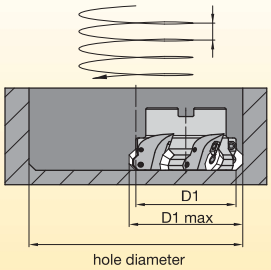
Ramping



Inch version

D1 inch	D1 max inch	Ap max inch	ramping angle (°)	ramping length inch
2.50	2.94	.46	5.5	4.78
3.00	3.44	.46	4.2	6.27
4.00	4.43	.46	2.9	9.09
5.00	5.43	.46	2.2	11.99
6.00	6.43	.46	1.8	14.65

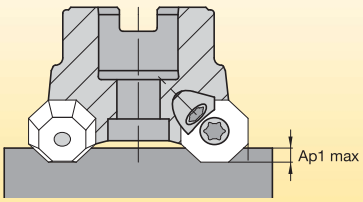
Helical Interpolation



Inch version

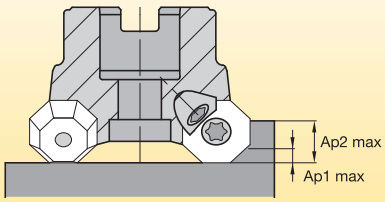
D1 inch	D1 max inch	hole diameter min inch	hole diameter max inch	Ap/Rev inch
2.50	2.94	4.872	5.748	.248
3.00	3.44	5.868	6.744	.248
4.00	4.43	7.863	8.739	.248
5.00	5.43	9.859	10.736	.248
6.00	6.43	11.857	12.733	.248

Plunging



max plunging depth	inch
Ap1 max	.17

Face Milling



max DOC Ap	inch	chipload (fz)
Ap1 max	.20	1 x fz
Ap2 max	.46	0,6 x fz