Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining

At .375 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LF	.004	**.007**	.013	.003	**.005**	.009	.002	**.004**	.008	.002	**.004**	.008	.002	**.004**	.008	.E..LF
.S..GF	.007	**.017**	.028	.005	**.013**	.020	.004	**.011**	.018	.004	**.010**	.016	.004	**.010**	.016	.S..GF
.S..HF	.007	**.017**	.028	.005	**.013**	.020	.004	**.011**	.018	.004	**.010**	.016	.004	**.010**	.016	.S..HF

At .188 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LF	.004	**.008**	.015	.003	**.006**	.011	.003	**.005**	.009	.003	**.005**	.009	.002	**.005**	.009	.E..LF
.S..GF	.008	**.020**	.032	.006	**.015**	.023	.005	**.013**	.020	.005	**.012**	.019	.005	**.012**	.018	.S..GF
.S..HF	.008	**.020**	.032	.006	**.015**	.023	.005	**.013**	.020	.005	**.012**	.019	.005	**.012**	.018	.S..HF

At .094 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LF	.005	**.010**	.019	.004	**.008**	.014	.004	**.007**	.012	.003	**.006**	.012	.003	**.006**	.011	.E..LF
.S..GF	.010	**.026**	.042	.008	**.019**	.031	.007	**.017**	.027	.006	**.015**	.025	.006	**.015**	.024	.S..GF
.S..HF	.010	**.026**	.042	.008	**.019**	.031	.007	**.017**	.027	.006	**.015**	.025	.006	**.015**	.024	.S..HF

At .047 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LF	.007	**.014**	.027	.005	**.011**	.020	.005	**.009**	.017	.004	**.009**	.016	.004	**.008**	.015	.E..LF
.S..GF	.014	**.036**	.059	.010	**.026**	.042	.009	**.023**	.036	.008	**.021**	.034	.008	**.021**	.033	.S..GF
.S..HF	.014	**.036**	.059	.010	**.026**	.042	.009	**.023**	.036	.008	**.021**	.034	.008	**.021**	.033	.S..HF

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