Recommended Starting Speeds [SFM]

Material Group		KYHS10			KYSM10			KYSP30			KYS30		
P	1	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–
	5	–	–	–	3960	**3200**	2380	3000	**2400**	1800	–	–	–
	6	–	–	–	3960	**3200**	2380	3000	**2400**	1800	–	–	–
M	1	–	–	–	3960	**3200**	2380	–	–	–	–	–	–
	2	–	–	–	3740	**3000**	–	–	–	–	–	–	–
	3	–	–	–	2760	**2400**	–	–	–	–	–	–	–
K	1	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–
N	1–2	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–
S	1	1680	**1320**	960	3490	**2860**	2220	2640	**2160**	1680	2640	**2160**	1680
	2	1680	**1320**	960	3490	**2860**	2220	2640	**2160**	1680	2640	**2160**	1680
	3	2400	**2040**	1680	5080	**4130**	3180	3840	**3120**	2400	3840	**3120**	2400
	4	–	–	–	–	–	–	–	–	–	–	–	–
H	1	1200	**1020**	780	–	–	–	–	–	–	–	–	–

NOTE: FIRST choice starting speeds are in **bold** type.
As the average chip thickness increases, the speed should be decreased.

Recommended Starting Feeds [IPT] • RPGN06..

Light Machining	General Purpose	Heavy Machining

At .125 Axial Depth of Cut (ap)

Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
..E	.005	**.005**	.006	.004	**.004**	.004	.003	**.003**	.004	.003	**.003**	.003	.003	**.003**	.003	..E

At .063 Axial Depth of Cut (ap)

Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
..E	.005	**.006**	.007	.004	**.004**	.005	.004	**.004**	.004	.003	**.004**	.004	.003	**.004**	.004	..E

At .031 Axial Depth of Cut (ap)

Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
..E	.007	**.008**	.009	.005	**.006**	.006	.005	**.005**	.006	.004	**.005**	.005	.004	**.005**	.005	..E

At .016 Axial Depth of Cut (ap)

Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
..E	.010	**.011**	.012	.007	**.008**	.009	.006	**.007**	.008	.006	**.007**	.007	.006	**.006**	.007	..E

NOTE: Use “Light Machining” values as starting feed rate.