Recommended Starting Speeds [m/min]

Material Group		KY4300			KY2100			KYS30		
P	1	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–
	5	–	–	–	–	–	–	–	–	–
	6	–	–	–	–	–	–	–	–	–
M	1	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–
K	1	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–
N	1–2	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–
S	1	510	**400**	295	1065	**870**	675	805	**660**	510
	2	510	**400**	295	1065	**870**	675	805	**660**	510
	3	730	**620**	510	1550	**1260**	970	1170	**950**	730
	4	–	–	–	–	–	–	–	–	–
H	1	365	**310**	240	–	–	–	–	–	–

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

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

At 6,35 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	0,09	**0,10**	0,11	0,07	**0,08**	0,09	0,06	**0,07**	0,07	0,06	**0,06**	0,07	0,06	**0,06**	0,07	..E
..T..	0,17	**0,26**	0,28	0,13	**0,19**	0,21	0,11	**0,17**	0,19	0,10	**0,16**	0,17	0,10	**0,16**	0,17	..T..

At 3,18 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	0,11	**0,12**	0,13	0,08	**0,09**	0,10	0,07	**0,08**	0,09	0,07	**0,07**	0,08	0,07	**0,07**	0,08	..E
..T..	0,20	**0,30**	0,33	0,15	**0,22**	0,25	0,13	**0,20**	0,21	0,12	**0,18**	0,20	0,12	**0,18**	0,20	..T..

At 1,59 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	0,14	**0,16**	0,17	0,11	**0,12**	0,13	0,09	**0,10**	0,11	0,09	**0,10**	0,10	0,09	**0,09**	0,10	..E
..T..	0,26	**0,39**	0,43	0,19	**0,29**	0,32	0,17	**0,26**	0,28	0,16	**0,24**	0,26	0,15	**0,23**	0,26	..T..

At 0,79 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	0,20	**0,21**	0,23	0,15	**0,16**	0,18	0,13	**0,14**	0,15	0,12	**0,13**	0,14	0,12	**0,13**	0,14	..E
..T..	0,35	**0,54**	0,59	0,26	**0,40**	0,44	0,23	**0,35**	0,38	0,21	**0,33**	0,36	0,21	**0,32**	0,35	..T..

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