Recommended Starting Speeds (sfm)

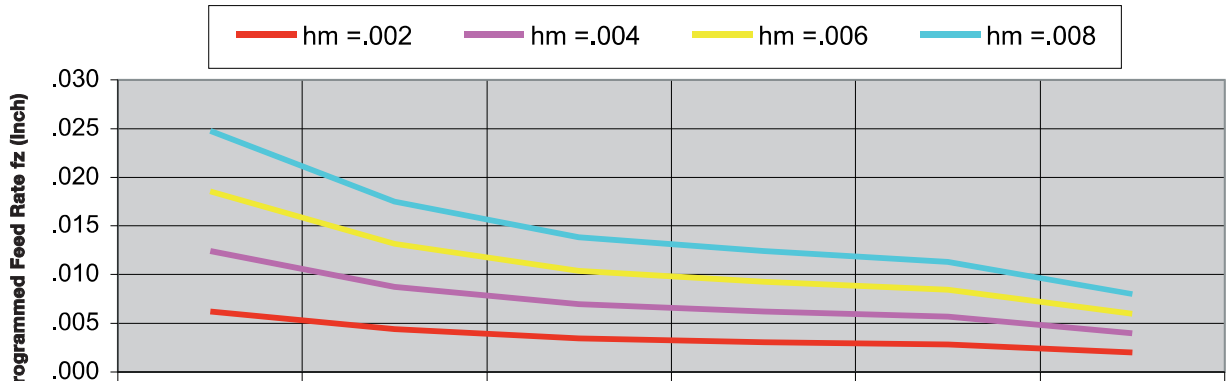
0° approach angle

Material Group	KC520M			KC715M			KC725M			KC735M			KC915M			KC935M		
P1				1120	**980**	910	860	**750**	700							1290	**1130**	1050
P2				690	**620**	560	530	**480**	430							800	**720**	650
P3				620	**560**	510	480	**430**	390							720	**650**	590
P4				470	**430**	390	360	**330**	300							540	**500**	450
P5				640	**570**	520	490	**440**	400							740	**660**	600
P6				390	**340**		300	**260**								450	**390**	
M1				730	**640**	590	560	**490**	450	340	**290**	270				840	**740**	680
M2							510	**460**	420	310	**280**	250				770	**690**	630
M3							380	**340**		230	**200**					570	**510**	
K1	880	**800**	710				540	**490**	440				1200	**1090**	970	840	**760**	680
K2	690	**620**	580				430	**380**	360				950	**850**	790	670	**600**	550
K3	580	**520**	470				360	**320**	290				800	**710**	650	560	**500**	460
N1																		
N2																		
S1							120	**100**										
S2							100	**100**										
S3							130	**130**										
S4							170	**150**										
H1																		

FIRST choice starting speeds are in bold type.
As the average chip thickness goes higher the speed should be decreased.

Recommended Starting Feeds

0° Approach Angle Feed-Per-Tooth Compensation
(Radial Width-of-Cut Dependent)



	10%	20%	30%	40%	50%	100%
hm =.002	.006	.004	.003	.003	.003	.002
hm =.004	.012	.009	.007	.006	.006	.004
hm =.006	.019	.013	.010	.009	.008	.006
hm =.008	.025	.018	.014	.012	.011	.008

Percentage of the Cutter Diameter in Cut