

■ Recommended Starting Speeds [m/min]

Material Group		TN2505			TN6525			TN6540		
P	1	–	–	–	410	320	280	360	280	240
	2	–	–	–	320	250	215	250	190	170
	3	–	–	–	280	215	185	215	170	140
	4	–	–	–	235	170	145	180	130	110
	5	–	–	–	310	235	200	240	180	150
	6	–	–	–	205	160	130	160	120	100
M	1	–	–	–	190	120	80	130	80	60
	2	–	–	–	120	80	50	80	50	40
	3	–	–	–	125	80	55	85	50	40
K	1	400	300	250	275	245	220	220	205	180
	2	540	365	280	215	190	180	175	155	140
	3	310	190	155	180	160	145	155	145	125
N	1	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–
S	1	–	–	–	–	–	–	50	35	30
	2	–	–	–	–	–	–	25	20	10
	3	–	–	–	–	–	–	70	40	30
	4	–	–	–	–	–	–	60	30	25
H	1	175	140	95	–	–	–	–	–	–
	2	175	140	95	–	–	–	–	–	–
	3	140	115	80	–	–	–	–	–	–

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



Recommended Starting Feeds

■ Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining
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At 3,50 Axial Depth of Cut (ap)

Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
MH	0,23	0,46	0,74	0,17	0,33	0,54	0,13	0,25	0,40	0,11	0,22	0,35	0,10	0,20	0,32	MH

At 1,50 Axial Depth of Cut (ap)

Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
MH	0,28	0,56	0,91	0,20	0,41	0,65	0,15	0,31	0,49	0,13	0,27	0,43	0,12	0,24	0,39	MH

At 0,75 Axial Depth of Cut (ap)

Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
MH	0,37	0,75	1,21	0,27	0,54	0,87	0,20	0,40	0,65	0,18	0,35	0,56	0,16	0,32	0,52	MH

At 0,50 Axial Depth of Cut (ap)

Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
MH	0,45	0,91	1,47	0,32	0,65	1,05	0,24	0,49	0,78	0,21	0,42	0,68	0,19	0,39	0,62	MH

NOTE: Use "Light Machining" value as starting feed rate.