

■ Recommended Starting Speeds [m/min]

Material Group		TN2505			TN6525			TN6540		
P	1	550	420	360	410	320	280	360	280	240
	2	320	240	205	320	250	215	250	190	170
	3	320	240	205	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 8,00 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%			
MM	0,39	0,52	0,82	0,28	0,37	0,59	0,21	0,28	0,44	0,18	0,24	0,38	0,17	0,22	0,35	MM
MH	0,51	0,70	1,17	0,37	0,50	0,84	0,28	0,38	0,63	0,24	0,33	0,55	0,22	0,30	0,50	MH

At 4,00 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%			
MM	0,45	0,60	0,94	0,32	0,43	0,68	0,24	0,32	0,51	0,21	0,28	0,44	0,19	0,26	0,40	MM
MH	0,59	0,81	1,36	0,43	0,58	0,97	0,32	0,43	0,72	0,28	0,38	0,63	0,25	0,35	0,58	MH

At 2,00 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%			
MM	0,59	0,79	1,24	0,43	0,57	0,89	0,32	0,42	0,66	0,28	0,37	0,58	0,25	0,34	0,53	MM
MH	0,77	1,06	1,79	0,56	0,76	1,28	0,42	0,57	0,95	0,36	0,50	0,83	0,33	0,45	0,76	MH

At 1,00 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%			
MM	0,81	1,08	1,71	0,58	0,78	1,22	0,43	0,58	0,91	0,38	0,51	0,79	0,35	0,46	0,72	MM
MH	1,06	1,46	2,48	0,76	1,04	1,75	0,57	0,78	1,30	0,50	0,68	1,13	0,45	0,62	1,03	MH

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