

■ Recommended Starting Speeds [SFM]

Material Group	WK15CM			WP25PM			WU35PM			WP35CM			WP40PM			
P	1	-	-	-	1295	1120	1060	1025	905	845	1790	1555	1460	1165	1025	965
	2	-	-	-	1080	940	785	865	750	630	1105	1000	905	985	845	710
	3	-	-	-	1000	845	690	785	670	550	1000	905	805	905	770	630
	4	-	-	-	890	725	590	710	590	475	750	690	630	805	670	535
	5	-	-	-	725	670	590	590	535	475	1025	905	830	670	610	535
	6	-	-	-	650	490	395	510	395	310	630	535	430	590	450	355
M	1	-	-	-	805	710	650	670	590	535	805	725	610	770	670	610
	2	-	-	-	725	630	510	610	510	430	725	630	550	690	590	490
	3	-	-	-	550	475	370	450	395	310	570	510	450	510	450	355
K	1	1655	1520	1340	905	805	725	-	-	-	1165	1045	940	-	-	-
	2	1320	1165	1080	710	630	590	-	-	-	925	830	750	-	-	-
	3	1105	985	905	590	535	475	-	-	-	770	690	630	-	-	-
N	1	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	1	-	-	-	155	140	95	140	120	95	-	-	-	155	140	120
	2	-	-	-	155	140	95	140	120	95	-	-	-	155	140	120
	3	-	-	-	200	155	95	180	140	95	-	-	-	200	155	120
	4	-	-	-	275	200	140	235	180	120	260	200	130	260	200	140
H	1	-	-	-	475	355	275	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

Indexable Milling

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 [IPT]

Light Machining	General Purpose	Heavy Machining
-----------------	-----------------	-----------------

At .370 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..ML	.003	.009	.016	.003	.007	.012	.002	.006	.010	.002	.006	.010	.002	.005	.009	.E..ML
.S..MM	.007	.015	.027	.005	.011	.020	.005	.010	.017	.004	.009	.016	.004	.009	.016	.S..MM

At .188 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..ML	.004	.011	.020	.003	.008	.015	.003	.007	.013	.003	.007	.012	.003	.007	.012	.E..ML
.S..MM	.009	.019	.034	.006	.014	.025	.006	.012	.021	.005	.011	.020	.005	.011	.020	.S..MM

At .094 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..ML	.006	.015	.027	.004	.011	.020	.004	.010	.017	.004	.009	.016	.003	.009	.016	.E..ML
.S..MM	.012	.025	.046	.009	.018	.033	.007	.016	.029	.007	.015	.027	.007	.015	.026	.S..MM

At .047 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..ML	.008	.021	.037	.006	.016	.027	.005	.014	.023	.005	.013	.022	.005	.012	.021	.E..ML
.S..MM	.016	.035	.065	.012	.025	.046	.010	.022	.040	.010	.020	.037	.009	.020	.036	.S..MM

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