

■ Recommended Starting Speeds [SFM]

Face Mills

Material Group		TN6525			TN6540			TN7525			TN7535		
P	1	1340	1045	925	1180	925	785	1340	1025	925	1790	1555	1460
	2	1045	830	710	830	630	550	1025	830	710	1105	1000	905
	3	925	710	610	710	550	450	925	710	610	1000	905	805
	4	770	550	475	590	430	355	770	550	475	750	690	630
	5	1025	770	650	785	590	490	1025	770	650	1025	905	830
	6	670	535	430	535	395	335	670	535	430	630	535	430
M	1	630	395	260	430	260	200	805	725	610	805	725	610
	2	395	260	155	260	155	140	725	630	550	725	630	550
	3	415	260	180	275	155	140	570	510	450	570	510	450
K	1	905	805	725	725	670	590	1240	925	785	1165	1045	940
	2	710	630	590	570	510	450	1060	785	650	925	830	750
	3	590	535	475	510	475	415	785	650	550	770	690	630
N	1	-	-	-	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-
S	1	-	-	-	155	120	95	-	-	-	-	-	-
	2	-	-	-	80	60	40	-	-	-	-	-	-
	3	-	-	-	235	140	95	-	-	-	-	-	-
	4	-	-	-	200	95	80	-	-	-	-	-	-
H	1	-	-	-	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-

(continued)

(Recommended Starting Speeds [SFM] – continued)

Material Group		WK15CM			WP40PM			TTI25			THM		
P	1	-	-	-	1165	1025	965	1415	1180	985	-	-	-
	2	-	-	-	985	845	710	1025	830	710	-	-	-
	3	-	-	-	905	770	630	1025	830	710	-	-	-
	4	-	-	-	805	670	535	865	710	590	-	-	-
	5	-	-	-	670	610	535	1045	770	650	-	-	-
	6	-	-	-	590	450	355	475	355	295	-	-	-
M	1	-	-	-	770	670	610	1570	1025	710	-	-	-
	2	-	-	-	690	590	490	1060	670	475	-	-	-
	3	-	-	-	510	450	355	1045	690	475	-	-	-
K	1	1655	1520	1340	-	-	-	725	610	510	475	355	295
	2	1320	1165	1080	-	-	-	590	475	415	490	395	275
	3	1105	985	905	-	-	-	475	415	335	510	370	235
N	1	-	-	-	-	-	-	-	-	-	3540	2365	1970
	2	-	-	-	-	-	-	-	-	-	2695	1830	1520
	3	-	-	-	-	-	-	-	-	-	1770	1105	785
S	1	-	-	-	155	140	120	-	-	-	-	-	-
	2	-	-	-	155	140	120	-	-	-	-	-	-
	3	-	-	-	200	155	120	-	-	-	-	-	-
	4	-	-	-	260	200	140	-	-	-	-	-	-
H	1	-	-	-	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-

Face Mills

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
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Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry
	5%			10%			20%			30%			40-100%			
...20	.007	.026	.047	.005	.018	.033	.004	.014	.025	.003	.012	.022	.003	.011	.020	...20
...21	.010	.029	.049	.007	.021	.035	.005	.016	.026	.005	.014	.023	.004	.013	.021	...21
...31	.010	.030	.050	.007	.022	.036	.006	.016	.027	.005	.014	.023	.004	.013	.021	...31

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