

■ Recommended Starting Speeds [m/min]

Material Group		THM			TTM/TTM08		
P	1	-	-	-	560	490	460
	2	-	-	-	345	280	245
	3	-	-	-	345	280	245
	4	-	-	-	280	195	180
	5	-	-	-	360	280	260
	6	-	-	-	165	130	115
M	1	-	-	-	330	195	130
	2	-	-	-	195	115	80
	3	-	-	-	215	130	100
K	1	395	295	245	-	-	-
	2	410	330	230	-	-	-
	3	425	310	195	-	-	-
N	1	2950	1970	1640	-	-	-
	2	2245	1525	1265	-	-	-
	3	1475	920	655	-	-	-
S	1	-	-	-	-	-	-
	2	-	-	-	-	-	-
	3	-	-	-	-	-	-
	4	-	-	-	-	-	-
H	1	-	-	-	-	-	-
	2	-	-	-	-	-	-
	3	-	-	-	-	-	-

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

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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%			
TCAX/TNAX	0,12	0,29	0,45	0,08	0,21	0,33	0,06	0,16	0,25	0,06	0,14	0,21	0,05	0,13	0,20	TCAX/TNAX

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