

■ Recommended Starting Feeds [IPT] • High-Feed

Light Machining	General Purpose	Heavy Machining
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At .100 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)														Insert Geometry	
	5%			10%			20%			30%			40–100%			
.E..D721	.011	.041	.066	.008	.029	.047	.006	.022	.035	.005	.019	.030	.005	.017	.028	.E..D721
.E..D41	.014	.046	.072	.010	.033	.051	.008	.024	.038	.007	.021	.033	.006	.019	.030	.E..D41
.E..D411	.014	.046	.072	.010	.033	.051	.008	.024	.038	.007	.021	.033	.006	.019	.030	.E..D411
.S..GP	.020	.051	.077	.015	.036	.055	.011	.027	.041	.009	.024	.035	.009	.022	.032	.S..GP
.S..D	.020	.051	.077	.015	.036	.055	.011	.027	.041	.009	.024	.036	.009	.022	.032	.S..D

At .070 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..D721	.013	.048	.078	.010	.035	.056	.007	.026	.041	.006	.022	.036	.006	.021	.033	.E..D721
.E..D41	.017	.054	.086	.012	.039	.061	.009	.029	.045	.008	.025	.039	.007	.023	.036	.E..D41
.E..D411	.017	.054	.086	.012	.039	.061	.009	.029	.045	.008	.025	.039	.007	.023	.036	.E..D411
.S..GP	.024	.061	.092	.017	.043	.065	.013	.032	.048	.011	.028	.042	.010	.026	.038	.S..GP
.S..D	.024	.061	.092	.017	.043	.065	.013	.032	.048	.011	.028	.042	.010	.026	.038	.S..D

At .055 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)														Insert Geometry	
	5%			10%			20%			30%			40–100%			
.E..D721	.015	.054	.088	.011	.039	.063	.008	.029	.046	.007	.025	.040	.007	.023	.037	.E..D721
.E..D41	.019	.061	.097	.014	.044	.069	.010	.033	.051	.009	.028	.044	.008	.026	.040	.E..D41
.E..D411	.019	.061	.097	.014	.044	.069	.010	.033	.051	.009	.028	.044	.008	.026	.040	.E..D411
.S..GP	.027	.068	.104	.019	.049	.073	.014	.036	.054	.013	.031	.047	.012	.029	.043	.S..GP
.S..D	.027	.068	.104	.019	.049	.074	.014	.036	.054	.013	.031	.047	.012	.029	.043	.S..D

■ Feed Rate Guide • Plunging • IC 12 • fz [in/tooth]

Insert Geometry	Programmed Feed per Tooth (fz)			Insert Geometry
	Max .354" insert engagement (ae radial engagement)			
.E..D721	.002	.008	.013	.E..D721
.E..D41	.003	.009	.014	.E..D41
.E..D411	.003	.009	.014	.E..D411
.S..GP	.004	.010	.015	.S..GP
.S..D	.004	.010	.015	.S..D



NOTE: For further details about using the 7792VX series in plunging operations, please see page V30.

Use "Light Machining" values as starting feed rate

Please see pages X22-X37 for recommended starting speeds.