

Recommended Starting Speeds (sfm)

FIX-PERFECT — Cast Iron

MDHX 1004 inserts

Material Group	K110M			KC520M			KT530M		
P1									
P2									
P3									
P4									
P5									
P6									
M1									
M2									
M3									
K1	1200	900	600	880	800	710			
K2	850	750	650	690	620	580	1500	1200	1000
K3	650	500	400	580	520	470	1000	900	800
N1									
N2									
S1									
S2									
S3									
S4									
H1									

FIRST choice starting speeds are in bold type.

As the average chip thickness goes higher the speed should be decreased.

Recommended Starting Feeds

15° Approach Angle Feed-Per-Tooth Compensation
(Radial Width-of-Cut Dependent)

