Recommended Starting Speeds [m/min]

Material Group	KYSP30 (up to HRC 48)	KYSM10 (up to HRC 35)	KYHS10 (up to HRC 62)
P1			
P2			
P3			
P4			
P5	725	975	
P6	725	975	
M1		975	
M2		915	
M3		725	
K1			
K2			
K3			
N1			
N2			
S1	900	2125	
S2	1225	1700	800
S3	1225	1700	800
S4			
H1			300

Recommended Feed Data • Nickel and Cobalt Alloys

insert	Ap max	recommended starting values		
		Ap	fz	ae
RPGN060200E	1,5	1,0	0,05	65%
RPGN090300E	2,5	1,5	0,08	65%
RPGN120400E	3,0	2,0	0,10	65%

Recommended Feed Data • Hard Machining

insert	Ap max	recommended starting values		
		Ap	fz	ae
RPGN060200E	1,0	0,75	0,10	55%
RPGN090300E	1,5	1,00	0,10	55%
RPGN120400E	2,0	1,30	0,12	55%

Note:

A – Use these tools with the appropriate equipment/machines. Machines have to be covered for safety reasons: Hot flowing chips and loud noise are involved, which is common during the milling process.

B – Use only air flow as coolant method.

C – Higher RPMs are involved; use balanced toolholder for higher tool life and safer operation.

D – Consider increasing the fz in hard machining when smaller Ap are applied.

Recommended Starting Speeds [SFM]

Material Group	KYSP30 (up to HRC 48)	KYSM10 (up to HRC 35)	KYHS10 (up to HRC 62)
P1			
P2			
P3			
P4			
P5	2400	3200	
P6	2400	3200	
M1		3200	
M2		3000	
M3		2400	
K1			
K2			
K3			
N1			
N2			
S1	3000	7000	
S2	4000	5600	2600
S3	4000	5600	2600
S4			
H1			1000

Recommended Feed Data • Nickel and Cobalt Alloys

insert	Ap max	recommended starting values		
		Ap	fz	ae
RPG2150E	0.059	0.039	0.002	65%
RPG32E	0.098	0.059	0.003	65%
RPG43E	0.118	0.079	0.004	65%

Recommended Feed Data • Hard Machining

insert	Ap max	recommended starting values		
		Ap	fz	ae
RPG2150E	0.039	0.030	0.004	55%
RPG32E	0.059	0.039	0.004	55%
RPG43E	0.079	0.051	0.005	55%

Note:

A – Use these tools with the appropriate equipment/machines. Machines have to be covered for safety reasons: Hot flowing chips and loud noise are involved, which is common during the milling process.

B – Use only air flow as coolant method.

C – Higher RPMs are involved; use balanced toolholder for higher tool life and safer operation.

D – Consider increasing the fz in hard machining when smaller Ap are applied.