

Recommended Starting Speeds (sfm)

KenFeed Inserts - Inch

Material Group	KC522M			KC525M		
	see chart for feed per tooth			see chart for feed per tooth		
P1	820	750	690	720	660	590
P2	690	660	620	590	520	490
P3	620	590	560	520	490	460
P4	560	520	490	460	430	390
P5	590	560	520	490	460	430
P6	520	490	460	430	390	360
M1	720	690	660	490	460	430
M2	620	560	490	430	390	360
M3	430	390	360	300	260	230
K1						
K2						
K3						
N1						
N2						
S1	200	200	160	200	180	160
S2	200	200	160	200	180	160
S3	160	130	130	160	150	130
S4		200				200
H1	520	390	260			

FIRST choice starting speeds are in bold type.
As the average chip thickness goes higher the speed should be decreased.

Recommended Starting Feeds

End Mills

cutter Dia	order number	insert size	feed p/tooth fz	Max Ap	Max ramp angle
1.500	2509390	WP - - 06X4	.020 - .060	0.059	5.0°
1.500	2509391	WP - - 06X4	.020 - .060	0.059	5.0°
1.500	2509392	WP - - 06X4	.020 - .060	0.059	5.0°

Helical Ramping from Solid

cutter Dia	Min hole Dia	Max hole Dia	Max axial depth	Max ramp angle
1.500	2.480	2.890	0.059	5.0°
1.500	2.480	2.890	0.059	5.0°
1.500	2.480	2.890	0.059	5.0°
2.000	2.830	3.890	0.059	4.0°
2.500	3.840	4.890	0.059	2.0°
3.000	5.050	5.890	0.059	1.0°

Shell Mills

cutter Dia	order number	insert size	feed p/tooth fz	Max Ap	Max ramp angle
2.000	2509403	WP - - 0806	.020 - .060	0.059	4.0°
2.500	2509404	WP - - 0806	.020 - .060	0.059	2.0°
3.000	2509405	WP - - 0806	.020 - .060	0.059	1.0°

Starting Axial Depth of Cut

cutter Dia	insert size	feed p/tooth fz	starting Ap
1.500	WP - - 06X4	.020 - .060	0.040
2.000	WP - - 0806	.020 - .060	0.040
2.500	WP - - 0806	.020 - .060	0.040
3.000	WP - - 0806	.020 - .060	0.040