Recommended Starting Speeds [SFM]

Material Group		KC422M			KC510M			KCK15			KC520M			KCPM20		
P	1	–	–	–	–	–	–	–	–	–	–	–	–	2170	**1910**	1760
	2	–	–	–	–	–	–	–	–	–	–	–	–	1340	**1210**	1090
	3	–	–	–	–	–	–	–	–	–	–	–	–	1210	**1090**	1000
	4	–	–	–	960	**780**	660	–	–	–	–	–	–	910	**840**	760
	5	–	–	–	–	–	–	–	–	–	–	–	–	1090	**980**	900
	6	–	–	–	–	–	–	–	–	–	–	–	–	760	**660**	570
M	1	–	–	–	–	–	–	–	–	–	–	–	–	880	**790**	680
	2	–	–	–	–	–	–	–	–	–	–	–	–	800	**700**	620
	3	–	–	–	–	–	–	–	–	–	–	–	–	640	**570**	490
K	1	–	–	–	1150	**1040**	940	1660	**1510**	1340	1060	**960**	850	1420	**1280**	1150
	2	–	–	–	910	**820**	760	1310	**1170**	1090	830	**740**	700	1130	**1010**	920
	3	–	–	–	770	**680**	620	1100	**980**	900	700	**620**	560	950	**840**	780
N	1	4220	**3720**	3440	2520	**2240**	2060	–	–	–	–	–	–	–	–	–
	2	3720	**3440**	3000	2280	**2100**	1920	–	–	–	–	–	–	–	–	–
S	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
H	1	–	–	–	630	**510**	360	–	–	–	–	–	–	550	**460**	370
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

Material Group		KC522M			KC725M			KCMP30			KCPK30		
P	1	1300	**1130**	1060	1030	**900**	840	1780	**1560**	1450	1780	**1560**	1450
	2	1080	**950**	790	860	**760**	640	1100	**1000**	900	1100	**1000**	900
	3	1000	**840**	700	790	**670**	550	1000	**900**	820	1000	**900**	820
	4	890	**730**	590	710	**590**	470	740	**690**	620	740	**690**	620
	5	730	**660**	590	590	**530**	470	1020	**910**	830	1020	**910**	830
	6	650	**490**	400	520	**400**	310	620	**540**	–	620	**540**	–
M	1	800	**710**	650	670	**590**	540	820	**720**	620	820	**720**	620
	2	730	**620**	520	610	**520**	430	730	**640**	550	730	**640**	550
	3	550	**480**	370	460	**400**	310	570	**520**	460	570	**520**	460
K	1	900	**820**	720	–	–	–	–	–	–	1160	**1050**	940
	2	710	**640**	590	–	–	–	–	–	–	920	**830**	760
	3	590	**530**	480	–	–	–	–	–	–	770	**690**	640
N	1	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–
S	1	160	**140**	110	140	**120**	100	140	**120**	100	–	–	–
	2	160	**140**	110	140	**120**	100	140	**120**	100	–	–	–
	3	200	**160**	110	180	**140**	100	180	**140**	100	–	–	–
	4	280	**200**	140	240	**180**	120	240	**180**	120	–	–	–
H	1	470	**360**	280	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–

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

Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining

At .197 Axial Depth of Cut (ap)

Insert Geometry	Programmed feed per tooth (fz) as a % of radial depth of cut (ae) of working diameter (dw)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.F..LDJ	.004	**.011**	.011	.003	**.008**	.008	.002	**.007**	.007	.002	**.007**	.007	.002	**.007**	.006	.F..LDJ
.E..LDJ	.004	**.011**	.015	.003	**.008**	.011	.002	**.007**	.010	.002	**.007**	.009	.002	**.007**	.009	.E..LDJ
.E..LD	.004	**.011**	.023	.003	**.008**	.017	.002	**.007**	.015	.002	**.007**	.014	.002	**.007**	.014	.E..LD
.S..GDJ	.008	**.017**	.026	.006	**.012**	.019	.005	**.011**	.017	.005	**.010**	.016	.005	**.010**	.015	.S..GDJ
.S..GD	.008	**.017**	.026	.006	**.012**	.019	.005	**.011**	.017	.005	**.010**	.016	.005	**.010**	.015	.S..GD
.S..HD	.013	**.017**	.028	.010	**.012**	.021	.009	**.011**	.018	.008	**.010**	.017	.008	**.010**	.017	.S..HD

Indexable Milling

At .098 Axial Depth of Cut (ap)

Insert Geometry	Programmed feed per tooth (fz) as a % of radial depth of cut (ae) of working diameter (dw)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.F..LDJ	.004	**.013**	.012	.003	**.010**	.009	.003	**.009**	.008	.003	**.008**	.008	.002	**.008**	.007	.F..LDJ
.E..LDJ	.004	**.013**	.018	.003	**.010**	.013	.003	**.009**	.011	.003	**.008**	.011	.002	**.008**	.010	.E..LDJ
.E..LD	.004	**.013**	.027	.003	**.010**	.020	.003	**.009**	.017	.003	**.008**	.016	.002	**.008**	.016	.E..LD
.S..GDJ	.009	**.019**	.030	.007	**.014**	.022	.006	**.012**	.019	.006	**.012**	.018	.006	**.011**	.018	.S..GDJ
.S..GD	.009	**.019**	.030	.007	**.014**	.022	.006	**.012**	.019	.006	**.012**	.018	.006	**.011**	.018	.S..GD
.S..HD	.015	**.019**	.033	.011	**.014**	.024	.010	**.012**	.021	.009	**.012**	.020	.009	**.011**	.019	.S..HD

At .049 Axial Depth of Cut (ap)

Insert Geometry	Programmed feed per tooth (fz) as a % of radial depth of cut (ae) of working diameter (dw)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.F..LDJ	.005	**.017**	.016	.004	**.013**	.012	.004	**.011**	.011	.003	**.010**	.010	.003	**.010**	.010	.F..LDJ
.E..LDJ	.005	**.017**	.023	.004	**.013**	.017	.004	**.011**	.015	.003	**.010**	.014	.003	**.010**	.014	.E..LDJ
.E..LD	.005	**.017**	.035	.004	**.013**	.026	.004	**.011**	.022	.003	**.010**	.021	.003	**.010**	.020	.E..LD
.S..GDJ	.012	**.026**	.040	.009	**.019**	.029	.008	**.016**	.025	.007	**.015**	.024	.007	**.015**	.023	.S..GDJ
.S..GD	.012	**.026**	.040	.009	**.019**	.029	.008	**.016**	.025	.007	**.015**	.024	.007	**.015**	.023	.S..GD
.S..HD	.020	**.026**	.044	.015	**.019**	.032	.013	**.016**	.027	.012	**.015**	.026	.012	**.015**	.025	.S..HD

At .025 Axial Depth of Cut (ap)

Insert Geometry	Programmed feed per tooth (fz) as a % of radial depth of cut (ae) of working diameter (dw)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.F..LDJ	.007	**.024**	.023	.005	**.018**	.017	.005	**.015**	.014	.004	**.014**	.013	.004	**.014**	.013	.F..LDJ
.E..LDJ	.007	**.024**	.032	.005	**.018**	.023	.005	**.015**	.020	.004	**.014**	.019	.004	**.014**	.019	.E..LDJ
.E..LD	.007	**.024**	.049	.005	**.018**	.035	.005	**.015**	.031	.004	**.014**	.028	.004	**.014**	.028	.E..LD
.S..GDJ	.017	**.035**	.056	.012	**.026**	.040	.011	**.022**	.035	.010	**.021**	.032	.010	**.020**	.032	.S..GDJ
.S..GD	.017	**.035**	.056	.012	**.026**	.040	.011	**.022**	.035	.010	**.021**	.032	.010	**.020**	.032	.S..GD
.S..HD	.028	**.035**	.061	.021	**.026**	.044	.018	**.022**	.038	.017	**.021**	.035	.016	**.020**	.034	.S..HD

NOTE: Use “Light Machining” values as starting feed rate.