Recommended Starting Speeds [SFM]

Material Group		KC422M			KC510M			KCK15			KC520M			KCPM20			KC522M			KC725M			KCPK30		
P	1	–	–	–	–	–	–	–	–	–	–	–	–	2170	**1910**	1760	1300	**1130**	1060	1030	**900**	840	1780	**1560**	1450
	2	–	–	–	–	–	–	–	–	–	–	–	–	1340	**1210**	1090	1080	**950**	790	860	**760**	640	1100	**1000**	900
	3	–	–	–	–	–	–	–	–	–	–	–	–	1210	**1090**	1000	1000	**840**	700	790	**670**	550	1000	**900**	820
	4	–	–	–	960	**780**	660	–	–	–	–	–	–	910	**840**	760	890	**730**	590	710	**590**	470	740	**690**	620
	5	–	–	–	–	–	–	–	–	–	–	–	–	1090	**980**	900	730	**660**	590	590	**530**	470	1020	**910**	830
	6	–	–	–	–	–	–	–	–	–	–	–	–	760	**660**	570	650	**490**	400	520	**400**	310	620	**540**	0
M	1	–	–	–	–	–	–	–	–	–	–	–	–	880	**790**	680	800	**710**	650	670	**590**	540	820	**720**	620
	2	–	–	–	–	–	–	–	–	–	–	–	–	800	**700**	620	730	**620**	520	610	**520**	430	730	**640**	550
	3	–	–	–	–	–	–	–	–	–	–	–	–	640	**570**	490	550	**480**	370	460	**400**	310	570	**520**	460
K	1	–	–	–	1150	**1040**	940	1660	**1510**	1340	1060	**960**	850	1420	**1280**	1150	900	**820**	720	–	–	–	1160	**1050**	940
	2	–	–	–	910	**820**	760	1310	**1170**	1090	830	**740**	700	1130	**1010**	920	710	**640**	590	–	–	–	920	**830**	760
	3	–	–	–	770	**680**	620	1100	**980**	900	700	**620**	560	950	**840**	780	590	**530**	480	–	–	–	770	**690**	640
N	1	4220	**3720**	3440	2520	**2240**	2060	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	3720	**3440**	3000	2280	**2100**	1920	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
S	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	160	**140**	110	140	**120**	100	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	160	**140**	110	140	**120**	100	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	200	**160**	110	180	**140**	100	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	280	**200**	140	240	**180**	120	–	–	–
H	1	–	–	–	630	**510**	360	–	–	–	–	–	–	550	**460**	370	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.

Indexable Milling

Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining

At .236 Axial Depth of Cut (ap)

Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.F..LDJ	.004	**.006**	.011	.003	**.005**	.008	.002	**.004**	.007	.002	**.004**	.006	.002	**.004**	.006	.F..LDJ
.E..LD	.004	**.006**	.011	.003	**.005**	.008	.002	**.004**	.007	.002	**.004**	.006	.002	**.004**	.006	.E..LD
.S..GD	.008	**.014**	.024	.006	**.010**	.018	.005	**.009**	.016	.005	**.008**	.015	.005	**.008**	.014	.S..GD
.S..HD	.013	**.020**	.031	.010	**.015**	.022	.009	**.013**	.019	.008	**.012**	.018	.008	**.012**	.018	.S..HD

At .118 Axial Depth of Cut (ap)

Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.F..LDJ	.004	**.007**	.012	.003	**.005**	.009	.003	**.005**	.008	.003	**.004**	.007	.002	**.004**	.007	.F..LDJ
.E..LD	.004	**.007**	.012	.003	**.005**	.009	.003	**.005**	.008	.003	**.004**	.007	.002	**.004**	.007	.E..LD
.S..GD	.009	**.016**	.028	.007	**.012**	.021	.006	**.010**	.018	.006	**.010**	.017	.006	**.009**	.016	.S..GD
.S..HD	.015	**.023**	.035	.011	**.017**	.026	.010	**.015**	.022	.009	**.014**	.021	.009	**.014**	.020	.S..HD

At .059 Axial Depth of Cut (ap)

Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.F..LDJ	.005	**.009**	.016	.004	**.007**	.012	.004	**.006**	.010	.003	**.006**	.010	.003	**.005**	.010	.F..LDJ
.E..LD	.005	**.009**	.016	.004	**.007**	.012	.004	**.006**	.010	.003	**.006**	.010	.003	**.005**	.010	.E..LD
.S..GD	.012	**.021**	.038	.009	**.016**	.027	.008	**.013**	.024	.007	**.013**	.022	.007	**.012**	.022	.S..GD
.S..HD	.020	**.031**	.047	.015	**.023**	.034	.013	**.020**	.029	.012	**.018**	.027	.012	**.018**	.027	.S..HD

At .030 Axial Depth of Cut (ap)

Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.F..LDJ	.007	**.013**	.022	.005	**.009**	.016	.005	**.008**	.014	.004	**.008**	.013	.004	**.007**	.013	.F..LDJ
.E..LD	.007	**.013**	.022	.005	**.009**	.016	.005	**.008**	.014	.004	**.008**	.013	.004	**.007**	.013	.E..LD
.S..GD	.017	**.029**	.052	.012	**.021**	.038	.011	**.018**	.032	.010	**.017**	.030	.010	**.017**	.029	.S..GD
.S..HD	.028	**.043**	.066	.021	**.031**	.047	.018	**.027**	.040	.017	**.025**	.037	.016	**.024**	.037	.S..HD

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