

■ Recommended Starting Speeds [SFM]

Material Group	KCK15	KC520M	KCPM20	KC522M	KC725M	KCMP30	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	— — —	— — —	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	1660 1510 1340	1060 960 850	1420 1280 1150	900 820 720	— — —	— — —
	2	1310 1170 1090	830 740 700	1130 1010 920	710 640 590	— — —	— — —
	3	1100 980 900	700 620 560	950 840 780	590 530 480	— — —	— — —
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	— — —	— — —	550 460 370	470 360 280	— — —	— — —
	2	— — —	— — —	— — —	— — —	— — —	— — —
	3	— — —	— — —	— — —	— — —	— — —	— — —

Indexable Milling

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
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At .315 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%			
.E.LDJ	.004	.011	.015	.003	.008	.011	.002	.007	.010	.002	.007	.009	.002	.007	.009	.E.LDJ
.S.GD	.008	.020	.023	.006	.015	.017	.005	.013	.015	.005	.012	.014	.005	.012	.014	.S.GD
.S.HD	.015	.020	.031	.011	.015	.022	.010	.013	.019	.009	.012	.018	.009	.012	.018	.S.HD

At .157 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%			
.E.LDJ	.004	.013	.018	.003	.010	.013	.003	.009	.011	.003	.008	.011	.002	.008	.010	.E.LDJ
.S.GD	.009	.023	.027	.007	.017	.020	.006	.015	.017	.006	.014	.016	.006	.014	.016	.S.GD
.S.HD	.018	.023	.035	.013	.017	.026	.011	.015	.022	.011	.014	.021	.010	.014	.020	.S.HD

At .079 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%			
.E.LDJ	.005	.017	.023	.004	.013	.017	.004	.011	.015	.003	.010	.014	.003	.010	.014	.E.LDJ
.S.GD	.012	.031	.036	.009	.023	.026	.008	.020	.023	.007	.018	.021	.007	.018	.021	.S.GD
.S.HD	.023	.031	.047	.017	.023	.034	.015	.020	.029	.014	.018	.027	.014	.018	.027	.S.HD

At .039 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%			
.E.LDJ	.007	.024	.032	.005	.018	.023	.005	.015	.020	.004	.014	.019	.004	.014	.019	.E.LDJ
.S.GD	.017	.043	.050	.012	.031	.036	.011	.027	.031	.010	.025	.029	.010	.024	.028	.S.GD
.S.HD	.032	.043	.066	.024	.031	.047	.020	.027	.040	.019	.025	.037	.019	.024	.037	.S.HD

NOTE: Use "Light Machining" values as starting feed rate.