

■ Recommended Starting Speeds [SFM]

Material Group		KC725M		
P	1	—	—	—
	2	—	—	—
	3	—	—	—
	4	—	—	—
	5	—	—	—
	6	—	—	—
M	1	—	—	—
	2	—	—	—
	3	—	—	—
K	1	—	—	—
	2	—	—	—
	3	—	—	—
N	1-2	—	—	—
	3	—	—	—
S	1	—	—	—
	2	—	—	—
	3	—	—	—
	4	240	180	120
H	1	—	—	—
	2	—	—	—
	3	—	—	—

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

■ Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining
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Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)														Insert Geometry	
	10%			20%			30%			40%		50-100%				
.E..GD2	.007	.010	.014	.005	.008	.011	.004	.007	.009	.004	.006	.009	.004	.006	.008	.E..GD2
.E..GN	.007	.010	.014	.005	.008	.011	.004	.007	.009	.004	.006	.009	.004	.006	.008	.E..GN
.S..GN	.008	.012	.018	.006	.009	.013	.005	.008	.011	.005	.007	.011	.005	.007	.010	.S..GN

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



Face Mills