## Recommended Starting Speeds [SFM]

| Material Group | | TN2510 | | | TN6540 | | | TN7525 | | | TN7535 | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| P | 1 | 2165 | **1910** | 1770 | 1180 | **925** | 785 | 1340 | **1025** | 925 | 1790 | **1555** | 1460 |
| | 2 | 1340 | **1220** | 1080 | 830 | **630** | 550 | 1025 | **830** | 710 | 1105 | **1000** | 905 |
| | 3 | 1220 | **1080** | 1000 | 710 | **550** | 450 | 925 | **710** | 610 | 1000 | **905** | 805 |
| | 4 | 905 | **845** | 750 | 590 | **430** | 355 | 770 | **550** | 475 | 750 | **690** | 630 |
| | 5 | 1080 | **985** | 905 | 785 | **590** | 490 | 1025 | **770** | 650 | 1025 | **905** | 830 |
| | 6 | 750 | **670** | 570 | 535 | **395** | 335 | 670 | **535** | 430 | 630 | **535** | 430 |
| M | 1 | 890 | **785** | 690 | 430 | **260** | 200 | 805 | **725** | 610 | 805 | **725** | 610 |
| | 2 | 805 | **690** | 630 | 260 | **155** | 140 | 725 | **630** | 550 | 725 | **630** | 550 |
| | 3 | 630 | **570** | 490 | 275 | **155** | 140 | 570 | **510** | 450 | 570 | **510** | 450 |
| K | 1 | 1380 | **1180** | 985 | 725 | **670** | 590 | 1240 | **925** | 785 | 1165 | **1045** | 940 |
| | 2 | 1180 | **985** | 830 | 570 | **510** | 450 | 1060 | **785** | 650 | 925 | **830** | 750 |
| | 3 | 985 | **830** | 650 | 510 | **475** | 415 | 785 | **650** | 550 | 770 | **690** | 630 |
| N | 1 | – | – | – | – | – | – | – | – | – | – | – | – |
| | 2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | 3 | – | – | – | – | – | – | – | – | – | – | – | – |
| S | 1 | – | – | – | 155 | **120** | 95 | – | – | – | – | – | – |
| | 2 | – | – | – | 80 | **60** | 40 | – | – | – | – | – | – |
| | 3 | – | – | – | 235 | **140** | 95 | – | – | – | – | – | – |
| | 4 | – | – | – | 200 | **95** | 80 | – | – | – | – | – | – |
| H | 1 | 475 | **360** | 230 | – | – | – | – | – | – | – | – | – |
| | 2 | 475 | **360** | 230 | – | – | – | – | – | – | – | – | – |
| | 3 | 380 | **260** | 150 | – | – | – | – | – | – | – | – | – |

*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 |
|---|---|---|

### At .157 Axial Depth of Cut (ap)

| Insert Geometry | Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae) | | | | | | | | | | | | | | | Insert Geometry |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | 5% | | | 10% | | | 20% | | | 30% | | | 40–100% | | | |
| RDMW- | .007 | **.011** | .016 | .005 | **.008** | .012 | .004 | **.006** | .009 | .003 | **.005** | .008 | .003 | **.005** | .007 | RDMW- |
| RDHT-T | .009 | **.012** | .024 | .007 | **.009** | .018 | .005 | **.007** | .013 | .004 | **.006** | .011 | .004 | **.005** | .011 | RDHT-T |
| RDMT-T | .009 | **.012** | .024 | .007 | **.009** | .018 | .005 | **.007** | .013 | .004 | **.006** | .011 | .004 | **.005** | .011 | RDMT-T |
| RDMW-T | .009 | **.016** | .028 | .007 | **.012** | .021 | .005 | **.009** | .015 | .004 | **.008** | .013 | .004 | **.007** | .012 | RDMW-T |

### At .079 Axial Depth of Cut (ap)

| Insert Geometry | Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae) | | | | | | | | | | | | | | | Insert Geometry |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | 5% | | | 10% | | | 20% | | | 30% | | | 40–100% | | | |
| RDMW- | .008 | **.013** | .019 | .006 | **.009** | .014 | .005 | **.007** | .010 | .004 | **.006** | .009 | .004 | **.006** | .008 | RDMW- |
| RDHT-T | .010 | **.014** | .028 | .008 | **.010** | .020 | .006 | **.008** | .015 | .005 | **.007** | .013 | .005 | **.006** | .012 | RDHT-T |
| RDMT-T | .010 | **.014** | .028 | .008 | **.010** | .020 | .006 | **.008** | .015 | .005 | **.007** | .013 | .005 | **.006** | .012 | RDMT-T |
| RDMW-T | .010 | **.019** | .033 | .008 | **.014** | .024 | .006 | **.010** | .018 | .005 | **.009** | .015 | .005 | **.008** | .014 | RDMW-T |

### At .039 Axial Depth of Cut (ap)

| Insert Geometry | Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae) | | | | | | | | | | | | | | | Insert Geometry |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | 5% | | | 10% | | | 20% | | | 30% | | | 40–100% | | | |
| RDMW- | .011 | **.017** | .025 | .008 | **.012** | .018 | .006 | **.009** | .013 | .005 | **.008** | .012 | .005 | **.007** | .011 | RDMW- |
| RDHT-T | .014 | **.018** | .037 | .010 | **.013** | .027 | .007 | **.010** | .020 | .006 | **.009** | .017 | .006 | **.008** | .016 | RDHT-T |
| RDMT-T | .014 | **.018** | .037 | .010 | **.013** | .027 | .007 | **.010** | .020 | .006 | **.009** | .017 | .006 | **.008** | .016 | RDMT-T |
| RDMW-T | .014 | **.025** | .043 | .010 | **.018** | .031 | .007 | **.013** | .023 | .006 | **.012** | .020 | .006 | **.011** | .019 | RDMW-T |

### At .020 Axial Depth of Cut (ap)

| Insert Geometry | Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae) | | | | | | | | | | | | | | | Insert Geometry |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | 5% | | | 10% | | | 20% | | | 30% | | | 40–100% | | | |
| RDMW- | .015 | **.023** | .034 | .011 | **.017** | .024 | .008 | **.013** | .018 | .007 | **.011** | .016 | .007 | **.010** | .014 | RDMW- |
| RDHT-T | .019 | **.025** | .051 | .014 | **.018** | .037 | .010 | **.014** | .027 | .009 | **.012** | .024 | .008 | **.011** | .022 | RDHT-T |
| RDMT-T | .019 | **.025** | .051 | .014 | **.018** | .037 | .010 | **.014** | .027 | .009 | **.012** | .024 | .008 | **.011** | .022 | RDMT-T |
| RDMW-T | .019 | **.034** | .060 | .014 | **.024** | .043 | .010 | **.018** | .032 | .009 | **.016** | .028 | .008 | **.014** | .025 | RDMW-T |

*NOTE: Use "Light Machining" value as starting feed rate.*