

■ Recommended Starting Speeds [SFM]

Copy Mills

Material Group		TN6520			TN6525			TN7535		
P	1	-	-	-	1340	1045	925	1790	1555	1460
	2	-	-	-	1045	830	710	1105	1000	905
	3	-	-	-	925	710	610	1000	905	805
	4	-	-	-	770	550	475	750	690	630
	5	-	-	-	1025	770	650	1025	905	830
	6	-	-	-	670	535	430	630	535	430
M	1	-	-	-	630	395	260	805	725	610
	2	-	-	-	395	260	155	725	630	550
	3	-	-	-	415	260	180	570	510	450
K	1	1475	1045	750	905	805	725	1165	1045	940
	2	1280	830	630	710	630	590	925	830	750
	3	985	750	535	590	535	475	770	690	630
N	1	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-
S	1	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-
	4	-	-	-	-	-	-	-	-	-
H	1	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-

(continued)

(Recommended Starting Speeds [SFM] – continued)

Material Group		WK15CM			WP25PM			WS30PM			WP40PM		
P	1	-	-	-	1295	1120	1060	-	-	-	1165	1025	965
	2	-	-	-	1080	940	785	-	-	-	985	845	710
	3	-	-	-	1000	845	690	-	-	-	905	770	630
	4	-	-	-	890	725	590	-	-	-	805	670	535
	5	-	-	-	725	670	590	-	-	-	670	610	535
	6	-	-	-	650	490	395	-	-	-	590	450	355
M	1	-	-	-	805	710	650	890	785	725	770	670	610
	2	-	-	-	725	630	510	805	710	570	690	590	490
	3	-	-	-	550	475	370	610	535	415	510	450	355
K	1	1655	1520	1340	905	805	725	-	-	-	-	-	-
	2	1320	1165	1080	710	630	590	-	-	-	-	-	-
	3	1105	985	905	590	535	475	-	-	-	-	-	-
N	1	-	-	-	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-
S	1	-	-	-	155	140	95	180	155	120	155	140	120
	2	-	-	-	155	140	95	180	155	120	155	140	120
	3	-	-	-	200	155	95	215	180	120	200	155	120
	4	-	-	-	275	200	140	335	235	155	260	200	140
H	1	-	-	-	475	355	275	-	-	-	-	-	-
	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

■ Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining
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For Plunging Applications

Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry
	5%			10%			20%			30%			40-100%			
...MM	.035	.061	.150	.025	.044	.104	.019	.033	.076	.017	.028	.066	.015	.026	.061	...MM
...MH	.035	.092	.197	.025	.065	.134	.019	.048	.098	.017	.042	.085	.015	.038	.078	...MH

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