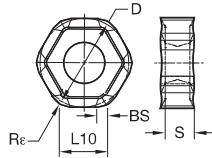
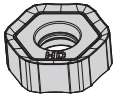
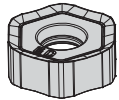


Face Mills



● first choice  
○ alternate choice

P																		
M				○		○												
K	●	●	○	○	○	○	○	○	○									
N																		
S										●			●	●	●		○	
H													○					

■ HNPJ-GD

catalogue number	cutting edges	D	L10	S	BS	Re	hm	TN6510	TN6520	TN6525	TN6540	TN7535	WK15CM	WP25PM	WP35CM	WS30PM	WP40PM
HNPJ0704ANSNGD	12	13	6,80	4,45	1,27	1,20	0,10	3954432	3954473	-	3954474	3954475	5427374	5895293	5895294	5528976	5550906

■ HNPJ-HD

catalogue number	cutting edges	D	L10	S	BS	Re	hm	TN6510	TN6520	TN6525	TN6540	TN7535	WK15CM	WP25PM	WP35CM	WS30PM	WP40PM
HNPJ0704ANSNHD	12	13	6,80	4,41	1,25	1,20	0,14	3954477	3954478	-	3954479	3954480	5427375	5895295	5895296	-	5550907
HNPJ070432ANSNHD	12	13	6,80	4,42	-	3,20	0,14	3954481	3954482	-	3954483	3954484	-	-	-	-	5895297

Recommended Starting Speeds

■ Recommended Starting Speeds [m/min]

Material Group		TN6510			TN6520			TN6525			TN6540			TN7535			WK15CM		
P	1	-	-	-	-	-	-	410	<b>320</b>	280	360	<b>280</b>	240	545	<b>475</b>	445	-	-	-
	2	-	-	-	-	-	-	320	<b>250</b>	215	250	<b>190</b>	170	335	<b>305</b>	275	-	-	-
	3	-	-	-	-	-	-	280	<b>215</b>	185	215	<b>170</b>	140	305	<b>275</b>	245	-	-	-
	4	-	-	-	-	-	-	235	<b>170</b>	145	180	<b>130</b>	110	230	<b>210</b>	190	-	-	-
	5	-	-	-	-	-	-	310	<b>235</b>	200	240	<b>180</b>	150	310	<b>275</b>	250	-	-	-
	6	-	-	-	-	-	-	205	<b>160</b>	130	160	<b>120</b>	100	190	<b>160</b>	130	-	-	-
M	1	-	-	-	-	-	-	190	<b>120</b>	80	130	<b>80</b>	60	245	<b>220</b>	185	-	-	-
	2	-	-	-	-	-	-	120	<b>80</b>	50	80	<b>50</b>	40	220	<b>190</b>	170	-	-	-
	3	-	-	-	-	-	-	125	<b>80</b>	55	85	<b>50</b>	40	175	<b>155</b>	140	-	-	-
K	1	480	<b>350</b>	260	450	<b>320</b>	230	275	<b>245</b>	220	220	<b>205</b>	180	355	<b>320</b>	290	505	<b>460</b>	410
	2	420	<b>280</b>	205	390	<b>250</b>	190	215	<b>190</b>	180	175	<b>155</b>	140	280	<b>250</b>	230	400	<b>355</b>	330
	3	335	<b>260</b>	200	300	<b>230</b>	160	180	<b>160</b>	145	155	<b>145</b>	125	235	<b>210</b>	190	335	<b>300</b>	275
N	1	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	1	-	-	-	-	-	-	-	-	-	50	<b>35</b>	30	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	25	<b>20</b>	10	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	70	<b>40</b>	30	-	-	-	-	-	-
	4	-	-	-	-	-	-	-	-	-	60	<b>30</b>	25	-	-	-	-	-	-
H	1	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

(continued)

(Recommended Starting Speeds [m/min] – continued)

Material Group		WP25PM			WP35CM			WS30PM			WP40PM			TN6501			THM-U		
P	1	395	<b>340</b>	325	545	<b>475</b>	445	-	-	-	355	<b>310</b>	295	-	-	-	-	-	-
	2	330	<b>290</b>	240	335	<b>305</b>	275	-	-	-	300	<b>260</b>	215	-	-	-	-	-	-
	3	305	<b>260</b>	210	305	<b>275</b>	245	-	-	-	275	<b>235</b>	190	-	-	-	-	-	-
	4	270	<b>220</b>	180	230	<b>210</b>	190	-	-	-	245	<b>205</b>	160	-	-	-	-	-	-
	5	220	<b>205</b>	180	310	<b>275</b>	250	-	-	-	205	<b>185</b>	160	-	-	-	-	-	-
	6	200	<b>150</b>	120	190	<b>160</b>	130	-	-	-	180	<b>140</b>	110	-	-	-	-	-	-
M	1	245	<b>215</b>	200	245	<b>220</b>	185	270	<b>240</b>	220	235	<b>205</b>	185	-	-	-	-	-	-
	2	220	<b>190</b>	155	220	<b>190</b>	170	245	<b>215</b>	175	210	<b>180</b>	150	-	-	-	-	-	-
	3	170	<b>145</b>	115	175	<b>155</b>	140	185	<b>160</b>	125	155	<b>140</b>	110	-	-	-	-	-	-
K	1	275	<b>245</b>	220	355	<b>320</b>	290	-	-	-	-	-	-	-	-	-	-	-	-
	2	215	<b>190</b>	180	280	<b>250</b>	230	-	-	-	-	-	-	-	-	-	-	-	-
	3	180	<b>160</b>	145	235	<b>210</b>	190	-	-	-	-	-	-	-	-	-	-	-	-
N	1	-	-	-	-	-	-	-	-	-	-	-	-	2400	<b>1440</b>	1200	2400	<b>1440</b>	1200
	2	-	-	-	-	-	-	-	-	-	-	-	-	1640	<b>980</b>	800	1640	<b>980</b>	800
	3	-	-	-	-	-	-	-	-	-	-	-	-	960	<b>600</b>	480	960	<b>600</b>	480
S	1	50	<b>40</b>	30	-	-	-	55	<b>50</b>	35	50	<b>40</b>	35	-	-	-	-	-	-
	2	50	<b>40</b>	30	-	-	-	55	<b>50</b>	35	50	<b>40</b>	35	-	-	-	-	-	-
	3	60	<b>50</b>	30	-	-	-	65	<b>55</b>	35	60	<b>50</b>	35	-	-	-	-	-	-
	4	85	<b>60</b>	40	80	<b>60</b>	40	100	<b>70</b>	50	80	<b>60</b>	40	-	-	-	-	-	-
H	1	145	<b>110</b>	85	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

Face Mills

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 [mm]

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
	5%			10%			20%			30%			40-100%			
.F..LDJ	0,14	<b>0,26</b>	0,53	0,10	<b>0,19</b>	0,38	0,08	<b>0,14</b>	0,29	0,07	<b>0,12</b>	0,25	0,06	<b>0,11</b>	0,23	.F..LDJ
.E..LD	0,14	<b>0,41</b>	0,82	0,10	<b>0,29</b>	0,59	0,08	<b>0,22</b>	0,44	0,07	<b>0,19</b>	0,38	0,06	<b>0,18</b>	0,35	.E..LD
.S..GD	0,27	<b>0,68</b>	1,10	0,20	<b>0,49</b>	0,79	0,15	<b>0,37</b>	0,59	0,13	<b>0,32</b>	0,51	0,12	<b>0,29</b>	0,47	.S..GD
.S..HD	0,27	<b>0,68</b>	1,10	0,20	<b>0,49</b>	0,79	0,15	<b>0,37</b>	0,59	0,13	<b>0,32</b>	0,51	0,12	<b>0,29</b>	0,47	.S..HD

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