

Recommended Starting Speeds [m/min]

Material Group		WK15CM			WP35CM			WP40PM		
P	0	-	-	-	455	395	370	295	260	245
	1	-	-	-	455	395	370	295	260	245
	2	-	-	-	280	255	230	250	215	180
	3	-	-	-	255	230	205	230	195	160
	4	-	-	-	190	175	160	205	170	135
	5	-	-	-	260	230	210	170	155	135
	6	-	-	-	160	135	110	150	115	90
M	1	-	-	-	205	185	155	195	170	155
	2	-	-	-	185	160	140	175	150	125
	3	-	-	-	145	130	115	130	115	90
K	1	420	385	340	295	265	240	-	-	-
	2	335	295	275	235	210	190	-	-	-
	3	280	250	230	195	175	160	-	-	-
N	1	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-
S	1	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-
	4	-	-	-	66	50	33	-	-	-
H	1	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-

Slotting Mills

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

Recommended Starting Feeds
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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%			
SNHX	0,12	0,28	0,71	0,08	0,20	0,51	0,06	0,15	0,38	0,06	0,13	0,33	0,05	0,12	0,30	SNHX

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