

■ Recommended Starting Speeds [SFM]

Material Group		TN6520			TN6525			TN6540			TN7535			WK15CM			WP25PM		
P	1	-	-	-	1340	1045	925	1180	925	785	1790	1555	1460	-	-	-	1295	1120	1060
	2	-	-	-	1045	830	710	830	630	550	1105	1000	905	-	-	-	1080	940	785
	3	-	-	-	925	710	610	710	550	450	1000	905	805	-	-	-	1000	845	690
	4	-	-	-	770	550	475	590	430	355	750	690	630	-	-	-	890	725	590
	5	-	-	-	1025	770	650	785	590	490	1025	905	830	-	-	-	725	670	590
	6	-	-	-	670	535	430	535	395	335	630	535	430	-	-	-	650	490	395
M	1	-	-	-	630	395	260	430	260	200	805	725	610	-	-	-	805	710	650
	2	-	-	-	395	260	155	260	155	140	725	630	550	-	-	-	725	630	510
	3	-	-	-	415	260	180	275	155	140	570	510	450	-	-	-	550	475	370
K	1	1475	1045	750	905	805	725	725	670	590	1165	1045	940	1655	1520	1340	905	805	725
	2	1280	830	630	710	630	590	570	510	450	925	830	750	1320	1165	1080	710	630	590
	3	985	750	535	590	535	475	510	475	415	770	690	630	1105	985	905	590	535	475
N	1	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	1	-	-	-	-	-	-	155	120	95	-	-	-	-	-	-	155	140	95
	2	-	-	-	-	-	-	80	60	40	-	-	-	-	-	-	155	140	95
	3	-	-	-	-	-	-	235	140	95	-	-	-	-	-	-	200	155	95
	4	-	-	-	-	-	-	200	95	80	-	-	-	-	-	-	275	200	140
H	1	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	475	355	275
	2	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

Material Group		WS30PM			WP35CM			WP40PM			TN6501			THM-U		
P	1	-	-	-	1790	1555	1460	1165	1025	965	-	-	-	-	-	-
	2	-	-	-	1105	1000	905	985	845	710	-	-	-	-	-	-
	3	-	-	-	1000	905	805	905	770	630	-	-	-	-	-	-
	4	-	-	-	750	690	630	805	670	535	-	-	-	-	-	-
	5	-	-	-	1025	905	830	670	610	535	-	-	-	-	-	-
	6	-	-	-	630	535	430	590	450	355	-	-	-	-	-	-
M	1	890	785	725	805	725	610	770	670	610	-	-	-	-	-	-
	2	805	710	570	725	630	550	690	590	490	-	-	-	-	-	-
	3	610	535	415	570	510	450	510	450	355	-	-	-	-	-	-
K	1	-	-	-	1165	1045	940	-	-	-	-	-	-	-	-	-
	2	-	-	-	925	830	750	-	-	-	-	-	-	-	-	-
	3	-	-	-	770	690	630	-	-	-	-	-	-	-	-	-
N	1	-	-	-	-	-	-	-	-	-	7870	4720	3935	7870	4720	3935
	2	-	-	-	-	-	-	-	-	-	5370	3210	2615	5370	3210	2615
	3	-	-	-	-	-	-	-	-	-	3150	1970	1570	3150	1970	1570
S	1	180	155	120	-	-	-	155	140	120	-	-	-	-	-	-
	2	180	155	120	-	-	-	155	140	120	-	-	-	-	-	-
	3	215	180	120	-	-	-	200	155	120	-	-	-	-	-	-
	4	335	235	155	260	200	130	260	200	140	-	-	-	-	-	-
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

■ 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
	5%			10%			20%			30%			40–100%			
.F..LDJ	.018	.036	.073	.013	.026	.052	.010	.019	.039	.008	.017	.034	.008	.015	.031	.F..LDJ
.E..LD	.018	.055	.112	.013	.039	.079	.010	.029	.058	.008	.025	.051	.008	.023	.046	.E..LD
.S..GD	.028	.093	.153	.020	.066	.106	.015	.049	.078	.013	.042	.068	.012	.039	.062	.S..GD
.S..HD	.036	.093	.153	.026	.066	.106	.019	.049	.078	.017	.042	.068	.015	.039	.062	.S..HD

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