■ Recommended Starting Speeds [SFM]

Material Group		WDN00U		
P	1	–	–	–
	2	–	–	–
	3	–	–	–
	4	–	–	–
	5	–	–	–
	6	–	–	–
M	1	–	–	–
	2	–	–	–
	3	–	–	–
K	1	–	–	–
	2	–	–	–
	3	–	–	–
N	1–2	3000	**6500**	16000
	3	1500	**2000**	2500
S	1	–	–	–
	2	–	–	–
	3	–	–	–
	4	–	–	–
H	1	–	–	–

Recommended Starting Feeds

■ Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)														Insert Geometry
	10%			**20%**			**30%**			**40%**			**50–100%**		
SDR…	.003	**.007**	.011	.003	**.005**	.008	.002	**.004**	.007	.002	**.004**	.006	.002	**.004**	.006	SDR…
EDR…	.003	**.007**	.011	.003	**.005**	.008	.002	**.004**	.007	.002	**.004**	.006	.002	**.004**	.006	EDR…

*NOTE: First choice starting feed (fz) is in **bold** type.*
Use corresponding speed (vc).
fz and vc are valid for ae ≥0.4 D1.
For smaller ae, fz and vc should be multiplied by the factor given below:

$$hm = fz \cdot \sqrt{\frac{ae}{D1}} \cdot \sin \chi_r$$

$$fz = \frac{hm}{\sin \chi_r} \cdot \sqrt{\frac{D1}{ae}}$$

ae/D1 =	0.2	0.3	0.4
fz-Factor	1.5	1.3	1.0
vc-Factor	1.3	1.2	1.1