

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

Material Group		WP25PM			WP35CM			WS30PM			WP40PM			TN6501			THM-U		
P	1	395	340	325	545	475	445	-	-	-	355	310	295	-	-	-	-	-	-
	2	330	290	240	335	305	275	-	-	-	300	260	215	-	-	-	-	-	-
	3	305	260	210	305	275	245	-	-	-	275	235	190	-	-	-	-	-	-
	4	270	220	180	230	210	190	-	-	-	245	205	160	-	-	-	-	-	-
	5	220	205	180	310	275	250	-	-	-	205	185	160	-	-	-	-	-	-
	6	200	150	120	190	160	130	-	-	-	180	140	110	-	-	-	-	-	-
M	1	245	215	200	245	220	185	270	240	220	235	205	185	-	-	-	-	-	-
	2	220	190	155	220	190	170	245	215	175	210	180	150	-	-	-	-	-	-
	3	170	145	115	175	155	140	185	160	125	155	140	110	-	-	-	-	-	-
K	1	275	245	220	355	320	290	-	-	-	-	-	-	-	-	-	-	-	-
	2	215	190	180	280	250	230	-	-	-	-	-	-	-	-	-	-	-	-
	3	180	160	145	235	210	190	-	-	-	-	-	-	-	-	-	-	-	-
N	1	-	-	-	-	-	-	-	-	-	-	-	-	2400	1440	1200	2400	1440	1200
	2	-	-	-	-	-	-	-	-	-	-	-	-	1640	980	800	1640	980	800
	3	-	-	-	-	-	-	-	-	-	-	-	-	960	600	480	960	600	480
S	1	50	40	30	-	-	-	55	50	35	50	40	35	-	-	-	-	-	-
	2	50	40	30	-	-	-	55	50	35	50	40	35	-	-	-	-	-	-
	3	60	50	30	-	-	-	65	55	35	60	50	35	-	-	-	-	-	-
	4	85	60	40	80	60	40	100	70	50	80	60	40	-	-	-	-	-	-
H	1	145	110	85	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	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 [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	0,48	0,89	1,81	0,34	0,64	1,29	0,26	0,48	0,96	0,22	0,42	0,83	0,21	0,38	0,76	.F.LDJ
.E..LD	0,48	1,38	2,85	0,34	0,99	2,00	0,26	0,74	1,48	0,22	0,64	1,28	0,21	0,59	1,17	.E..LD
.S..GD	0,92	2,35	3,89	0,66	1,67	2,70	0,49	1,23	1,98	0,43	1,07	1,72	0,39	0,98	1,57	.S..GD
.S..HD	0,92	2,35	3,89	0,66	1,67	2,70	0,49	1,23	1,98	0,43	1,07	1,72	0,39	0,98	1,57	.S..HD

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