

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

Material Group		WK15CM			WP40PM			TT125			THM		
P	1	-	-	-	355	<b>310</b>	295	430	<b>360</b>	300	-	-	-
	2	-	-	-	300	<b>260</b>	215	310	<b>250</b>	215	-	-	-
	3	-	-	-	275	<b>235</b>	190	310	<b>250</b>	215	-	-	-
	4	-	-	-	245	<b>205</b>	160	265	<b>215</b>	180	-	-	-
	5	-	-	-	205	<b>185</b>	160	320	<b>235</b>	200	-	-	-
	6	-	-	-	180	<b>140</b>	110	145	<b>110</b>	90	-	-	-
M	1	-	-	-	235	<b>205</b>	185	480	<b>310</b>	215	-	-	-
	2	-	-	-	210	<b>180</b>	150	325	<b>205</b>	145	-	-	-
	3	-	-	-	155	<b>140</b>	110	320	<b>210</b>	145	-	-	-
K	1	505	<b>460</b>	410	-	-	-	220	<b>185</b>	155	145	<b>110</b>	90
	2	400	<b>355</b>	330	-	-	-	180	<b>145</b>	125	150	<b>120</b>	85
	3	335	<b>300</b>	275	-	-	-	145	<b>125</b>	100	155	<b>115</b>	70
N	1	-	-	-	-	-	-	-	-	-	1080	<b>720</b>	600
	2	-	-	-	-	-	-	-	-	-	820	<b>560</b>	460
	3	-	-	-	-	-	-	-	-	-	540	<b>335</b>	240
S	1	-	-	-	50	<b>40</b>	35	-	-	-	-	-	-
	2	-	-	-	50	<b>40</b>	35	-	-	-	-	-	-
	3	-	-	-	60	<b>50</b>	35	-	-	-	-	-	-
	4	-	-	-	80	<b>60</b>	40	-	-	-	-	-	-
H	1	-	-	-	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-

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

Face Mills

Recommended Starting Feeds

■ Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining
-----------------	-----------------	-----------------

Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry
	5%			10%			20%			30%			40-100%			
...20	0,17	<b>0,66</b>	1,19	0,12	<b>0,47</b>	0,86	0,09	<b>0,35</b>	0,64	0,08	<b>0,31</b>	0,56	0,07	<b>0,28</b>	0,51	...20
...21	0,24	<b>0,74</b>	1,25	0,18	<b>0,53</b>	0,89	0,13	<b>0,40</b>	0,66	0,12	<b>0,35</b>	0,58	0,11	<b>0,32</b>	0,53	...21
...31	0,26	<b>0,76</b>	1,28	0,19	<b>0,55</b>	0,91	0,14	<b>0,41</b>	0,68	0,12	<b>0,36</b>	0,59	0,11	<b>0,33</b>	0,54	...31

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