

■ Recommended Starting Speeds [m/min]

Material Group		WDN00U		
P	1	-	-	-
	2	-	-	-
	3	-	-	-
	4	-	-	-
	5	-	-	-
	6	-	-	-
M	1	-	-	-
	2	-	-	-
	3	-	-	-
K	1	-	-	-
	2	-	-	-
	3	-	-	-
N	1-2	910	1980	4880
	3	460	610	760
S	1	-	-	-
	2	-	-	-
	3	-	-	-
	4	-	-	-
H	1	-	-	-

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
	10%			20%			30%			40%			50-100%			
SDR...	0,08	0,17	0,33	0,06	0,13	0,25	0,06	0,11	0,22	0,05	0,10	0,20	0,05	0,10	0,20	SDR...
EDR...	0,08	0,17	0,33	0,06	0,13	0,25	0,06	0,11	0,22	0,05	0,10	0,20	0,05	0,10	0,20	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:

ae/D1 =	0,2	0,3	0,4
fz-Factor	1,5	1,3	1,0
vc-Factor	1,3	1,2	1,1

