

■ Recommended Starting Speeds [m/min]

Chamfer Mills

Material Group		TN2510			TN7525			TN7535			WK15CM			THM		
<b>P</b>	1	660	<b>580</b>	540	410	<b>310</b>	280	545	<b>475</b>	445	-	-	-	-	-	-
	2	410	<b>370</b>	330	310	<b>250</b>	215	335	<b>305</b>	275	-	-	-	-	-	-
	3	370	<b>330</b>	305	280	<b>215</b>	185	305	<b>275</b>	245	-	-	-	-	-	-
	4	275	<b>260</b>	230	235	<b>170</b>	145	230	<b>210</b>	190	-	-	-	-	-	-
	5	330	<b>300</b>	275	310	<b>235</b>	200	310	<b>275</b>	250	-	-	-	-	-	-
	6	230	<b>205</b>	175	205	<b>160</b>	130	190	<b>160</b>	130	-	-	-	-	-	-
<b>M</b>	1	270	<b>240</b>	210	245	<b>220</b>	185	245	<b>220</b>	185	-	-	-	-	-	-
	2	245	<b>210</b>	190	220	<b>190</b>	170	220	<b>190</b>	170	-	-	-	-	-	-
	3	190	<b>175</b>	150	175	<b>155</b>	140	175	<b>155</b>	140	-	-	-	-	-	-
<b>K</b>	1	420	<b>360</b>	300	380	<b>280</b>	240	355	<b>320</b>	290	505	<b>460</b>	410	145	<b>110</b>	90
	2	360	<b>300</b>	250	325	<b>240</b>	200	280	<b>250</b>	230	400	<b>355</b>	330	150	<b>120</b>	85
	3	300	<b>250</b>	200	240	<b>200</b>	170	235	<b>210</b>	190	335	<b>300</b>	275	155	<b>115</b>	70
<b>N</b>	1	-	-	-	-	-	-	-	-	-	-	-	-	1080	<b>720</b>	600
	2	-	-	-	-	-	-	-	-	-	-	-	-	820	<b>560</b>	460
	3	-	-	-	-	-	-	-	-	-	-	-	-	540	<b>335</b>	240
<b>S</b>	1	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	4	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
<b>H</b>	1	145	<b>110</b>	70	-	-	-	-	-	-	-	-	-	-	-	-
	2	145	<b>110</b>	70	-	-	-	-	-	-	-	-	-	-	-	-
	3	115	<b>80</b>	45	-	-	-	-	-	-	-	-	-	-	-	-

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

Recommended Starting Feeds

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Light Machining	General Purpose	Heavy Machining
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Insert Geometry	Programmed Feed per Tooth (fz)			Insert Geometry
SD09	0,10	<b>0,15</b>	0,30	SD09
SP12	0,10	<b>0,15</b>	0,35	SP12

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