

■ Recommended Starting Speeds [m/min]

Material Group		WK15PM			WP25PM			WU35PM			WP40PM			WK15CM			WP35CM		
P	1	-	-	-	330	<b>285</b>	270	260	<b>230</b>	215	300	<b>260</b>	250	-	-	-	455	<b>395</b>	370
	2	-	-	-	275	<b>240</b>	200	220	<b>190</b>	160	250	<b>220</b>	180	-	-	-	280	<b>255</b>	230
	3	-	-	-	255	<b>215</b>	175	200	<b>170</b>	140	230	<b>200</b>	160	-	-	-	255	<b>230</b>	205
	4	-	-	-	225	<b>185</b>	150	180	<b>150</b>	120	210	<b>170</b>	140	-	-	-	190	<b>175</b>	160
	5	-	-	-	185	<b>170</b>	150	150	<b>135</b>	120	170	<b>160</b>	140	-	-	-	260	<b>230</b>	210
	6	-	-	-	165	<b>125</b>	100	130	<b>100</b>	80	150	<b>120</b>	90	-	-	-	160	<b>135</b>	110
M	1	-	-	-	205	<b>180</b>	165	170	<b>150</b>	135	200	<b>170</b>	160	-	-	-	205	<b>185</b>	155
	2	-	-	-	185	<b>160</b>	130	155	<b>130</b>	110	180	<b>150</b>	130	-	-	-	185	<b>160</b>	140
	3	-	-	-	140	<b>120</b>	95	115	<b>100</b>	80	130	<b>120</b>	90	-	-	-	145	<b>130</b>	115
K	1	270	<b>245</b>	215	230	<b>205</b>	185	-	-	-	-	-	-	420	<b>385</b>	340	295	<b>265</b>	240
	2	210	<b>190</b>	175	180	<b>160</b>	150	-	-	-	-	-	-	335	<b>295</b>	275	235	<b>210</b>	190
	3	175	<b>160</b>	145	150	<b>135</b>	120	-	-	-	-	-	-	280	<b>250</b>	230	195	<b>175</b>	160
N	1-2	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	1	-	-	-	40	<b>35</b>	25	35	<b>30</b>	25	40	<b>40</b>	30	-	-	-	-	-	-
	2	-	-	-	40	<b>35</b>	25	35	<b>30</b>	25	40	<b>40</b>	30	-	-	-	-	-	-
	3	-	-	-	50	<b>40</b>	25	45	<b>35</b>	25	50	<b>40</b>	30	-	-	-	-	-	-
	4	-	-	-	70	<b>50</b>	35	60	<b>45</b>	30	70	<b>50</b>	40	-	-	-	-	-	-
H	1	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

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%			
XN.U-ML	0,17	<b>0,29</b>	0,46	0,13	<b>0,21</b>	0,33	0,09	<b>0,16</b>	0,25	0,08	<b>0,14</b>	0,22	0,08	<b>0,13</b>	0,20	XN.U-ML
XN.U-MM	0,21	<b>0,39</b>	0,58	0,15	<b>0,28</b>	0,42	0,11	<b>0,21</b>	0,31	0,10	<b>0,19</b>	0,27	0,09	<b>0,17</b>	0,25	XN.U-MM
XNGU-MH	0,23	<b>0,45</b>	0,70	0,17	<b>0,33</b>	0,50	0,13	<b>0,24</b>	0,38	0,11	<b>0,21</b>	0,33	0,10	<b>0,20</b>	0,30	XNGU-MH

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