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

Material Group		TN7535			WK15CM			WS30PM		
P	0	455	**395**	370	–	–	–	–	–	–
	1	455	**395**	370	–	–	–	–	–	–
	2	280	**255**	230	–	–	–	–	–	–
	3	255	**230**	205	–	–	–	–	–	–
	4	190	**175**	160	–	–	–	–	–	–
	5	260	**230**	210	–	–	–	–	–	–
	6	160	**135**	110	–	–	–	–	–	–
M	1	205	**185**	155	–	–	–	225	**200**	185
	2	185	**160**	140	–	–	–	205	**180**	145
	3	145	**130**	115	–	–	–	155	**135**	105
K	1	295	**265**	240	420	**385**	340	–	–	–
	2	235	**210**	190	335	**295**	275	–	–	–
	3	195	**175**	160	280	**250**	230	–	–	–
N	1	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–
S	1	–	–	–	–	–	–	45	**40**	30
	2	–	–	–	–	–	–	45	**40**	30
	3	–	–	–	–	–	–	55	**45**	30
	4	–	–	–	–	–	–	85	**60**	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.

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%			
.F..ALP	0,12	**0,23**	0,46	0,08	**0,17**	0,33	0,06	**0,13**	0,25	0,06	**0,11**	0,22	0,05	**0,10**	0,20	.F..ALP
.E..ML	0,12	**0,35**	0,58	0,08	**0,25**	0,42	0,06	**0,19**	0,31	0,06	**0,17**	0,27	0,05	**0,15**	0,25	.E..ML
.S..MM	0,12	**0,42**	0,70	0,08	**0,30**	0,50	0,06	**0,23**	0,38	0,06	**0,20**	0,33	0,05	**0,18**	0,30	.S..MM
.S..MH	0,23	**0,54**	0,85	0,17	**0,39**	0,61	0,13	**0,29**	0,46	0,11	**0,25**	0,40	0,10	**0,23**	0,36	.S..MH

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