

■ Recommended Starting Speeds [m/min]

Material Group		WK15CM			WP25PM			WU35PM			WP35CM			WP40PM		
P	0	-	-	-	330	285	270	260	230	215	455	395	370	295	260	245
	1	-	-	-	330	285	270	260	230	215	455	395	370	295	260	245
	2	-	-	-	275	240	200	220	190	160	280	255	230	250	215	180
	3	-	-	-	255	215	175	200	170	140	255	230	205	230	195	160
	4	-	-	-	225	185	150	180	150	120	190	175	160	205	170	135
	5	-	-	-	185	170	150	150	135	120	260	230	210	170	155	135
	6	-	-	-	165	125	100	130	100	80	160	135	110	150	115	90
M	1	-	-	-	205	180	165	170	150	135	205	185	155	195	170	155
	2	-	-	-	185	160	130	155	130	110	185	160	140	175	150	125
	3	-	-	-	140	120	95	115	100	80	145	130	115	130	115	90
K	1	420	385	340	230	205	185	-	-	-	295	265	240	-	-	-
	2	335	295	275	180	160	150	-	-	-	235	210	190	-	-	-
	3	280	250	230	150	135	120	-	-	-	195	175	160	-	-	-
N	1	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	1	-	-	-	40	35	25	35	30	25	-	-	-	40	35	30
	2	-	-	-	40	35	25	35	30	25	-	-	-	40	35	30
	3	-	-	-	50	40	25	45	35	25	-	-	-	50	40	30
	4	-	-	-	70	50	35	60	45	30	66	50	33	65	50	35
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

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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%			
MDHW	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	MDHW

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