

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

Material Group		WP25PM			WS30PM			WP40PM		
P	1	395	340	325	-	-	-	355	310	295
	2	330	290	240	-	-	-	300	260	215
	3	305	260	210	-	-	-	275	235	190
	4	270	220	180	-	-	-	245	205	160
	5	220	205	180	-	-	-	205	185	160
	6	200	150	120	-	-	-	180	140	110
M	1	245	215	200	270	240	220	235	205	185
	2	220	190	155	245	215	175	210	180	150
	3	170	145	115	185	160	125	155	140	110
K	1	275	245	220	-	-	-	-	-	-
	2	215	190	180	-	-	-	-	-	-
	3	180	160	145	-	-	-	-	-	-
N	1	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-
S	1	50	40	30	55	50	35	50	40	35
	2	50	40	30	55	50	35	50	40	35
	3	60	50	30	65	55	35	60	50	35
	4	85	60	40	100	70	50	80	60	40
H	1	145	110	85	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-

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

Copy Mills

Recommended Starting Feeds

■ Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining
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For Plunging Applications

Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry
	5%			10%			20%			30%			40-100%			
..MM	0,90	1,67	4,09	0,65	1,19	2,83	0,48	0,88	2,08	0,42	0,77	1,80	0,38	0,70	1,64	..MM
..MH	0,90	2,34	5,00	0,65	1,66	3,41	0,48	1,23	2,49	0,42	1,07	2,16	0,38	0,98	1,97	..MH

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