

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

Material Group		WP35CM			WS30PM			WP40PM		
P	1	545	475	445	-	-	-	355	310	295
	2	335	305	275	-	-	-	300	260	215
	3	305	275	245	-	-	-	275	235	190
	4	230	210	190	-	-	-	245	205	160
	5	310	275	250	-	-	-	205	185	160
	6	190	160	130	-	-	-	180	140	110
M	1	245	220	185	270	240	220	235	205	185
	2	220	190	170	245	215	175	210	180	150
	3	175	155	140	185	160	125	155	140	110
K	1	355	320	290	-	-	-	-	-	-
	2	280	250	230	-	-	-	-	-	-
	3	235	210	190	-	-	-	-	-	-
N	1	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-
S	1	-	-	-	55	50	35	50	40	35
	2	-	-	-	55	50	35	50	40	35
	3	-	-	-	65	55	35	60	50	35
	4	80	60	40	100	70	50	80	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.

Copy Mills

Recommended Starting Feeds

■ Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining
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For All Other 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	1,87	3,62	0,65	1,33	2,52	0,48	0,99	1,86	0,42	0,86	1,61	0,39	0,79	1,47	..MM
..MH	0,90	2,35	4,97	0,65	1,67	3,40	0,48	1,23	2,48	0,42	1,07	2,15	0,39	0,98	1,96	..MH
..MR	0,90	2,81	5,44	0,65	1,97	3,69	0,48	1,46	2,69	0,42	1,27	2,33	0,39	1,16	2,13	..MR

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