

■ Recommended Starting Speeds [m/min]

Material Group		TN2505			TN6525			TN6540		
P	1	550	420	360	410	320	280	360	280	240
	2	320	240	205	320	250	215	250	190	170
	3	320	240	205	280	215	185	215	170	140
	4	-	-	-	235	170	145	180	130	110
	5	-	-	-	310	235	200	240	180	150
	6	-	-	-	205	160	130	160	120	100
M	1	-	-	-	190	120	80	130	80	60
	2	-	-	-	120	80	50	80	50	40
	3	-	-	-	125	80	55	85	50	40
K	1	400	300	250	275	245	220	220	205	180
	2	540	365	280	215	190	180	175	155	140
	3	310	190	155	180	160	145	155	145	125
N	1	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-
S	1	-	-	-	-	-	-	50	35	30
	2	-	-	-	-	-	-	25	20	10
	3	-	-	-	-	-	-	70	40	30
	4	-	-	-	-	-	-	60	30	25
H	1	175	140	95	-	-	-	-	-	-
	2	175	140	95	-	-	-	-	-	-
	3	140	115	80	-	-	-	-	-	-

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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At 6,00 Axial Depth of Cut (ap)

Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry
	5%			10%			20%			30%			40-100%			
MM	0,33	0,48	0,76	0,24	0,35	0,54	0,18	0,26	0,41	0,16	0,23	0,35	0,14	0,21	0,33	MM
MH	0,35	0,70	1,17	0,25	0,50	0,84	0,19	0,38	0,63	0,16	0,33	0,55	0,15	0,30	0,50	MH

At 3,00 Axial Depth of Cut (ap)

Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry
	5%			10%			20%			30%			40-100%			
MM	0,38	0,56	0,88	0,28	0,40	0,63	0,21	0,30	0,47	0,18	0,26	0,41	0,17	0,24	0,38	MM
MH	0,40	0,81	1,36	0,29	0,58	0,97	0,22	0,43	0,72	0,19	0,38	0,63	0,17	0,35	0,58	MH

At 2,00 Axial Depth of Cut (ap)

Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry
	5%			10%			20%			30%			40-100%			
MM	0,44	0,65	1,02	0,32	0,47	0,73	0,24	0,35	0,55	0,21	0,30	0,48	0,19	0,28	0,44	MM
MH	0,47	0,94	1,59	0,34	0,68	1,13	0,25	0,50	0,84	0,22	0,44	0,73	0,20	0,40	0,67	MH

At 1,00 Axial Depth of Cut (ap)

Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry
	5%			10%			20%			30%			40-100%			
MM	0,60	0,88	1,38	0,43	0,63	0,99	0,32	0,47	0,74	0,28	0,41	0,64	0,26	0,38	0,59	MM
MH	0,63	1,28	2,16	0,45	0,91	1,53	0,34	0,68	1,14	0,30	0,59	0,99	0,27	0,54	0,90	MH

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

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