

■ 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.

Copy Mills

Recommended Starting Feeds

■ Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining
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At 8,00 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	0,39	<b>0,52</b>	0,82	0,28	<b>0,37</b>	0,59	0,21	<b>0,28</b>	0,44	0,18	<b>0,24</b>	0,38	0,17	<b>0,22</b>	0,35	MM
MH	0,51	<b>0,70</b>	1,17	0,37	<b>0,50</b>	0,84	0,28	<b>0,38</b>	0,63	0,24	<b>0,33</b>	0,55	0,22	<b>0,30</b>	0,50	MH

At 4,00 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	0,45	<b>0,60</b>	0,94	0,32	<b>0,43</b>	0,68	0,24	<b>0,32</b>	0,51	0,21	<b>0,28</b>	0,44	0,19	<b>0,26</b>	0,40	MM
MH	0,59	<b>0,81</b>	1,36	0,43	<b>0,58</b>	0,97	0,32	<b>0,43</b>	0,72	0,28	<b>0,38</b>	0,63	0,25	<b>0,35</b>	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	0,59	<b>0,79</b>	1,24	0,43	<b>0,57</b>	0,89	0,32	<b>0,42</b>	0,66	0,28	<b>0,37</b>	0,58	0,25	<b>0,34</b>	0,53	MM
MH	0,77	<b>1,06</b>	1,79	0,56	<b>0,76</b>	1,28	0,42	<b>0,57</b>	0,95	0,36	<b>0,50</b>	0,83	0,33	<b>0,45</b>	0,76	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	0,81	<b>1,08</b>	1,71	0,58	<b>0,78</b>	1,22	0,43	<b>0,58</b>	0,91	0,38	<b>0,51</b>	0,79	0,35	<b>0,46</b>	0,72	MM
MH	1,06	<b>1,46</b>	2,48	0,76	<b>1,04</b>	1,75	0,57	<b>0,78</b>	1,30	0,50	<b>0,68</b>	1,13	0,45	<b>0,62</b>	1,03	MH

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