

■ 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%			
...43	0,46	<b>0,60</b>	0,93	0,33	<b>0,44</b>	0,67	0,25	<b>0,33</b>	0,50	0,22	<b>0,28</b>	0,44	0,20	<b>0,26</b>	0,40	...43
...TX	0,46	<b>0,70</b>	1,12	0,33	<b>0,50</b>	0,81	0,25	<b>0,38</b>	0,60	0,22	<b>0,33</b>	0,52	0,20	<b>0,30</b>	0,48	...TX

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%			
...43	0,54	<b>0,70</b>	1,08	0,39	<b>0,50</b>	0,78	0,29	<b>0,38</b>	0,58	0,25	<b>0,33</b>	0,50	0,23	<b>0,30</b>	0,46	...43
...TX	0,54	<b>0,81</b>	1,30	0,39	<b>0,58</b>	0,93	0,29	<b>0,43</b>	0,69	0,25	<b>0,38</b>	0,61	0,23	<b>0,35</b>	0,55	...TX

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%			
...43	0,70	<b>0,92</b>	1,42	0,51	<b>0,66</b>	1,02	0,38	<b>0,49</b>	0,76	0,33	<b>0,43</b>	0,66	0,30	<b>0,39</b>	0,60	...43
...TX	0,70	<b>1,06</b>	1,72	0,51	<b>0,76</b>	1,23	0,38	<b>0,57</b>	0,91	0,33	<b>0,50</b>	0,79	0,30	<b>0,45</b>	0,73	...TX

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%			
...43	0,96	<b>1,26</b>	1,97	0,69	<b>0,90</b>	1,40	0,52	<b>0,67</b>	1,04	0,45	<b>0,59</b>	0,90	0,41	<b>0,54</b>	0,83	...43
...TX	0,96	<b>1,46</b>	2,38	0,69	<b>1,04</b>	1,68	0,52	<b>0,78</b>	1,25	0,45	<b>0,68</b>	1,08	0,41	<b>0,62</b>	0,99	...TX

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

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