

Recommended Starting Speeds [m/min]

Chamfer Mills 30°, 45°, 60°

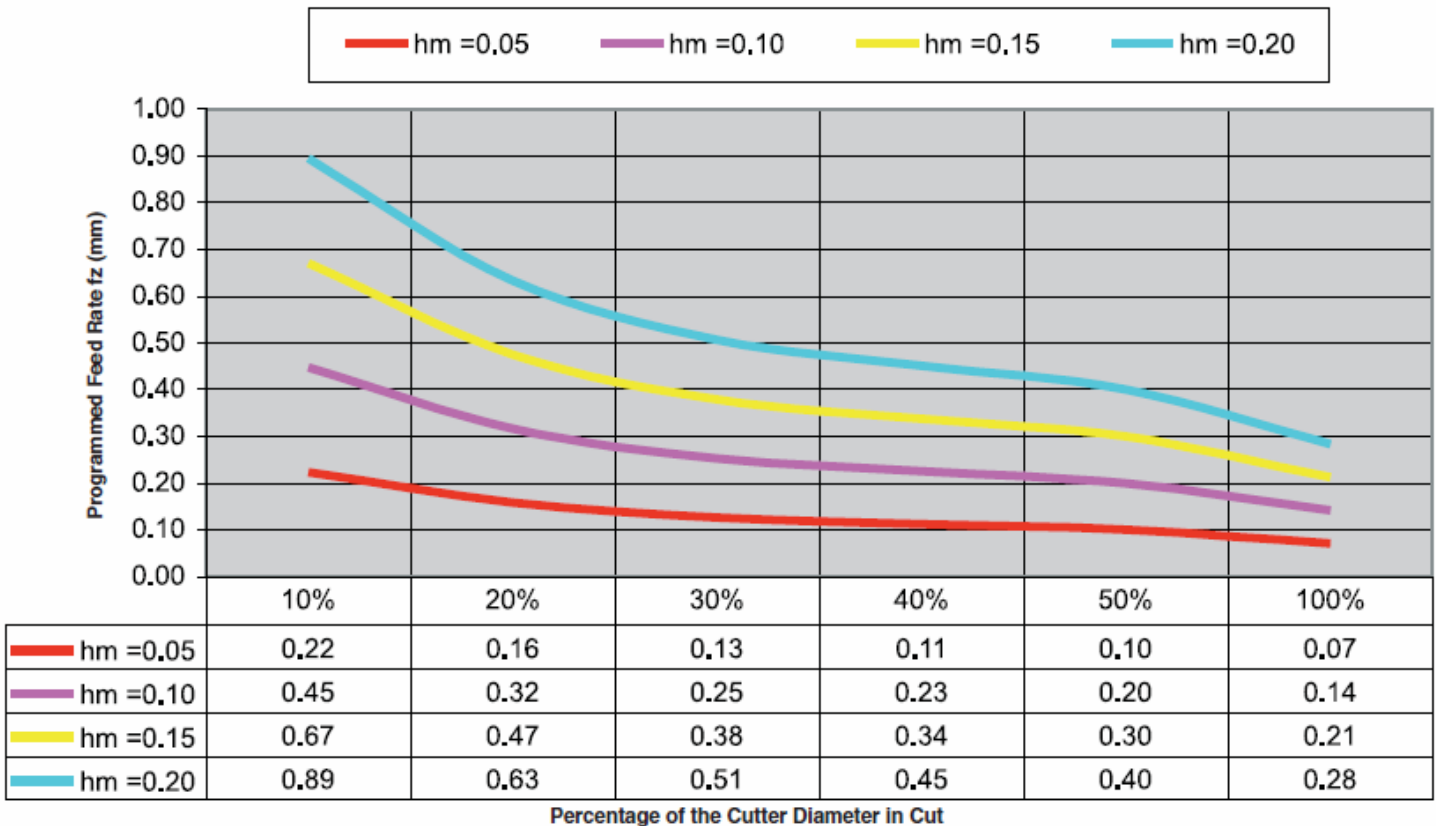
| Material Group | KC725M | | | KC735M | | | KC915M | | | KC935M | | |
|----------------|--------|------------|-----|--------|------------|-----|--------|------------|-----|--------|------------|-----|
| | | | | | | | | | | | | |
| P1 | 310 | 270 | 250 | | | | | | | 470 | 410 | 380 |
| P2 | 190 | 180 | 160 | | | | | | | 290 | 260 | 240 |
| P3 | 180 | 160 | 140 | | | | | | | 260 | 240 | 220 |
| P4 | 130 | 120 | 110 | | | | | | | 200 | 180 | 160 |
| P5 | 180 | 160 | 150 | | | | | | | 265 | 240 | 215 |
| P6 | 110 | 90 | | | | | | | | 160 | 140 | |
| M1 | 200 | 180 | 160 | 120 | 110 | 100 | | | | 310 | 270 | 250 |
| M2 | 180 | 170 | 150 | 110 | 100 | 90 | | | | 280 | 250 | 230 |
| M3 | 140 | 120 | | 80 | 70 | | | | | 210 | 180 | |
| K1 | 200 | 180 | 160 | | | | 440 | 400 | 350 | 310 | 280 | 250 |
| K2 | 160 | 140 | 130 | | | | 350 | 310 | 290 | 240 | 220 | 200 |
| K3 | 130 | 120 | 110 | | | | 290 | 260 | 240 | 200 | 180 | 170 |
| N1 | | | | | | | | | | | | |
| N2 | | | | | | | | | | | | |
| S1 | 40 | 40 | | | | | | | | | | |
| S2 | 40 | 40 | | | | | | | | | | |
| S3 | 50 | 50 | | | | | | | | | | |
| S4 | 60 | 50 | | | | | | | | | | |
| H1 | | | | | | | | | | | | |

FIRST choice starting speeds are in bold type.

As the average chip thickness value goes higher the speed should be decreased.

Recommended Starting Feeds

30°, 45° Approach Angle Feed-Per-Tooth Compensation
(Radial Width-of-Cut Dependent)



Percentage of the Cutter Diameter in Cut