

# Recommended Starting Speeds [m/min]

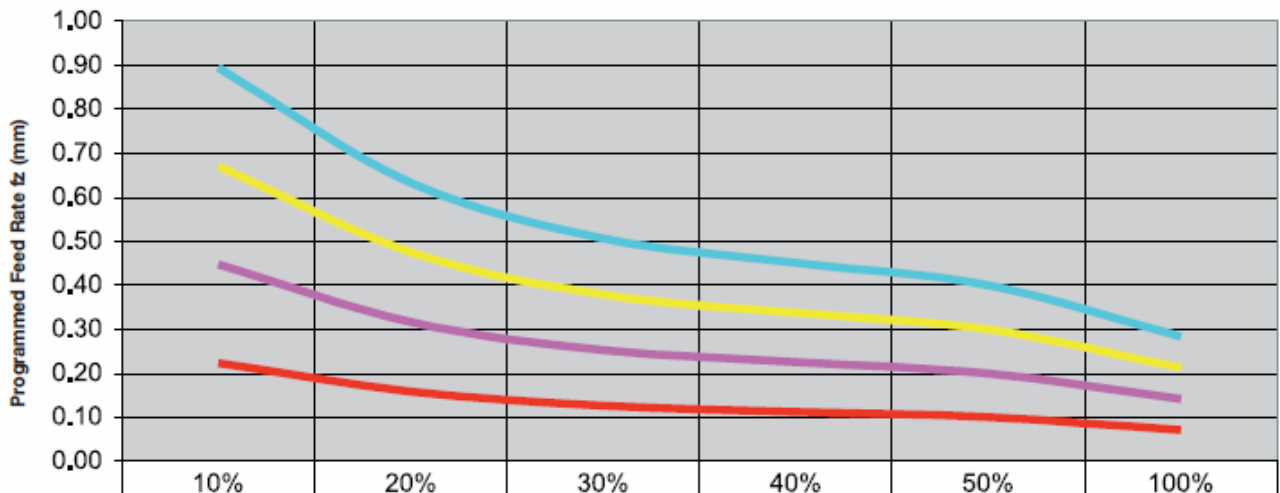
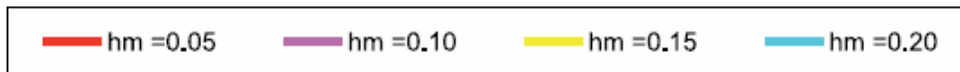
45° approach angle

Material Group	KC520M			KC522M			KC725M			KC915M			KC935M		
P1							310	<b>270</b>	250				470	<b>410</b>	380
P2							190	<b>180</b>	160				290	<b>260</b>	240
P3							180	<b>160</b>	140				260	<b>240</b>	220
P4				120	<b>110</b>	100	130	<b>120</b>	110				200	<b>180</b>	160
P5				155	<b>150</b>	135	180	<b>160</b>	150				265	<b>240</b>	215
P6				100	<b>80</b>		110	<b>90</b>					160	<b>140</b>	
M1				180	<b>160</b>	150	200	<b>180</b>	160				310	<b>270</b>	250
M2				170	<b>150</b>	140	180	<b>170</b>	150				280	<b>250</b>	230
M3				120	<b>110</b>		140	<b>120</b>					210	<b>180</b>	
K1	320	<b>290</b>	260				200	<b>180</b>	160	440	<b>400</b>	350	310	<b>280</b>	250
K2	250	<b>220</b>	210	240	<b>220</b>	200	160	<b>140</b>	130	350	<b>310</b>	290	240	<b>220</b>	200
K3	210	<b>190</b>	170	200	<b>180</b>	170	130	<b>120</b>	110	290	<b>260</b>	240	200	<b>180</b>	170
N1															
N2															
S1				40	<b>30</b>		40	<b>40</b>							
S2				30	<b>30</b>		40	<b>40</b>							
S3				40	<b>40</b>		50	<b>50</b>							
S4				50	<b>50</b>		60	<b>50</b>							
H1															

FIRST choice starting speeds are in bold type.  
The speed should be decreased as the average chip thickness increases.

# Recommended Starting Feeds

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



hm = 0.05	0.22	0.16	0.13	0.11	0.10	0.07
hm = 0.10	0.45	0.32	0.25	0.23	0.20	0.14
hm = 0.15	0.67	0.47	0.38	0.34	0.30	0.21
hm = 0.20	0.89	0.63	0.51	0.45	0.40	0.28

Percentage of the Cutter Diameter in Cut