

Recommended Starting Speeds [m/min]

90° approach angle

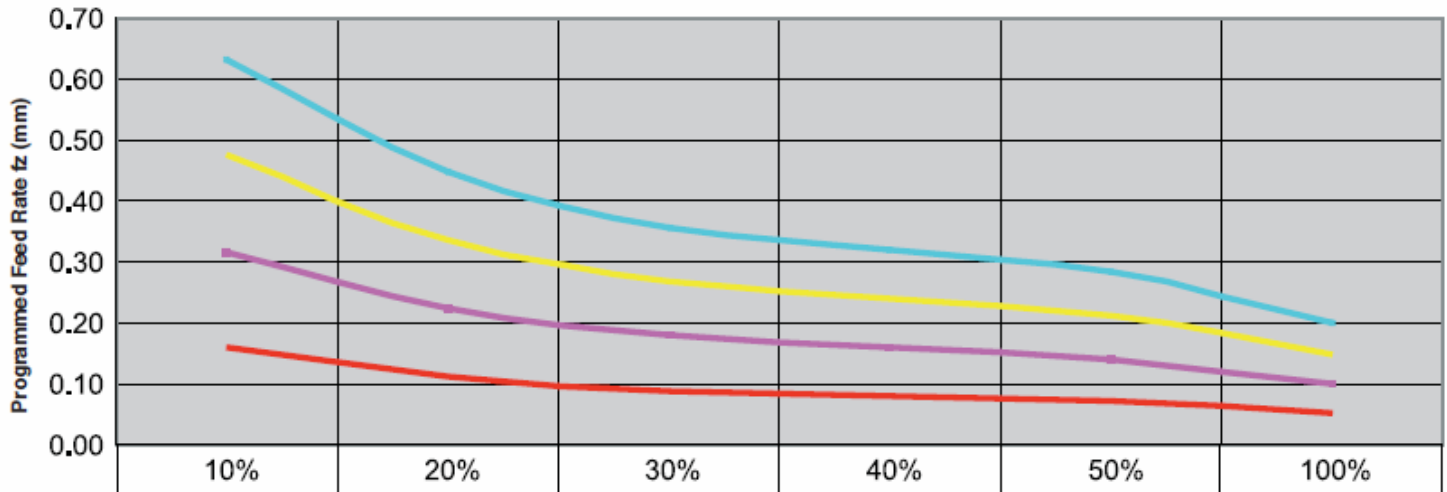
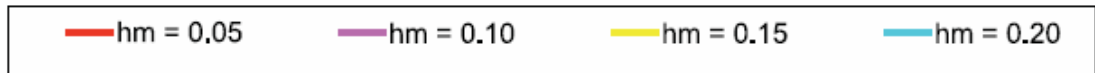
Material Group	KC410M			KC520M			KC725M			KC915M			KC935M			KT530M		
P1							260	230	210				390	340	320	290	250	230
P2							160	150	130				240	220	200	180	160	140
P3							150	130	120				220	200	180	160	140	130
P4							110	100	90				160	150	140	120	110	100
P5							125	110	100				225	200	180	165	149	130
P6							90	80					140	120		100	90	
M1							170	150	140				250	220	210	190	160	150
M2							150	140	130				230	210	190	170	150	140
M3							120	100					170	150		130	110	
K1				270	240	220	160	150	130	360	330	290	250	230	210			
K2				210	190	180	130	120	110	290	260	240	200	180	170			
K3				180	160	140	110	100	90	240	220	200	170	150	140			
N1	1210	1080	990															
N2																		
S1							40	30										
S2							30	30										
S3							40	40										
S4							50	50										
H1																		

FIRST choice starting speeds are in bold type.

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

Recommended Starting Feeds

90° Approach Angle Feed-Per-Tooth Compensation
(Radial Width-of-Cut Dependent)



hm = 0.05	0.16	0.11	0.09	0.08	0.07	0.05
hm = 0.10	0.32	0.22	0.18	0.16	0.14	0.10
hm = 0.15	0.47	0.34	0.27	0.24	0.21	0.15
hm = 0.20	0.63	0.45	0.36	0.32	0.28	0.20

Percentage of the Cutter Diameter in Cut