

Recommended Starting Speeds [m/min]

90° approach angle

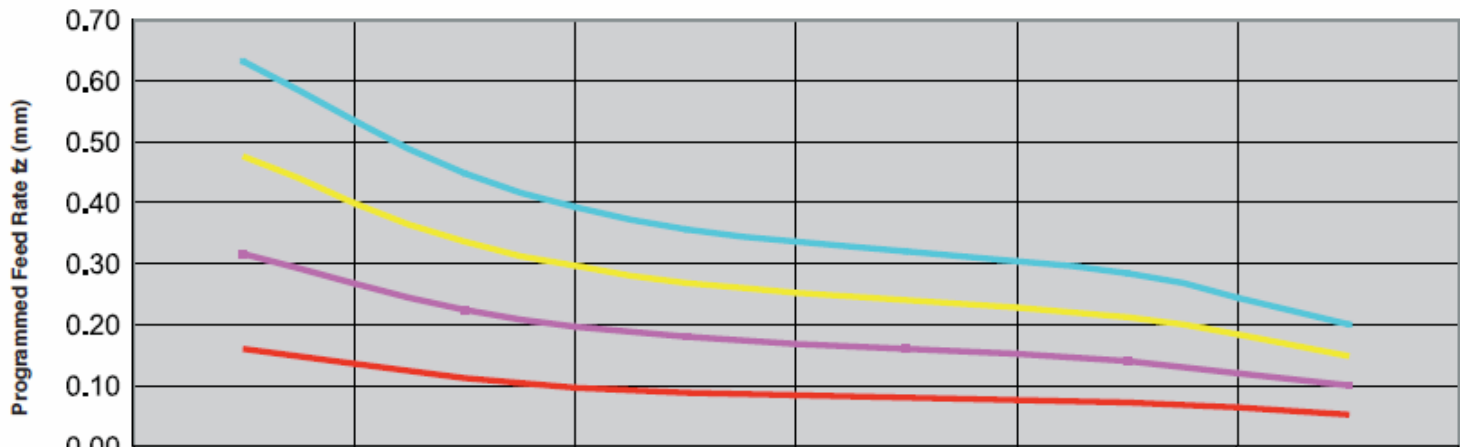
Material Group	KC410M			KC520M			KC522M			KC725M			KC915M			KC935M			KY3500		
P1										260	230	210				390	340	320			
P2										160	150	130				240	220	200			
P3										150	130	120				220	200	180			
P4							100	90	80	110	100	90				160	150	140			
P5							130	125	105	125	110	100				225	200	180			
P6							80	70		90	80					140	120				
M1							150	130	120	170	150	140				250	220	210			
M2							140	120	120	150	140	130				230	210	190			
M3							100	90		120	100					170	150				
K1				270	240	220				160	150	130	360	330	290	250	230	210	800	730	650
K2				210	190	180	200	180	170	130	120	110	290	260	240	200	180	170	630	570	530
K3				180	160	140	170	150	140	110	100	90	240	220	200	170	150	140	530	470	430
N1	1210	1080	990																		
N2																					
S1							30	30		40	30										
S2							30	30		30	30										
S3							40	40		40	40										
S4							50	40		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