Recommended Starting Speeds [m/min]

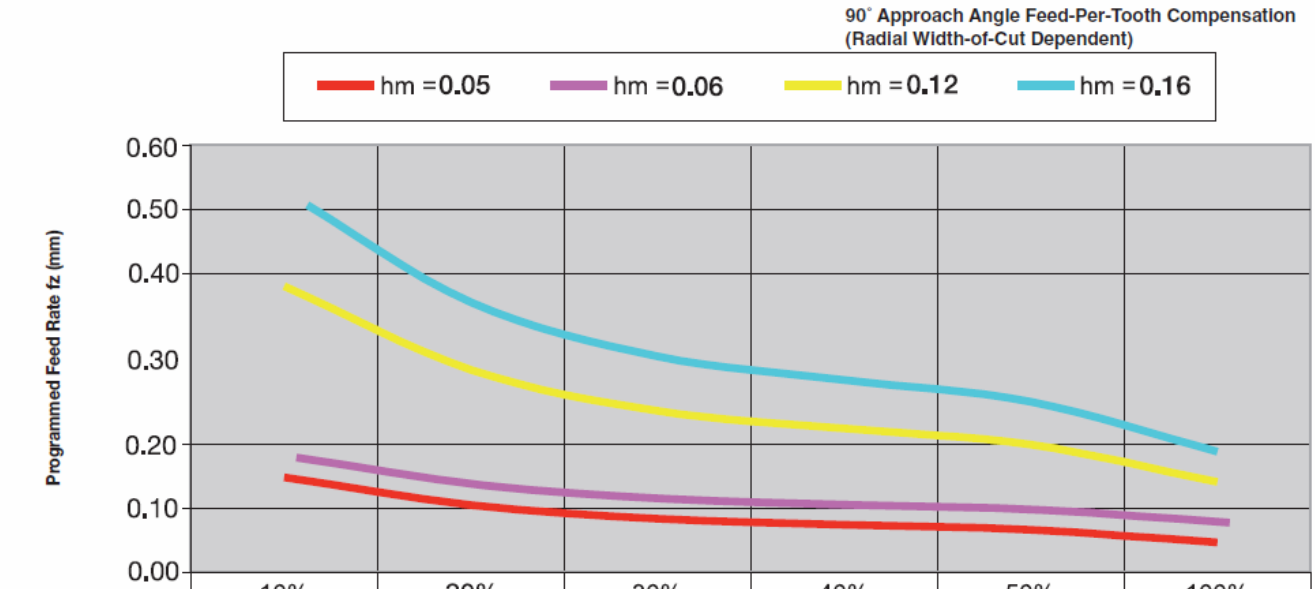
■ 90° approach angle

Material Group	KC410M			KC725M			KCPK30 KC935M		
P1				260	**230**	210	390	**340**	320
P2				160	**150**	130	240	**220**	200
P3				150	**130**	120	220	**200**	180
P4				110	**100**	90	160	**150**	140
P5				125	**110**	100	225	**200**	180
P6				90	**80**		140	**120**	
M1				170	**150**	140	250	**220**	210
M2				150	**140**	130	230	**210**	190
M3				120	**100**		170	**150**	
K1				160	**150**	130	250	**230**	210
K2				130	**120**	110	200	**180**	170
K3				110	**100**	90	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 value goes higher the speed should be decreased.

Recommended Starting Feeds



	10%	20%	30%	40%	50%	100%
hm =0.05	0.16	0.11	0.09	0.08	0.07	0.05
hm =0.06	0.19	0.13	0.11	0.10	0.08	0.06
hm =0.12	0.38	0.27	0.21	0.19	0.17	0.12
hm =0.16	0.51	0.36	0.29	0.25	0.23	0.16