

Insert Selection Guide

Material Group	Light Machining		General Purpose		Heavy Machining	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
N1-N2	.F..ALP	WN10HM	.F..ALP	WN10HM	.E..ALP	WN10HM
N3	.F..ALP	WN10HM	.F..ALP	WN10HM	.E..ALP	WN10HM

Recommended Starting Speeds [m/min]

Material Group	★ WN10HM		
	1	2950	1800
2	2950	1800	875
3	1600	850	480

NOTE: FIRST choice starting speeds are in **bold** type.
As the average chip thickness increases, the speed should be decreased.

Recommended Starting Feeds [mm]

Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry			
	Light Machining			General Purpose			Heavy Machining			Light Machining			General Purpose				Heavy Machining		
	5%	10%	20%	30%	40-100%	5%	10%	20%	30%	40-100%	5%	10%	20%	30%	40-100%				
.F..ALP	0,12	0,45	0,81	0,08	0,33	0,58	0,06	0,25	0,43	0,06	0,21	0,38	0,05	0,20	0,35	.F..ALP			
.E..ALP	0,15	0,50	0,92	0,11	0,36	0,66	0,08	0,27	0,50	0,07	0,24	0,43	0,07	0,22	0,40	.E..ALP			

NOTE: Use "Light Machining" values as starting feed rate.

★ = ALL-STAR PORTFOLIO PRODUCT. ALL-STAR PRODUCTS ARE PROVEN SOLUTIONS THAT ARE ALWAYS AVAILABLE.

★ INDEXABLE MILLING

★ SOLID END MILLING

★ HOLEMAKING

★ TAPPING

★ TURNING