

Recommended Starting Speeds [m/min]*

Material Group		WP25PM			WP40PM			WS40PM		
P	1	395	340	325	355	310	295	-	-	-
	2	330	290	240	300	260	215	-	-	-
	3	305	260	210	275	235	190	-	-	-
	4	270	220	180	245	205	160	-	-	-
	5	220	205	180	205	185	160	205	175	145
	6	200	150	120	180	140	110	180	130	95
M	1	245	215	200	235	205	185	250	205	170
	2	220	190	155	210	180	150	215	175	145
	3	170	145	115	155	140	110	175	130	100
S	1	50	40	30	50	40	35	50	40	30
	2	50	40	30	50	40	35	50	40	30
	3	60	50	30	60	50	35	60	50	30
	4	85	60	40	80	60	40	70	60	35

NOTE: FIRST choice starting speeds are in **bold** type. As the average chip thickness increases, the speed should be decreased.
 *Material groups P, M, K, and H show recommended starting speeds for dry machining. For wet machining, reduce speed by 20%.
 *Material groups N and S show recommended starting speeds for wet machining. Not recommended for dry machining.

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining
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At 1,30 Axial Depth of Cut (AP1)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%		10%		20%		30%		40-100%							
.E..MM	0,49	1,59	2,52	0,35	1,13	1,78	0,26	0,84	1,31	0,23	0,73	1,14	0,21	0,67	1,04	.E..MM
.S..MH	0,70	1,80	2,76	0,51	1,28	1,94	0,38	0,95	1,44	0,33	0,83	1,25	0,30	0,76	1,14	.S..MH

At 1,70 Axial Depth of Cut (AP1)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%		10%		20%		30%		40-100%							
.E..MM	0,43	1,39	2,20	0,31	0,99	1,56	0,23	0,74	1,15	0,20	0,64	1,00	0,19	0,59	0,92	.E..MM
.S..MH	0,62	1,57	2,41	0,45	1,12	1,70	0,33	0,84	1,26	0,29	0,73	1,10	0,27	0,67	1,00	.S..MH

At 2,50 Axial Depth of Cut (AP1)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%		10%		20%		30%		40-100%							
.E..MM	0,36	1,15	1,81	0,26	0,83	1,29	0,19	0,62	0,96	0,17	0,54	0,83	0,15	0,49	0,76	.E..MM
.S..MH	0,51	1,30	1,99	0,37	0,93	1,41	0,28	0,70	1,05	0,24	0,61	0,91	0,22	0,55	0,83	.S..MH

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

