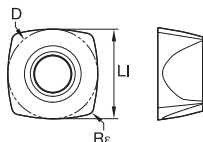


- ◆◆ first choice with coolant
- ◇◇ first choice without coolant
- ◆ alternate choice with coolant
- ◇ alternate choice without coolant



P1-P2					◇/◆		◇◇	◆◆		
P3-P4		◇/◆	◇	◇			◇◇	◆◆		
P5-P6		◇/◆		◇			◇	◆◆	◇◇	◇/◆
M1-M2								◇◇		◆
M3								◆		◆◆
K1-K2							◇◇	◇	◆◆	
K3		◇/◆	◇				◇◇	◇	◆◆	
N1	◆◆									
N2	◆◆									
S1								◆		◆◆
S2								◆		◆◆
S3								◆◆		◆
S4								◆◆		◆



ISO catalog number	ANSI catalog number	D mm	LI mm	Re mm													
Light Machining																	
XDPT120512ERD411	XDPT120512ERD411	12,70	.500	12,70	.500	1,2	.047	-	-	-	-	6187808	-	-	-	-	-



General Machining																	
XDLT120508ERD41	XDLT120508ERD41	12,70	.500	12,70	.500	0,8	.031	-	-	-	-	6441067	-	5652729	5654220	-	5653930
XDLT120508ERD721	XDLT120508ERD721	12,70	.500	12,70	.500	0,8	.031	5656252	-	-	-	-	-	-	-	-	-
XDPT120508ERD41	XDPT120508ERD41	12,70	.500	12,70	.500	0,8	.031	-	-	-	-	6187806	-	6010774	6010773	-	6010772
XDLT120512ERD411	XDLT120512ERD411	12,70	.500	12,70	.500	1,2	.047	-	-	-	-	6441068	-	-	5652899	-	5652248
XDPT120515SRGP	XDPT120515SRGP	12,70	.500	12,70	.500	1,5	.059	-	6074030	6074028	6074027	-	-	-	-	-	-



Heavy Machining																	
XDLW120508SRD	XDLW120508SRD	12,70	.500	12,70	.500	0,8	.031	-	-	-	-	-	5656214	-	-	5651223	5655109
XDPW120515SRD	XDPW120515SRD	12,70	.500	12,70	.500	1,5	.058	-	-	6033255	6033254	-	-	-	-	-	-

XDL...: Ground inserts; high versatility for machining soft materials and difficult-to-machine stainless steels and high-temp alloys.
 XDP...: Pressed; lower cost per edge for most roughing to semi-finishing operations.

- .E..D721: First choice for non-ferrous alloys.
- .E.D41: General purpose in soft steels. Best fit for face milling and slotting operations.
- .E.D411: General purpose in stainless steel and high-temp alloys. Best fit for pocketing and profiling operations in general, also in combination with long overhangs.
- .S..D: First choice for roughing alloyed steel and cast iron.
- .S.GP: General use on alloyed steels. Good balance across all machining situations.

■ Recommended Starting Feeds [IPT] • High-Feed

Light Machining	General Purpose	Heavy Machining
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At .100 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40-100%			
.E..D721	.011	.041	.066	.008	.029	.047	.006	.022	.035	.005	.019	.030	.005	.017	.028	.E..D721
.E..D41	.014	.046	.072	.010	.033	.051	.008	.024	.038	.007	.021	.033	.006	.019	.030	.E..D41
.E..D411	.014	.046	.072	.010	.033	.051	.008	.024	.038	.007	.021	.033	.006	.019	.030	.E..D411
.S..GP	.020	.051	.077	.015	.036	.055	.011	.027	.041	.009	.024	.035	.009	.022	.032	.S..GP
.S..D	.020	.051	.077	.015	.036	.055	.011	.027	.041	.009	.024	.036	.009	.022	.032	.S..D

At .070 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40-100%			
.E..D721	.013	.048	.078	.010	.035	.056	.007	.026	.041	.006	.022	.036	.006	.021	.033	.E..D721
.E..D41	.017	.054	.086	.012	.039	.061	.009	.029	.045	.008	.025	.039	.007	.023	.036	.E..D41
.E..D411	.017	.054	.086	.012	.039	.061	.009	.029	.045	.008	.025	.039	.007	.023	.036	.E..D411
.S..GP	.024	.061	.092	.017	.043	.065	.013	.032	.048	.011	.028	.042	.010	.026	.038	.S..GP
.S..D	.024	.061	.092	.017	.043	.065	.013	.032	.048	.011	.028	.042	.010	.026	.038	.S..D

At .055 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40-100%			
.E..D721	.015	.054	.088	.011	.039	.063	.008	.029	.046	.007	.025	.040	.007	.023	.037	.E..D721
.E..D41	.019	.061	.097	.014	.044	.069	.010	.033	.051	.009	.028	.044	.008	.026	.040	.E..D41
.E..D411	.019	.061	.097	.014	.044	.069	.010	.033	.051	.009	.028	.044	.008	.026	.040	.E..D411
.S..GP	.027	.068	.104	.019	.049	.073	.014	.036	.054	.013	.031	.047	.012	.029	.043	.S..GP
.S..D	.027	.068	.104	.019	.049	.074	.014	.036	.054	.013	.031	.047	.012	.029	.043	.S..D

■ Feed Rate Guide • Plunging • IC 12 • fz [in/tooth]

Insert Geometry	Programmed Feed per Tooth (fz) Max .354" insert engagement (ae radial engagement)			Insert Geometry
.E..D721	.002		.008	.E..D721
.E..D41	.003		.009	.E..D41
.E..D411	.003		.009	.E..D411
.S..GP	.004		.010	.S..GP
.S..D	.004		.010	.S..D



■ Recommended Starting Feeds [mm] • High-Feed

Light Machining	General Purpose	Heavy Machining
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At 2,50 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40-100%			
.E..D721	0,28	1,02	1,65	0,21	0,73	1,18	0,15	0,55	0,88	0,13	0,48	0,76	0,12	0,44	0,70	.E..D721
.E..D41	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..D41
.E..D411	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..D411
.S..GP	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..GP
.S..D	0,51	1,30	1,95	0,37	0,93	1,38	0,28	0,70	1,03	0,24	0,61	0,89	0,22	0,55	0,82	.S..D

At 1,70 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40-100%			
.E..D721	0,34	1,23	2,00	0,25	0,88	1,42	0,19	0,66	1,05	0,16	0,57	0,92	0,15	0,52	0,84	.E..D721
.E..D41	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..D41
.E..D411	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..D411
.S..GP	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..GP
.S..D	0,62	1,57	2,36	0,45	1,12	1,67	0,33	0,84	1,24	0,29	0,73	1,08	0,27	0,67	0,98	.S..D

At 1,30 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40-100%			
.E..D721	0,39	1,41	2,29	0,28	1,01	1,62	0,21	0,75	1,20	0,18	0,65	1,04	0,17	0,60	0,96	.E..D721
.E..D41	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..D41
.E..D411	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..D411
.S..GP	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..GP
.S..D	0,70	1,80	2,71	0,51	1,28	1,90	0,38	0,95	1,41	0,33	0,83	1,22	0,30	0,76	1,12	.S..D

■ Feed Rate Guide • Plunging • IC 12 • fz [mm/tooth]

Insert Geometry	Programmed Feed per Tooth (fz)			Insert Geometry
	Max 9mm insert engagement (ae radial engagement)			
.E..D721	0,06			.E..D721
.E..D41	0,07			.E..D41
.E..D411	0,07			.E..D411
.S..GP	0,10			.S..GP
.S..D	0,10			.S..D

Material Group		GH2			KC522M			KCPK30			KCPM40			KCSM40		
P	1	-	-	-	1295	1115	1065	1790	1560	1460	1165	1015	970	-	-	-
	2	-	-	-	1085	950	785	1100	1000	900	985	855	705	-	-	-
	3	-	-	-	1000	855	690	1000	900	805	900	770	625	-	-	-
	4	-	-	-	885	720	590	755	690	625	805	675	525	-	-	-
	5	-	-	-	720	675	590	1015	900	820	675	605	525	675	575	475
	6	-	-	-	655	490	395	625	525	475	590	460	360	590	425	310
M	1	-	-	-	805	705	655	805	720	605	770	675	605	820	675	560
	2	-	-	-	720	625	510	720	625	560	690	590	490	705	575	475
	3	-	-	-	560	475	375	575	510	460	510	460	360	575	425	330
K	1	985	720	475	900	805	720	1165	1050	950	-	-	-	-	-	-
	2	855	625	410	705	625	590	920	820	755	-	-	-	-	-	-
	3	720	575	395	590	525	475	770	690	625	-	-	-	-	-	-
N	1	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	1	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	4	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
H	1	-	-	-	475	360	280	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

Material Group		SC3025			SC6525			SP6519			X400			X500		
P	1	-	-	-	1460	1000	560	1165	855	510	1015	755	475	1065	785	510
	2	-	-	-	1280	885	475	1015	755	460	900	675	410	950	705	460
	3	-	-	-	1150	785	410	900	655	395	785	590	375	820	605	395
	4	-	-	-	820	575	310	690	490	295	590	425	280	625	475	295
	5	-	-	-	625	475	310	560	410	280	-	-	-	510	395	280
	6	-	-	-	560	395	230	475	330	195	-	-	-	425	310	195
M	1	-	-	-	785	705	560	1065	770	460	-	-	-	985	720	460
	2	-	-	-	755	625	475	920	675	410	-	-	-	870	625	395
	3	-	-	-	575	510	360	770	560	330	-	-	-	705	510	310
K	1	1560	1085	590	1540	1065	575	1165	870	560	-	-	-	1015	870	675
	2	1310	900	475	1200	820	460	950	690	425	-	-	-	870	705	510
	3	1085	755	410	-	-	-	870	625	395	-	-	-	675	560	395
N	1	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	1	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	4	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
H	1	-	-	-	-	-	-	-	-	-	375	280	180	-	-	-
	2	-	-	-	-	-	-	-	-	-	310	230	130	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

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

Dry
 Wet



Material Group		GH2			KC522M			KCPK30			KCPM40			KCSM40		
P	1	-	-	-	1035	890	850	1430	1250	1170	930	810	775	-	-	-
	2	-	-	-	870	760	630	880	800	720	790	685	565	-	-	-
	3	-	-	-	800	685	550	800	720	645	720	615	500	-	-	-
	4	-	-	-	710	575	470	605	550	500	645	540	420	-	-	-
	5	-	-	-	575	540	470	810	720	655	540	485	420	540	460	380
	6	-	-	-	525	390	315	500	420	385	470	370	290	470	340	250
M	1	-	-	-	645	565	525	645	575	485	615	540	485	655	540	450
	2	-	-	-	575	500	410	575	500	450	550	470	390	565	460	380
	3	-	-	-	450	380	300	460	410	370	410	370	290	460	340	265
K	1	790	575	380	720	645	575	930	840	760	-	-	-	-	-	-
	2	685	500	330	565	500	470	735	655	605	-	-	-	-	-	-
	3	575	460	315	470	420	380	615	550	500	-	-	-	-	-	-
N	1	3780	2980	1260	-	-	-	-	-	-	-	-	-	-	-	-
	2	3780	2980	1260	-	-	-	-	-	-	-	-	-	-	-	-
	3	2785	2295	930	-	-	-	-	-	-	-	-	-	-	-	-
S	1	-	-	-	130	105	80	-	-	-	130	105	90	130	105	80
	2	-	-	-	130	105	80	-	-	-	130	105	90	130	105	80
	3	-	-	-	155	130	80	-	-	-	155	130	90	155	130	80
	4	-	-	-	225	155	105	210	155	105	210	155	105	185	155	90
H	1	-	-	-	380	290	225	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

Material Group		SC3025			SC6525			SP6519			X400			X500		
P	1	-	-	-	1170	800	450	930	685	410	810	605	380	850	630	410
	2	-	-	-	1025	710	380	810	605	370	720	540	330	760	565	370
	3	-	-	-	920	630	330	720	525	315	630	470	300	655	485	315
	4	-	-	-	655	460	250	550	390	235	470	340	225	500	380	235
	5	-	-	-	500	380	250	450	330	225	-	-	-	410	315	225
	6	-	-	-	450	315	185	380	265	155	-	-	-	340	250	155
M	1	-	-	-	630	565	450	850	615	370	-	-	-	790	575	370
	2	-	-	-	605	500	380	735	540	330	-	-	-	695	500	315
	3	-	-	-	460	410	290	615	450	265	-	-	-	565	410	250
K	1	1250	870	470	1230	850	460	930	695	450	-	-	-	810	695	540
	2	1050	720	380	960	655	370	760	550	340	-	-	-	695	565	410
	3	870	605	330	-	-	-	695	500	315	-	-	-	540	450	315
N	1	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	1	-	-	-	-	-	-	170	130	80	-	-	-	155	105	80
	2	-	-	-	-	-	-	155	105	65	-	-	-	145	105	65
	3	-	-	-	-	-	-	170	130	80	-	-	-	155	130	80
	4	-	-	-	-	-	-	250	185	120	-	-	-	235	170	105
H	1	-	-	-	-	-	-	-	-	-	300	225	145	-	-	-
	2	-	-	-	-	-	-	-	-	-	250	185	105	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

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

Dry
 Wet

Material Group		GH2			KC522M			KCPK30			KCPM40			KCSM40		
P	1	-	-	-	395	340	325	545	475	445	355	310	295	275	240	205
	2	-	-	-	330	290	240	335	305	275	300	260	215	240	205	160
	3	-	-	-	305	260	210	305	275	245	275	235	190	205	180	160
	4	-	-	-	270	220	180	230	210	190	245	205	160	180	160	145
	5	-	-	-	220	205	180	310	275	250	205	185	160	160	145	125
	6	-	-	-	200	150	120	190	160	145	180	140	110	125	110	90
M	1	-	-	-	245	215	200	245	220	185	235	205	185	275	220	180
	2	-	-	-	220	190	155	220	190	170	210	180	150	180	145	125
	3	-	-	-	170	145	115	175	155	140	155	140	110	145	125	110
K	1	300	220	145	275	245	220	355	320	290	-	-	-	-	-	-
	2	260	190	125	215	190	180	280	250	230	-	-	-	-	-	-
	3	220	175	120	180	160	145	235	210	190	-	-	-	-	-	-
N	1	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	1	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	4	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
H	1	-	-	-	145	110	85	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

Material Group		SC3025			SC6525			SP6519			X400			X500		
P	1	-	-	-	445	305	170	355	260	155	310	230	145	325	240	155
	2	-	-	-	390	270	145	310	230	140	275	205	125	290	215	140
	3	-	-	-	350	240	125	275	200	120	240	180	115	250	185	120
	4	-	-	-	250	175	95	210	150	90	180	130	85	190	145	90
	5	-	-	-	190	145	95	170	125	85	-	-	-	155	120	85
	6	-	-	-	170	120	70	145	100	60	-	-	-	130	95	60
M	1	-	-	-	240	215	170	325	235	140	-	-	-	300	220	140
	2	-	-	-	230	190	145	280	205	125	-	-	-	265	190	120
	3	-	-	-	175	155	110	235	170	100	-	-	-	215	155	95
K	1	475	330	180	470	325	175	355	265	170	-	-	-	310	265	205
	2	400	275	145	365	250	140	290	210	130	-	-	-	265	215	155
	3	330	230	125	-	-	-	265	190	120	-	-	-	205	170	120
N	1	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	1	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	4	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
H	1	-	-	-	-	-	-	-	-	-	115	85	55	-	-	-
	2	-	-	-	-	-	-	-	-	-	95	70	40	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

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

Dry
 Wet



Material Group		GH2			KC522M			KCPK30			KCPM40			KCSM40		
P	1	-	-	-	315	270	260	435	380	355	285	250	235	-	-	-
	2	-	-	-	265	230	190	270	245	220	240	210	170	-	-	-
	3	-	-	-	245	210	170	245	220	195	220	190	150	-	-	-
	4	-	-	-	215	175	145	185	170	150	195	165	130	-	-	-
	5	-	-	-	175	165	145	250	220	200	165	150	130	165	140	115
	6	-	-	-	160	120	95	150	130	120	145	110	90	145	105	75
M	1	-	-	-	195	170	160	195	175	150	190	165	150	200	165	135
	2	-	-	-	175	150	125	175	150	135	170	145	120	170	140	115
	3	-	-	-	135	115	90	140	125	110	125	110	90	140	105	80
K	1	240	175	115	220	195	175	285	255	230	-	-	-	-	-	-
	2	210	150	100	170	150	145	225	200	185	-	-	-	-	-	-
	3	175	140	95	145	130	115	190	170	150	-	-	-	-	-	-
N	1	1150	910	385	-	-	-	-	-	-	-	-	-	-	-	-
	2	1150	910	385	-	-	-	-	-	-	-	-	-	-	-	-
	3	850	700	285	-	-	-	-	-	-	-	-	-	-	-	-
S	1	-	-	-	40	30	25	-	-	-	40	30	30	40	30	25
	2	-	-	-	40	30	25	-	-	-	40	30	30	40	30	25
	3	-	-	-	50	40	25	-	-	-	50	40	30	50	40	25
	4	-	-	-	70	50	30	65	50	30	65	50	30	55	50	30
H	1	-	-	-	115	90	70	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

Material Group		SC3025			SC6525			SP6519			X400			X500		
P	1	355	245	135	445	305	170	285	210	125	250	185	115	260	190	125
	2	310	215	115	390	270	145	250	185	110	220	165	100	230	170	110
	3	280	190	100	350	240	125	220	160	95	190	145	90	200	150	95
	4	200	140	75	250	175	95	170	120	70	145	105	70	150	115	70
	5	150	115	75	190	145	95	135	100	70	-	-	-	125	95	70
	6	135	95	55	170	120	70	115	80	50	-	-	-	105	75	50
M	1	190	170	135	240	215	170	260	190	110	-	-	-	240	175	110
	2	185	150	115	230	190	145	225	165	100	-	-	-	210	150	95
	3	140	125	90	175	155	110	190	135	80	-	-	-	170	125	75
K	1	375	260	140	470	325	175	285	210	135	-	-	-	250	210	165
	2	290	200	110	365	250	140	230	170	105	-	-	-	210	170	125
	3	-	-	-	-	-	-	210	150	95	-	-	-	165	135	95
N	1	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	1	-	-	-	-	-	-	50	40	25	-	-	-	50	30	25
	2	-	-	-	-	-	-	50	30	20	-	-	-	45	30	20
	3	-	-	-	-	-	-	50	40	25	-	-	-	50	40	25
	4	-	-	-	-	-	-	75	55	35	-	-	-	70	50	30
H	1	-	-	-	-	-	-	-	-	-	90	70	45	-	-	-
	2	-	-	-	-	-	-	-	-	-	75	55	30	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

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

Dry
 Wet