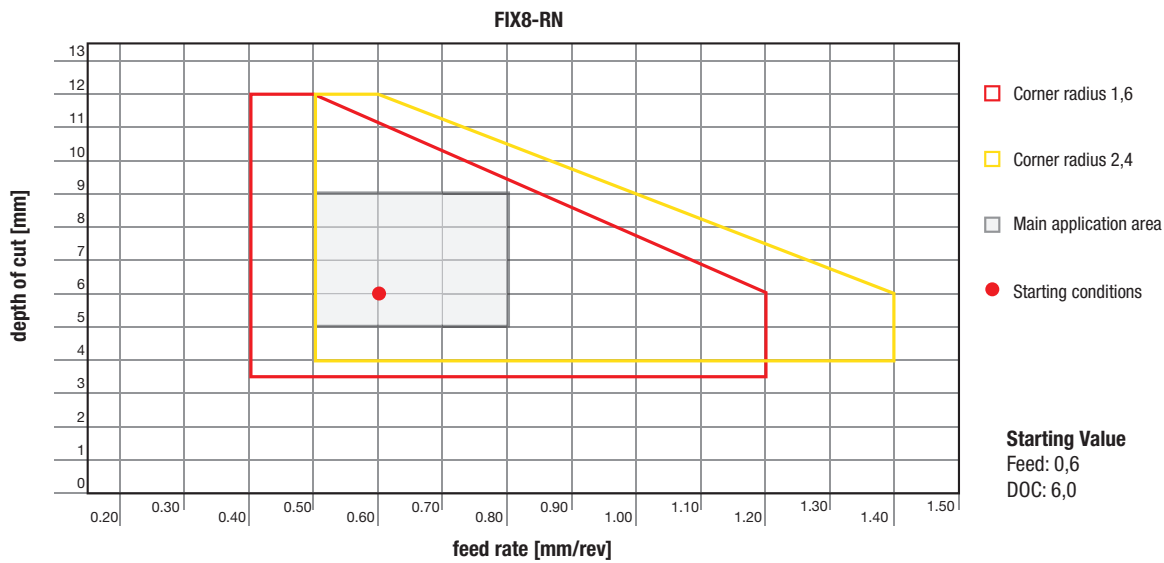
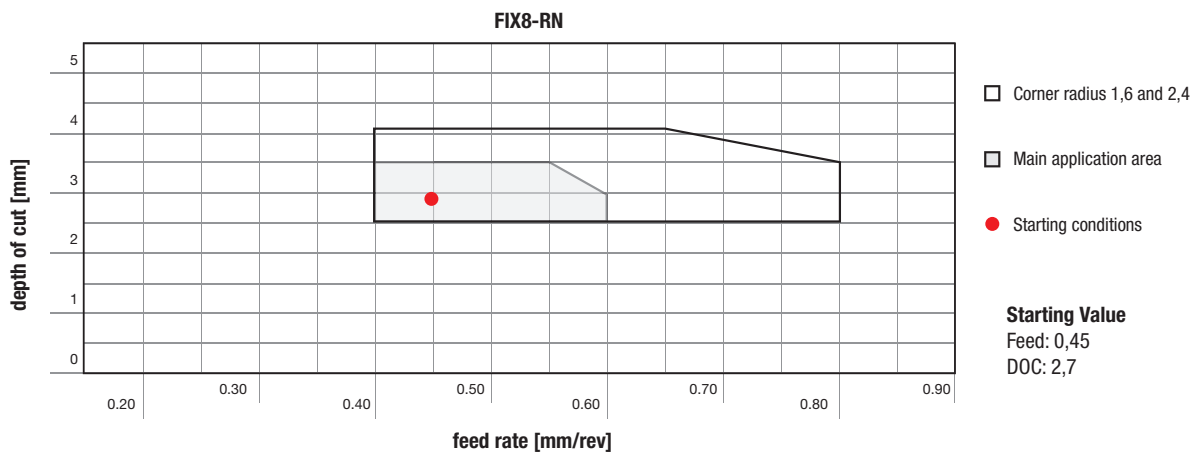


**FIX8™ • APPLICATION DATA • FEED & DEPTH OF CUT • LONGITUDINAL TURNING**



NOTE: For the 25mm toolholders, KM50 and PSC50, it is recommended to not surpass 80% of the maximum depth of cut or the maximum feed rate due to toolholder stability.

**FIX8 • APPLICATION DATA • FEED & DEPTH OF CUT • FACE TURNING**



NOTE: For the 25mm toolholders, KM50 and PSC50, it is recommended to not surpass 80% of the maximum depth of cut or the maximum feed rate due to toolholder stability.

**FIX8 • APPLICATION DATA • SPEED**

Material Group		KCPK05			KCP10B			KCP25B			KCP40B		
		Speed - m/min											
		min	Starting Value	max	min	Starting Value	max	min	Starting Value	max	min	Starting Value	max
P	0-1	125	285	320	100	275	315	95	195	250	90	145	170
	2	125	170	280	125	185	245	95	135	225	90	105	160
	3	125	135	195	120	135	175	95	110	160	70	85	120
	4	65	110	145	65	100	140	50	75	125	35	65	100
	5	105	160	190	105	150	210	85	135	190	75	95	105
	6	105	135	190	75	125	190	75	105	155	55	75	100
M	1	-	-	-	-	-	-	-	-	-	55	85	95
	2	-	-	-	-	-	-	-	-	-	55	75	90
	3	-	-	-	-	-	-	-	-	-	55	65	95
K	1	215	270	460	180	235	460	180	215	430	-	-	-
	2	110	235	290	110	215	270	110	200	250	-	-	-
	3	120	195	270	125	195	270	125	190	250	-	-	-