Proper feed rates for round inserts are dependent on the depth of cut.

For general profiling applications the nominal depth of cut noted below is one-half the theoretical maximum depth of cut for the insert.

The recommended feed values shown are for general profiling applications, at the nominal depths of cut shown – not the theoretical maximum depth of cut for the insert.

For depths of cut greater than the nominal depth of cut the feed values shown should be decreased; for smaller depths of cut the feed should be increased.

Insert Size	Theoretical Max Depth of Cut	Nominal Depth of Cut	Application	Recommended feed per insert f_z (inches) at Nominal Depth of Cut
5mm	.098	.049	Light / Medium	.004 (.002-.008)
7mm	.138	.069	Light / Medium	.005 (.003-.009)
8mm	.157	.078	Light	.004 (.002-.008)
			Medium	.006 (.003-.010)
			Roughing	.007 (.004-.012)
10mm	.197	.098	Light	.005 (.002-.008)
			Medium	.007 (.003-.010)
			Roughing	.008 (.004-.014)
12mm	.236	.118	Light	.006 (.003-.010)
			Medium	.008 (.004-.012)
			Roughing	.009 (.005-.015)
16mm	.315	.157	Light	.007 (.004-.010)
			Medium	.008 (.004-.014)
			Roughing	.010 (.006-.018)