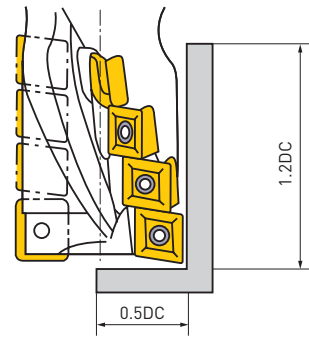
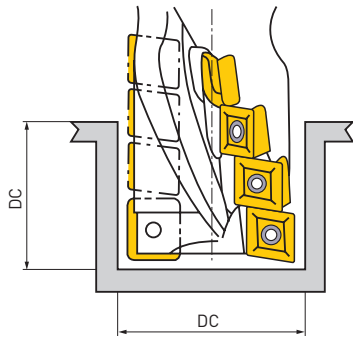


RECOMMENDED CUTTING CONDITIONS

Cutting Mode A : Slot Milling (Standard Cutting Length Type)

Cutting Mode B : Shoulder Milling (Standard Cutting Length Type)



Material	Hardness	Grade	Cutting Mode	Cutting Speed (m/min)	Table Feed (mm/min)		
					φ 25 mm	φ 32 mm	φ 40 mm
P Mild Steel	≤ 180HB	VP15TF	A	180 (100-250)	120 (100-140)	120 (100-140)	120 (100-140)
			B	180 (100-250)	200 (180-220)	200 (180-220)	230 (200-250)
Carbon Steel Alloy Steel	180-280HB	VP15TF	A	180 (100-250)	120 (100-140)	120 (100-140)	140 (120-150)
			B	180 (100-250)	150 (120-180)	150 (120-180)	180 (150-200)
	280-350HB	VP15TF	A	180 (100-250)	100 (80-120)	100 (80-120)	130 (100-150)
			B	180 (100-250)	120 (100-140)	120 (100-140)	150 (120-180)
High Alloy Steel	200-280HB	VP15TF	A	140 (100-180)	100 (80-120)	100 (80-120)	130 (100-150)
			B	140 (100-180)	120 (100-140)	120 (100-140)	150 (120-180)
M Stainless Steel	≤200HB	VP15TF	A	150 (100-200)	70 (50-90)	70 (50-90)	70 (50-90)
			B	150 (100-200)	100 (80-120)	100 (80-120)	120 (100-140)
K Cast Iron	Tensile Strength ≤450MPa	VP15TF	A	160 (100-220)	200 (180-220)	200 (180-220)	230 (200-250)
			B	160 (100-220)	230 (200-250)	230 (200-250)	260 (240-280)