

## RECOMMENDED CUTTING CONDITIONS

	Work Material	Grade	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)	l/d
<b>P</b>	Carbon Steel, Alloy Steel 180–350HB	<b>NX2525</b>	80 (40–120)	0.03 (0.01–0.05)	0.2 (0.1–0.3)	3–5
<b>M</b>	Stainless Steel ≤200HB	<b>VP15TF</b>	80 (40–120)	0.03 (0.01–0.05)	0.2 (0.1–0.3)	3–5
<b>K</b>	Cast Iron ≤350MPa	<b>VP15TF</b>	80 (40–120)	0.03 (0.01–0.05)	0.2 (0.1–0.3)	3–5
<b>N</b>	Non-Ferrous Material	<b>VP15TF</b>	120 (80–160)	0.05 (0.01–0.08)	0.4 (0.1–0.6)	3–5
		<b>MD220</b>	120 (80–160)	0.05 (0.01–0.08)	0.4 (0.1–0.6)	3–5
<b>H</b>	Heat Treated Steel 35–65HRC	<b>MB810</b>	80 (40–120)	0.03 (0.01–0.05)	0.1 (0.03–0.2)	3–5