

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed per Tooth (mm/tooth)	Cutting Mode	
P Alloy Tool Steel (ASTM D2)	≤250HB	VP20RT VP30RT	160 (120—200)	0.12 (0.08—0.2)	A	
				0.2 (0.1—0.4)	B	
				0.15 (0.1—0.3)	C	
	Alloy Tool Steel	≤250HB	VP20RT VP30RT	200 (160—250)	0.2 (0.1—0.3)	A
					0.3 (0.1—0.4)	B
					0.2 (0.1—0.4)	C
Cast Tool Steel	≤235HB	VP20RT	200 (160—250)	0.2 (0.1—0.3)	A	
				0.3 (0.1—0.4)	B	
				0.2 (0.1—0.4)	C	
	≤230HB	VP15TF VP20RT	200 (160—300)	0.2 (0.1—0.3)	A	
				0.3 (0.1—0.45)	B	
				0.2 (0.1—0.4)	C	
Ductile Cast Iron	Tensile Strength ≤540MPa	VP15TF VP20RT	200 (160—300)	0.25 (0.1—0.4)	A	
				0.35 (0.1—0.45)	B	
				0.25 (0.1—0.45)	C	
Cast Iron	Tensile Strength ≤350MPa	VP15TF VP20RT	200 (160—300)	0.25 (0.1—0.4)	A	
				0.35 (0.1—0.45)	B	
				0.25 (0.1—0.4)	C	

