

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P	Carbon Steel Alloy Steel	180HB—280HB	VP15TF	100 (50—150)	0.08 (0.01—0.15)
	Free Cutting Steel	—	VP15TF	110 (30—180)	0.08 (0.01—0.15)
			NX2525	150 (50—250)	0.08 (0.01—0.15)
M	Stainless Steel	≤200HB	VP15TF	80 (50—120)	0.06 (0.02—0.1)
N	Non-Ferrous Metal	—	HTi10	150 (70—230)	0.09 (0.03—0.15)