

RECOMMENDED CUTTING CONDITIONS

■ CUTTING SPEED (m/min)

	Work Material	Hardness	Coated		Carbide
			F7030	VP15TF	UTi20T
P	Mild Steel	≤180HB	250 (200–300)	250 (200–300)	150 (100–200)
	Carbon Steel Alloy Steel	180–280HB	180 (130–220)	180 (130–220)	140 (100–170)
		280–380HB	160 (110–190)	160 (110–190)	100 (70–120)
	Pre-Hardened Steel	35–45HRC	120 (80–140)	120 (80–140)	90 (60–100)
	High Alloy Steel	300HB	130 (90–160)	130 (90–160)	100 (70–120)
M	Stainless Steel	≤260HB	180 (130–220)	180 (130–220)	140 (100–170)
K	Cast Iron	Tensile Strength ≤350MPa	–	170 (130–220)	140 (100–170)
	Ductile Cast Iron	Tensile Strength 360–500MPa	–	140 (100–180)	120 (80–140)
		Tensile Strength 500–800MPa	–	110 (80–140)	90 (70–110)
H	Hardened Steel	45–60HRC	–	60 (50–100)	60 (40–70)

Note 1) Cutting speeds shown in bold type are for the recommended first choice grades.

■ FEED PER TOOTH (mm/t.)

Type	Depth of Cut (mm)							
	1	2	3	4	5	6	7	8
BRP4	0.40	0.30	0.20	0.10	–	–	–	–
BRP5	0.40	0.35	0.30	0.20	0.10	–	–	–
BRP6	0.50	0.40	0.30	0.25	0.23	0.20	–	–
BRP8	0.60	0.50	0.45	0.40	0.33	0.30	0.25	0.20