

## RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
<b>P</b>	Carbon Steel · Alloy Steel	180HB—280HB	<b>MS6015/VP15TF</b>	100 (50—150)	0.05 (0.02—0.09)
	Free Cutting Steel	—	<b>MS6015</b>	110 (30—180)	0.05 (0.01—0.09)
<b>M</b>	Stainless Steel	≤200HB	<b>VP15TF</b>	80 (50—120)	0.03 (0.02—0.05)
<b>N</b>	Non-Ferrous Metal	—	<b>MS6015</b>	150 (70—230)	0.07 (0.03—0.11)