

## 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) |