

RECOMMENDED CUTTING CONDITIONS

| | Work Material | Hardness | Grade | Cutting Speed (m/min) | Feed per Tooth (mm/tooth) |
|----------|---|-----------|------------------------|--------------------------|------------------------------|
| P | Mild Steel | ≤180HB | VP15TF | 180 (150—200) | 0.15 (0.1—0.2) |
| | Carbon Steel Alloy Steel | ≤280HB | VP15TF | 150 (120—200) | 0.15 (0.1—0.2) |
| | | 280—350HB | VP15TF | 140 (120—160) | 0.15 (0.1—0.2) |
| M | Stainless Steel | ≤270HB | VP15TF | 140 (120—160) | 0.2 (0.1—0.3) |
| N | Aluminium Alloy | — | LC15TF TF15 | 1000 (200—3000) | 0.3 (0.1—0.5) |
| S | Ti Alloy | — | VP15TF | 40 (30—60) | 0.1 (0.1—0.3) |
| | Heat Resistance Alloy (Inconel etc.) | — | VP15TF | 30 (20—40) | 0.15 (0.1—0.2) |
| H | Hardened Steel | 40—60HRC | VP15TF | 70 (50—100) | 0.1 (0.05—0.15) |

- Figures above are a guide lines for optimum general use. They may vary depending on machine rigidity, work clamping and length of tool overhang.
- When using $\phi 20$ shank type, set the table feed at under 0.05mm/tooth and maintain observation during cutting.
- Please adjust the table feed when using long- and extra-long-shank types.
- Please adjust the table feed when ramp machining (Recommended feed:0.05 mm/tooth under).