

## RECOMMENDED CUTTING CONDITIONS

Work Material	Hardness	Grade	CBJP		CBMP	
			Cutting Speed (m/min)	Feed (mm/rev)	Cutting Speed (m/min)	Feed (mm/rev)
<b>P</b> Mild Steel	≤180HB	<b>VP15TF</b>	180 (100–200)	0.16 (0.12–0.2)	180 (100–200)	0.225 (0.15–0.3)
	180–280HB	<b>VP15TF</b>	180 (100–200)	0.2 (0.15–0.25)	180 (100–200)	0.275 (0.2–0.35)
		<b>VP15TF</b>	120 (80–160)	0.16 (0.12–0.2)	120 (80–160)	0.225 (0.15–0.3)
<b>M</b> Carbon Steel Alloy Steel	280–350HB	<b>VP15TF</b>	120 (80–160)	0.16 (0.12–0.2)	120 (80–160)	0.225 (0.15–0.3)
	≤200HB	<b>VP15TF</b>	150 (100–200)	0.16 (0.12–0.2)	150 (100–200)	0.225 (0.15–0.3)
<b>K</b> Cast Iron	Tensile Strength ≤450MPa	<b>VP15TF</b>	160 (100–220)	0.3 (0.2–0.4)	160 (100–220)	0.35 (0.2–0.5)

● Revolution (min<sup>-1</sup>) = (1000 x Cutting Speed) ÷ (3.14 x φD<sub>1</sub>) ● Spindle feed (mm/min) = Feed rate x Tool spindle speed

(Note) CBJPR141S25 use feed per revolution 50 % of this table, because only 1 insert on the body.