

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed per Tooth (mm/tooth)	Recommended Max. Depth of Cut (mm)
P Carbon Steel Alloy Steel	≤180HB	VP15TF	180 (100–250)	0.35 (0.2–0.5)	4.5
		NX2525	175 (150–200)	0.25 (0.2–0.3)	4.5
	280–350HB	VP15TF	180 (100–250)	0.3 (0.2–0.4)	4.5
		NX2525	165 (130–200)	0.25 (0.2–0.3)	4.5
M Stainless Steel	≤200HB	VP15TF	150 (100–200)	0.35 (0.2–0.5)	3
K Gray Cast Iron	Tensile Strength ≤350MPa	VP15TF	160 (100–220)	0.4 (0.3–0.5)	4.5
H Hardened Steel	40–60HRC	VP15TF	80 (50–100)	0.2 (0.1–0.3)	2

● Revolution (min⁻¹)=(1000 x Cutting Speed)÷(3.14 x ϕD1)

● Table Feed (mm/min)

=Feed per Tooth x Number of Teeth x Cutter Revolution