

RECOMMENDED CUTTING CONDITIONS

	Material	Properties	Grade	Cutting Speed vc (SFM)	Feed per Rev. f (IPR)	Depth of Cut ap (inch)	Tool Overhang l/d
P	Pure Iron, Free Cutting Steel	—	MS7025	260(130—395)	.0012(.0004—.0020)	.008(.004—.012)	3—5
	Carbon Steel, Alloy Steel	Hardness 180—350HB	MS7025, VP15TF	260(130—395)	.0012(.0004—.0020)	.008(.004—.012)	3—5
M	Stainless Steel	Hardness ≤200HB	MS7025, MS9025, VP15TF	260(130—395)	.0012(.0004—.0020)	.008(.004—.012)	3—5
K	Gray Cast Iron	Tensile Strength ≤350MPa	VP15TF	260(130—395)	.0012(.0004—.0020)	.008(.004—.012)	3—5
N	Non-Ferrous Metal	—	TF15	395(260—525)	.0020(.0004—.0031)	.012(.004—.020)	3—5
S	Heat Resistant Alloy	—	MS9025	195(130—260)	.0008(.0004—.0012)	.008(.004—.012)	3—5

Note 1) Recommend wet cutting.