RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (SFM)
P	Mild Steel	≤180HB	**MP9025**	260 (195—330)
			VP10MF	490 (230—755)
			VP15TF	330 (195—460)
			VP20RT	260 (195—330)
	Carbon Steel Alloy Steel	180—280HB	**MP9025**	260 (195—330)
			VP10MF	460 (260—655)
			VP15TF	330 (195—460)
			VP20RT	260 (195—330)
M	Stainless Steel	≤200HB	**MP9025**	260 (130—395)
			VP15TF	260 (130—395)
			VP20RT	
K	Gray Cast Iron	Tensile Strength ≤350MPa	**VP10MF**	460 (260—655)
			VP15TF	295 (195—395)

	Work Material	Hardness	Grade	Cutting Speed (SFM)
S	Heat Resistant Alloy	—	**MP9025**	100 (65—130)
			VP10MF	150 (50—230)
			VP15TF	100 (65—130)
			VP20RT	
	Titanium Alloy	—	**MP9025**	150 (80—210)
			VP10MF	195 (130—260)
			VP15TF	150 (80—210)
			VP20RT	
H	Heat-Treated Alloy	45—55HRC	**VP10MF**	165 (100—230)
			VP15TF	130 (65—195)