

## RECOMMENDED CUTTING CONDITIONS

Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed per Tooth (mm/t.)
P Carbon Steel Alloy Steel	180–280HB	VP15TF	250 (150–350)	0.1 (0.05–0.15)
	280–380HB	VP15TF	200 (100–300)	
K Gray Cast Iron	Tensile Strength ≤350MPa	AP10H MB710	350 (200–500) 1500 (1000–2000)	0.1 (0.05–0.15)

Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed per Tooth (mm/t.)
K Ductile Cast Iron	Tensile Strength 360–500MPa	AP10H	250 (150–350)	0.1 (0.05–0.15)
		MB710	1000 (800–1200)	
Ductile Cast Iron	Tensile Strength 500–800MPa	AP10H	200 (100–300)	0.1 (0.05–0.15)
		MB710	1000 (800–1200)	

● Revolution (min<sup>-1</sup>)=(1000 x Cutting Speed)÷(3.14 x DC)

● Table Feed (mm/min)=Feed per Tooth x Number of Teeth x Cutter Revolution

Note 1) Recommended radial depth of cut is 0.1 mm.

Note 2) 2 directional vertical cutting is recommended for efficiency.

Note 3) For crossfeed cutting, the feed per tooth should be reduced to less than 0.05(mm/t.).