

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P	Carbon Steel · Alloy Steel	180HB–280HB	MS6015/VP15TF	100 (50–150)	0.08 (0.01–0.15)
	Free Cutting Steel	–	MS6015	110 (30–180)	0.08 (0.01–0.15)
			NX2525	150 (50–250)	0.08 (0.01–0.15)
M	Stainless Steel	≤200HB	VP15TF/MP9005/MP9015	80 (50–120)	0.06 (0.02–0.1)
		230HB	MS9025	100 (50–180)	0.08 (0.01–0.15)
N	Non-Ferrous Metal	–	HTi10/MT9005	150 (70–230)	0.09 (0.03–0.15)
S	Titanium Alloy	–	MT9005	60 (40–80)	0.08 (0.04–0.12)
	Heat Resistant Alloy	–	MP9015/MS9025	50 (20–75)	0.08 (0.04–0.12)