

## RECOMMENDED CUTTING CONDITIONS

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