

# MMTI BORING BARS

## RECOMMENDED CUTTING CONDITIONS

### INTERNAL THREADING

Material	Hardness	Grade	Vc
P	Mild steel ≤180HB	MP9025	80 (60–100)
		VP10MF	150 (70–230)
		VP15TF	100 (60–140)
		VP20RT	80 (60–100)
		MP9025	80 (60–100)
Carbon steel Alloy steel	180 – 280HB	VP10MF	140 (80–200)
		VP15TF	100 (60–140)
		VP20RT	80 (60–100)
M	Stainless steel ≤200HB	MP9025	80 (40–120)
		VP15TF	80 (40–120)
		VP20RT	80 (40–120)
K	Gray cast iron Tensile Strength ≤350MPa	VP10MF	140 (80–200)
		VP15TF	90 (60–120)
S	Heat-resistant alloy —	MP9025	30 (20– 40)
		VP10MF	45 (15– 70)
		VP15TF	30 (20– 40)
		VP20RT	30 (20– 40)
		MP9025	45 (25– 65)
Titanium alloy	—	VP10MF	60 (40– 80)
		VP15TF	45 (25– 65)
		VP20RT	45 (25– 65)
H	Heat-treated alloy 45 – 55HRC	VP10MF	50 (30– 70)
		VP15TF	40 (20– 60)