
CT-TYPE

RECOMMENDED CUTTING CONDITIONS

	Material	Properties	Grade	Vc	Recommended tool overhang (mm)
P	Pure iron, Free cutting steel	—	MS7025	50 (30 – 80)	LU + 2 mm
	Carbon steel, alloy steel	Hardness 180 – 350HB	MS7025, VP15TF	50 (30 – 80)	LU + 2 mm
M	Stainless steel	Hardness ≤200HB	MS7025, MS9025, VP15TF	50 (30 – 80)	LU + 2 mm
K	Gray cast iron	Tensile strength ≤350MPa	VP15TF	50 (30 – 80)	LU + 2 mm
N	Non-ferrous metal	—	TF15	80 (50 – 100)	LU + 2 mm
S	Heat resistant alloy	—	MS9025	40 (30 – 60)	LU + 2 mm

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1. Recommend wet machining.
2. Pay special attention to machining of small diameters at high revolutions as the feed rate cannot keep up with the speed.