

RECOMMENDED CUTTING CONDITIONS

	Workpiece Material	Grade	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)	l/d
P	Carbon Steel, Alloy Steel 180—350HB	NX2525	80 (40—120)	0.03 (0.01—0.05)	0.2 (0.1—0.3)	3—5
M	Stainless Steel ≤200HB	VP15TF	80 (40—120)	0.03 (0.01—0.05)	0.2 (0.1—0.3)	3—5
K	Gray Cast Iron ≤350MPa	VP15TF	80 (40—120)	0.03 (0.01—0.05)	0.2 (0.1—0.3)	3—5
N	Non-Ferrous Material	VP15TF	120 (80—160)	0.05 (0.01—0.08)	0.4 (0.1—0.6)	3—5
		MD220	120 (80—160)	0.05 (0.01—0.08)	0.4 (0.1—0.6)	3—5
H	Hardened Steel 35—65HRC	MB8110	80 (40—120)	0.03 (0.01—0.05)	0.1 (0.03—0.2)	3—5