

RECOMMENDED CUTTING CONDITIONS

	Workpiece Material	Hardness	Grade	Cutting Speed (m/min)	Feed per Tooth (mm/t)
P	Carbon Steel Alloy Steel	180—280HB	VP15TF	250 (150—350)	0.1 (0.05—0.15)
		280—380HB	VP15TF	200 (100—300)	
K	Gray Cast Iron	Tensile Strength ≤350MPa	AP10H	350 (200—500)	0.1 (0.05—0.15)
			MB710	1500 (1000—2000)	

	Workpiece Material	Hardness	Grade	Cutting Speed (m/min)	Feed per Tooth (mm/t)
K	Ductile Cast Iron	Tensile Strength 360—500MPa	AP10H	250 (150—350)	0.1 (0.05—0.15)
			MB710	1000 (800—1200)	
	Ductile Cast Iron	Tensile Strength 500—800MPa	AP10H	200 (100—300)	0.1 (0.05—0.15)
			MB710	1000 (800—1200)	

● Revolution (min⁻¹)=(1000 x Cutting Speed)÷(3.14 x DC)

● Table Feed (mm/min)=Feed per Tooth x Number of Teeth x Cutter Revolution

Note 1) Recommended radial depth of cut is 0.1mm.

Note 2) 2 directional vertical cutting is recommended for efficiency.

Note 3) For crossfeed cutting, the feed per tooth should be reduced to less than 0.05(mm/t).