

RECOMMENDED CUTTING CONDITIONS

	Workpiece Material	Hardness	Grade	Cutting Speed (m/min)	Feed per Tooth (mm/t)	pf (mm)
P	Carbon Steel Alloy Steel	180–280HB	VP15TF	180 (150–200)	0.2 (0.1–0.3)	≤0.5DC
		280–380HB				
K	Gray Cast Iron	Tensile Strength ≤350MPa	VP15TF	180 (150–200)	0.2 (0.1–0.3)	≤0.5DC
	Ductile Cast Iron	Tensile Strength 360–500MPa	VP15TF	150 (120–170)	0.2 (0.1–0.3)	≤0.5DC
		Tensile Strength 500–800MPa	VP15TF	120 (100–150)	0.2 (0.1–0.3)	≤0.5DC

● 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) The above conditions are suitable for general machining purposes, it is possible to use conditions that are different from the above.

Note 2) For horizontal feed machining, please reduce the feed rate by about 20–40%.

Note 3) If chatter or abnormal noises occur, adjust the depth of cut and cutting speed.