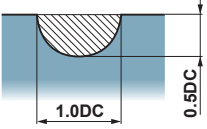
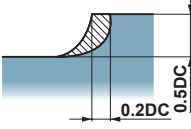
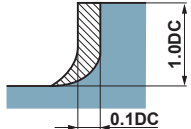


## RECOMMENDED CUTTING CONDITIONS

| Cutting Mode | A : Slot Milling                                                                  | B : Shoulder Milling (Standard Type)                                              | C : Shoulder Milling (Long Cutting Edge Type)                                       |
|--------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|
|              |  |  |  |

|   | Workpiece Material | Hardness                                 | Grade            | Cutting Speed (m/min) | Feed per Tooth (mm/t) | Cutting Mode |
|---|--------------------|------------------------------------------|------------------|-----------------------|-----------------------|--------------|
| P | Alloy Tool Steel   | $\leq 250\text{HB}$                      | VP20RT<br>VP30RT | 160 (120—200)         | 0.12 (0.08—0.2)       | A            |
|   |                    |                                          |                  |                       | 0.2 (0.1—0.4)         | B            |
|   |                    |                                          |                  |                       | 0.15 (0.1—0.3)        | C            |
|   | Alloy Tool Steel   | $\leq 250\text{HB}$                      | VP20RT<br>VP30RT | 200 (160—250)         | 0.2 (0.1—0.3)         | A            |
|   |                    |                                          |                  |                       | 0.3 (0.1—0.4)         | B            |
|   |                    |                                          |                  |                       | 0.2 (0.1—0.4)         | C            |
|   | Cast Tool Steel    | $\leq 235\text{HB}$                      | VP20RT           | 200 (160—250)         | 0.2 (0.1—0.3)         | A            |
|   |                    |                                          |                  |                       | 0.3 (0.1—0.4)         | B            |
|   |                    |                                          |                  |                       | 0.2 (0.1—0.4)         | C            |
|   | Cast Tool Steel    | $\leq 230\text{HB}$                      | VP15TF<br>VP20RT | 200 (160—300)         | 0.2 (0.1—0.3)         | A            |
|   |                    |                                          |                  |                       | 0.3 (0.1—0.45)        | B            |
|   |                    |                                          |                  |                       | 0.2 (0.1—0.4)         | C            |
| K | Ductile Cast Iron  | Tensile Strength<br>$\leq 540\text{MPa}$ | VP15TF<br>VP20RT | 200 (160—300)         | 0.25 (0.1—0.4)        | A            |
|   |                    |                                          |                  |                       | 0.35 (0.1—0.45)       | B            |
|   |                    |                                          |                  |                       | 0.25 (0.1—0.45)       | C            |
|   | Gray Cast Iron     | Tensile Strength<br>$\leq 350\text{MPa}$ | VP15TF<br>VP20RT | 200 (160—300)         | 0.25 (0.1—0.4)        | A            |
|   |                    |                                          |                  |                       | 0.35 (0.1—0.45)       | B            |
|   |                    |                                          |                  |                       | 0.25 (0.1—0.4)        | C            |