

RECOMMENDED CUTTING CONDITIONS

	Workpiece Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P	Carbon Steel · Alloy Steel	180HB–280HB	VP15TF	100 (50–150)	0.08 (0.01–0.15)
	Free Cutting Steel	–	VP15TF	110 (30–180)	0.08 (0.01–0.15)
M	Stainless Steel	≤200HB	VP15TF	80 (50–120)	0.06 (0.02–0.1)
N	Non-Ferrous Metal	–	VP15TF	150 (70–230)	0.09 (0.03–0.15)