

RECOMMENDED CUTTING CONDITIONS

| | Workpiece Material | Hardness | Grade | Cutting Speed (m/min) | Feed (mm/rev) |
|----------|----------------------------|-------------|-----------------------------|-----------------------|------------------|
| P | Carbon Steel · Alloy Steel | 180HB–280HB | MS6015/VP15TF | 100 (50–150) | 0.08 (0.01–0.15) |
| | Free Cutting Steel | – | MS6015 | 110 (30–180) | 0.08 (0.01–0.15) |
| | | | NX2525 | 150 (50–250) | 0.08 (0.01–0.15) |
| M | Stainless Steel | ≤200HB | VP15TF/MP9005/MP9015 | 80 (50–120) | 0.06 (0.02–0.1) |
| | | 230HB | MS7025/MS9025 | 100 (50–180) | 0.08 (0.01–0.15) |
| N | Non-Ferrous Metal | – | HTi10/MT9005 | 150 (70–230) | 0.09 (0.03–0.15) |
| S | Titanium Alloy | – | MT9005 | 60 (40–80) | 0.08 (0.04–0.12) |
| | Heat Resistant Alloy | – | MP9015/MS9025 | 50 (20–75) | 0.08 (0.04–0.12) |