## 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) |

Note1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.
Note2) Dimensions shown for insert corner RE 0.2.