

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P	Carbon Steel · Alloy Steel	180HB–280HB	VP15TF	100 (70–120)	0.06 (0.02–0.1)
	Free Cutting Steel	–	VP15TF	110 (30–180)	0.06 (0.02–0.1)
M	Stainless Steel	≤200HB	VP15TF	100 (70–120)	0.06 (0.02–0.1)

(Note) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.