

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)	0.05 (0.02—0.09)
	Free Cutting Steel	—	MS6015	110 (30—180)	0.05 (0.01—0.09)
M	Stainless Steel	≤200HB	VP15TF	80 (50—120)	0.03 (0.02—0.05)
N	Non-Ferrous Metal	—	MS6015	150 (70—230)	0.07 (0.03—0.11)