

RECOMMENDED CUTTING CONDITIONS

Workpiece Material		Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P	Carbon Steel Alloy Steel	180—280HB	VP20MF	120 (100—140)	0.14 (0.03—0.25)
			NX2525	130 (100—160)	0.12 (0.03—0.2)
M	Stainless Steel	≤200HB	VP20MF	120 (100—140)	0.12 (0.03—0.18)
K	Gray Cast Iron	Tensile Strength ≤350MPa	VP20MF	120 (100—140)	0.12 (0.03—0.18)

Note 1) For machining a narrow groove, apply a lower feed within the recommended range.