

RECOMMENDED CUTTING CONDITIONS

Workpiece Material		Hardness	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	VP10MF	150 (70—230)
			VP15TF	100 (60—140)
	Carbon Steel Alloy Steel	180—350HB	VP10MF	140 (80—200)
			VP15TF	100 (60—140)
M	Stainless Steel	≤200HB	VP10MF	130 (80—180)
			VP15TF	80 (40—120)
K	Gray Cast Iron	Tensile Strength≤350MPa	VP10MF	140 (80—200)
			VP15TF	90 (60—120)