

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	VP10MF	150 (70–230)
			VP15TF	100 (60–140)
			VP20RT	80 (60–100)
	Carbon Steel Alloy Steel	180–280HB	VP10MF	140 (80–200)
			VP15TF	100 (60–140)
			VP20RT	80 (60–100)
M	Stainless Steel	≤200HB	VP15TF	80 (40–120)
		VP20RT		
K	Gray Cast Iron	Tensile Strength ≤350MPa	VP10MF	140 (80–200)
			VP15TF	90 (60–120)

	Work Material	Hardness	Grade	Cutting Speed (m/min)
S	Heat-Resistant Alloy	—	VP10MF	45 (15–70)
			VP15TF	30 (20–40)
			VP20RT	
H	Titanium Alloy	—	VP10MF	60 (40–80)
			VP15TF	45 (25–65)
			VP20RT	
H	Heat-Treated Alloy	45–55HRC	VP10MF	50 (30–70)
			VP15TF	40 (20–60)