

## BACK TURNING TOOLS

### RECOMMENDED CUTTING CONDITIONS

	Work Material	Grade	Cutting Speed (SFM)	Feed (IPR)
<b>P</b>	Carbon Steel · Alloy Steel	<b>VP15TF</b>	165–490	.0004–.006
	Free Cutting Carbon Steel	<b>VP15TF</b>	100–590	.0004–.006
<b>M</b>	Stainless Steel	<b>VP15TF</b>	165–395	.0008–.004
<b>N</b>	Non-Ferrous Metal	<b>VP15TF</b>	230–755	.0012–.006

## CUTTING OFF TOOLS

### RECOMMENDED CUTTING CONDITIONS

	Work Material	Grade	Cutting Speed (SFM)	Feed (IPR)
<b>P</b>	Carbon Steel · Alloy Steel	<b>VP15TF</b>	165–490	.0008–.0035
	Free Cutting Carbon Steel	<b>VP15TF</b>	100–590	.0004–.0035
<b>M</b>	Stainless Steel	<b>VP15TF</b>	165–395	.0008–.0019
<b>N</b>	Non-Ferrous Metal	<b>VP15TF</b>	230–755	.0012–.0043