

RECOMMENDED CUTTING CONDITIONS

	Work Material	Grade	Cutting Speed (SFM)	Feed (IPR)
P	Carbon Steel · Alloy Steel	VP15TF	165—490	.0004—.006
	Free Cutting Steel	VP15TF	100—590	.0004—.006
		AP25N	165—820	.0004—.006
M	Stainless Steel	VP15TF	165—395	.0008—.004
N	Non-Ferrous Metal	HTi10	230—755	.0012—.006