

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (SFM)	Feed per Tooth (inch/tooth)
P	Mild Steel	≤180HB	VP15TF	590 (490–655)	.006 (.004–.008)
	Carbon Steel Alloy Steel	≤280HB	VP15TF	490 (390–655)	.006 (.004–.008)
		280–350HB	VP15TF	460 (390–525)	.006 (.004–.008)
M	Stainless Steel	≤270HB	VP15TF	460 (390–525)	.008 (.004–.012)
N	Aluminum Alloy	–	TF15	3280 (655–9840)	.012 (.004–.020)
S	Titanium Alloy	–	VP15TF	130 (100–195)	.004 (.004–.012)
	Heat Resistant Alloy	–	VP15TF	100 (65–130)	.006 (.004–.008)

The figure above are the guidelines for conditions of general cutting by a standard type tool.

The conditions vary depending on machine strength, the length of overhang, and work clamping conditions.

Please adjust table feed when using long shank type tool.