

RECOMMENDED CUTTING CONDITIONS

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