

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P	Carbon Steel · Alloy Steel	180HB–280HB	MS6015/VP15TF	100 (50–150)	0.08 (0.01–0.15)
	Free Cutting Steel	–	MS6015	110 (30–180)	0.08 (0.01–0.15)
			NX2525	150 (50–250)	0.08 (0.01–0.15)
M	Stainless Steel	≤200HB	VP15TF/MP9005/MP9015	80 (50–120)	0.06 (0.02–0.1)
		230HB	MS9025	100 (50–180)	0.08 (0.01–0.15)
N	Non-Ferrous Metal	–	HTi10/MT9005	150 (70–230)	0.09 (0.03–0.15)
S	Titanium Alloy	–	MT9005	60 (40–80)	0.08 (0.04–0.12)
	Heat Resistant Alloy	–	MP9015/MS9025	50 (20–75)	0.08 (0.04–0.12)

Note 1) The insert photos are only examples. The letters refer to the chipbreaker and the dimension refers to the inscribed circle.

Note 2) Dimensions shown for insert corner RE 0.2.