RECOMMENDED CUTTING CONDITIONS

Steel Shank							l/d ≤ 3		3 < l/d ≤ 5	
Heavy Metal Shank							l/d ≤ 3		3 < l/d ≤ 6	
	Work Material	Cutting Mode	Breaker	Recom-mendation	Grade	Cutting Speed (SFM)	Feed (IPR)	D.O.C. (inch)	Feed (IPR)	D.O.C. (inch)
P	Mild Steel <180HB	Finishing	**FV**	①	**NX2525**	555 (390—720)	.004 (.002—.006)	—.020	.004 (.002—.006)	—.020
		Light	**SV**	①	**VP45N**	460 (295—620)	.008 (.004—.010)	—.040	.006 (.002—.008)	—.040
				②	**VP15TF**	590 (425—755)	.008 (.004—.010)	—.040	.006 (.002—.008)	—.040
		Medium	**MV**	①	**VP45N**	425 (260—590)	.010 (.006—.014)	—.080	.008 (.006—.010)	—.060
				②	**VP15TF**	525 (360—690)	.010 (.006—.014)	—.080	.008 (.006—.010)	—.060
	Carbon Steel Alloy Steel 180—280HB	Finishing	**FV**	①	**VP15TF**	460 (295—620)	.004 (.002—.006)	—.020	.004 (.002—.006)	—.020
				②	**NX2525**	425 (260—590)	.004 (.002—.006)	—.020	.004 (.002—.006)	—.020
		Light	**SV**	①	**VP15TF**	425 (260—590)	.008 (.004—.010)	—.040	.006 (.002—.008)	—.040
				②	**UE6020**	460 (295—620)	.008 (.004—.010)	—.040	.006 (.002—.008)	—.040
		Medium	**MV**	①	**VP15TF**	390 (230—555)	.010 (.006—.014)	—.080	.008 (.006—.010)	—.060
				②	**UE6020**	425 (260—590)	.010 (.006—.014)	—.080	.008 (.006—.010)	—.060
M	Stainless Steel 180—280HB	Finishing	**FV**	①	**VP15TF**	490 (360—620)	.004 (.002—.006)	—.020	.004 (.002—.006)	—.020
		Light	**SV**	①	**US7020**	490 (360—620)	.008 (.004—.010)	—.040	.006 (.002—.008)	—.040
				②	**VP15TF**	425 (295—555)	.008 (.004—.010)	—.040	.006 (.002—.008)	—.040
		Medium	**MV**	①	**US7020**	460 (330—590)	.008 (.006—.010)	—.080	.008 (.006—.010)	—.040
				②	**VP15TF**	390 (260—525)	.008 (.006—.010)	—.080	.008 (.006—.010)	—.040
K	Cast Iron Tensile Strength<350MPa	Finishing	**F/FS**	①	**HTi10**	425 (295—525)	.006 (.004—.008)	—.020	.006 (.004—.008)	—.020
		Medium	**MV**	①	**VP15TF**	295 (195—390)	.008 (.006—.010)	—.080	.008 (.006—.010)	—.060
N	Aluminium Alloy	Finishing	**F/FS**	①	**HTi10**	985 (655—1310)	.004 (.002—.006)	—.020	.004 (.002—.006)	—.020
			No Breaker	①	**MD220**	655 (490—820)	.004 (.002—.006)	—.080	.004 (.002—.006)	—.040
H	Heat Treated Steel 35—65HRC	Finishing	No Breaker	①	**MB825**	330 (260—655)	.004 (.002—.006)	—.006	.004 (.002—.006)	—.004

* If the DIMPLE BAR vibrates, reduce cutting speed to 70% of the above.