

## RECOMMENDED CUTTING CONDITIONS

Work Material		Cutting Speed (SFM)		
		CVD	PVD	
Material	Hardness	F7010 / F7030 / F620	VP15TF / AP20M	
<b>P</b>	Mild Steel	≤ 180HB	820 (660—980)	820 (660—980)
	Carbon Steel	180—280HB	590 (425—720)	590 (425—720)
	Alloy Steel	280—380HB	525 (360—620)	525 (360—620)
	Prehardened Steel	35—45HB	390 (260—460)	390 (260—460)
	High Alloy Steel	≤ 300HB	425 (295—525)	425 (295—525)
	Sintered Steel	45—60HRC	—	215 (155—275)
<b>M</b>	Stainless Steel	≤ 260HB	590 (425—720)	590 (425—720)
<b>K</b>	Gray Cast Iron	Tensile Strength ≤ 350MPa	—	570 (425—720)
	Ductile Cast Iron	Tensile Strength 360—500MPa	—	470 (340—600)
		Tensile Strength 500—800MPa	—	360 (260—460)