

RECOMMENDED CUTTING CONDITIONS

	Work Material	Grade	Cutting Speed (SFM)	Feed (IPR)
P	Carbon Steel · Alloy Steel	VP15TF/VP15KZ	165–490	.0004–.0035
	Free Cutting Carbon Steel	VP15TF/VP15KZ	100–590	.0004–.0035
M	Stainless Steel	VP15TF/VP15KZ	165–395	.0008–.002
N	Non-Ferrous Metal	VP15TF/VP15KZ	230–755	.0012–.004