

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (SFM)
P	Mild Steel	≤180HB	MP9025	260 (195–330)
			VP10MF	490 (230–755)
			VP15TF	330 (195–460)
			VP20RT	260 (195–330)
	Carbon Steel Alloy Steel	180–280HB	MP9025	260 (195–330)
			VP10MF	460 (260–655)
			VP15TF	330 (195–460)
			VP20RT	260 (195–330)
M	Stainless Steel	≤200HB	MP9025	260 (130–395)
			VP15TF	260 (130–395)
			VP20RT	
K	Gray Cast Iron	Tensile Strength ≤350MPa	VP10MF	460 (260–655)
			VP15TF	295 (195–395)

	Work Material	Hardness	Grade	Cutting Speed (SFM)
S	Heat Resistant Alloy	–	MP9025	100 (65–130)
			VP10MF	150 (50–230)
			VP15TF	100 (65–130)
			VP20RT	
	Titanium Alloy	–	MP9025	150 (80–210)
VP10MF			195 (130–260)	
VP15TF			150 (80–210)	
VP20RT				
H	Heat-Treated Alloy	45–55HRC	VP10MF	165 (100–230)
			VP15TF	130 (65–195)