

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	CBJP		CBMP	
				Cutting Speed (m/min)	Feed (mm/rev)	Cutting Speed (m/min)	Feed (mm/rev)
P	Mild Steel	≤180HB	VP15TF	180 (100—200)	0.16 (0.12—0.2)	180 (100—200)	0.225 (0.15—0.3)
	Carbon Steel Alloy Steel	180—280HB	VP15TF	180 (100—200)	0.2 (0.15—0.25)	180 (100—200)	0.275 (0.2—0.35)
		280—350HB	VP15TF	120 (80—160)	0.16 (0.12—0.2)	120 (80—160)	0.225 (0.15—0.3)
M	Stainless Steel	≤200HB	VP15TF	150 (100—200)	0.16 (0.12—0.2)	150 (100—200)	0.225 (0.15—0.3)
K	Cast Iron	Tensile Strength ≤450MPa	VP15TF	160 (100—220)	0.3 (0.2—0.4)	160 (100—220)	0.35 (0.2—0.5)

● Revolution (min⁻¹)=(1000×Cutting Speed)÷(3.14×φD1)

● Table Feed (mm/min)=Feed per Tooth×Number of Teeth×Cutter Revolution

(Note) CBJPR141S25 type, reduce feed rate by 50% because only 1 insert is used.