

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed per Tooth (mm/tooth)	pf (mm)
P	Carbon Steel Alloy Steel	180—280HB	F7030	180 (150—200)	0.2 (0.1—0.3)	≤0.5D
		280—380HB				
K	Cast Iron	Tensile Strength ≤350MPa	VP15TF	180 (150—200)	0.2 (0.1—0.3)	≤0.5D
	Ductile Cast Iron	Tensile Strength 360—500MPa	VP15TF	150 (120—170)	0.2 (0.1—0.3)	≤0.5D
		Tensile Strength 500—800MPa	VP15TF	120 (100—150)	0.2 (0.1—0.3)	≤0.5D

● Revolution (min^{-1}) = $(1000 \times \text{Cutting Speed}) \div (3.14 \times \phi D_1)$

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

(Note 1) The above conditions are suitable for general machining purposes, it is possible to use conditions that are different from the above.

(Note 2) For horizontal feed machining, please reduce the feed rate by 20—40%.

(Note 3) If vibration occurs when machining, please reduce the depth of cut, and reduce the cutting speed by 20—50%.