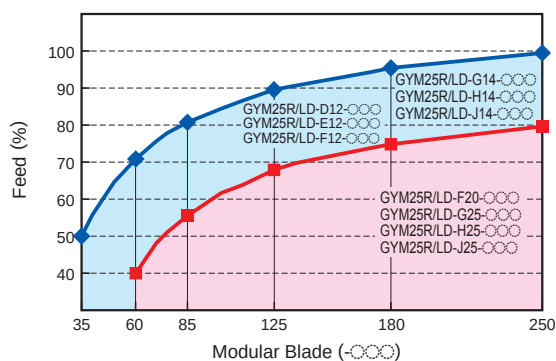


RELATIONSHIP BETWEEN THE MODULAR BLADE AND FEED PER ROTATION



(Note) Adjust the feed per rotation in the cutting conditions to the percentage shown in the table above.

RECOMMENDED CUTTING SPEED (m/min)

	Work Material	Hardness	Grade	Cutting Speed (m/min)					
				50	100	150	200	250	300
P	Mild Steel	≤160HB	VP20RT		80	180			
			VP10RT		90	190			
			NX2525		70	170			
	Carbon Steel Alloy Steel	160–280HB	VP20RT	60	140				
			VP10RT	70	150				
			MY5015		90	210			
			NX2525	55	135				
		280HB≤	VP20RT	50	110				
			VP10RT	60	120				
			MY5015		80	160			
			NX2525	45	105				
M	Stainless Steel	≤270HB	VP20RT	50	110				
			VP10RT	60	120				
K	Gray Cast Iron	Tensile Strength ≤300MPa	VP20RT	60	140				
			VP10RT	70	150				
			MY5015		90	210			
	Ductile Cast Iron	Tensile Strength ≤800MPa	VP20RT	50	110				
			VP10RT	60	120				
			MY5015		80	160			
S	Heat Resistant Alloy Titanium Alloy	—	VP20RT	30	60				
			VP10RT	40	70				
			RT9010	40	70				
H	Hardened steel	50HRC≤	MB8025	60	100				

(Note 1) VP20RT is the first recommended grade for materials other than hardened steel.

(Note 2) For VP10RT, VP20RT and MY5015, wet cutting is recommended.