

# STANDARD CUTTING CONDITIONS

ISO	Workpiece materials	Hardness (HB)	Grades	Cutting speed Vc (sfm)	Feed per tooth fz (ipt)
<b>P</b>	High carbon steel (1045, 1055, etc.)	200 - 300	AH110	328 - 984	0.004 - 0.012
	Alloy steel (4140, etc.)	150 - 300	AH110	328 - 984	0.004 - 0.012
	Prehardend steel (NAK80, PX5, etc.)	-	AH110	328 - 984	0.002 - 0.012
<b>H</b>	Hardened steel	(H13, etc.)	AH110	262 - 427	0.004 - 0.012
		(D2, etc.)	AH110	164 - 328	0.002 - 0.006