

| | | Cutting Speed – vc m/min | | |
|----------------|-----|-----------------------------|-------|-----|
| | | TN6025 | | |
| Material Group | | min | Start | max |
| P | 0/1 | 130 | 140 | 150 |
| | 2 | 110 | 145 | 175 |
| | 3 | 110 | 145 | 175 |
| | 4 | 75 | 95 | 115 |
| | 5 | 100 | 125 | 145 |
| | 6 | 40 | 55 | 65 |
| M | 1 | 60 | 75 | 90 |
| | 2 | 40 | 50 | 55 |
| | 3 | 40 | 50 | 60 |
| K | 1 | 60 | 80 | 90 |
| | 2 | 60 | 75 | 85 |
| | 3 | 60 | 75 | 90 |
| N | 1 | 600 | 750 | 900 |
| | 2 | 535 | 685 | 835 |
| | 3 | 230 | 300 | 370 |
| | 4 | 135 | 180 | 225 |
| | 5 | 70 | 90 | 110 |
| | 6 | 445 | 565 | 690 |
| | 7 | 550 | 700 | 850 |
| S | 1 | 25 | 35 | 40 |
| | 2 | 15 | 20 | 20 |
| | 3 | 40 | 60 | 70 |
| | 4 | 20 | 30 | 35 |