

STANDARD CUTTING CONDITIONS

ISO	Workpiece materials	Priority	Grades	Cutting speed Vc (sfm)	Feed f (ipt)
P	Low carbon steels (1015, etc.)	First choice	SH725	262 - 591	0.001 - 0.004
		Sharpness	AH725	262 - 591	0.001 - 0.004
	Carbon steels, Alloy steels (1055, etc.)	First choice	SH725	262 - 591	0.001 - 0.004
		Sharpness	AH725	262 - 591	0.001 - 0.004
M	Prehardened steels (NAK80, PX5 etc.)	First choice	SH725	262 - 591	0.001 - 0.004
		Sharpness	AH725	262 - 591	0.001 - 0.004
K	Stainless steels (S30400, etc.)	First choice	SH725	164 - 394	0.001 - 0.004
		Sharpness	AH725	164 - 394	0.001 - 0.004
K	Grey cast irons (No.250B, No.300B etc.)	First choice	AH725	164 - 591	0.001 - 0.004
		Sharpness	SH725	164 - 591	0.001 - 0.004
	Ductile cast irons (60-40-18, 80-55-06, etc.)	First choice	AH725	164 - 591	0.001 - 0.004
		Sharpness	SH725	164 - 591	0.001 - 0.004
S	Titanium alloys (Ti-6Al-4V, etc.)	First choice	SH725	66 - 262	0.001 - 0.004
		Sharpness	AH725	66 - 262	0.001 - 0.004
	Superalloys (Inconel718, etc.)	First choice	SH725	66 - 262	0.001 - 0.004
		Sharpness	AH725	66 - 262	0.001 - 0.004