

STANDARD CUTTING CONDITIONS

ISO	Workpiece material	Grade	Application	Cutting speed Vc (sfm)	Feed f (ipr)
P	High carbon steel 1045, etc.	AH110	Grooving	328 - 656	0.005 - 0.014
		AH725	Threading	262 - 591	-
	Alloy steel 4137, etc.	AH110	Grooving	164 - 262	0.005 - 0.012
		AH725	Threading	197 - 525	-
M	Stainless steel S30400, etc.	AH110	Grooving	164 - 492	0.004 - 0.005
		AH725	Threading	164 - 427	-
K	Gray cast iron No.250B, etc.	AH110	Grooving	164 - 591	0.004 - 0.010
		AH725	Threading	-	-
	Ductile cast iron 60-40-18, etc.	AH110	Grooving	164 - 394	0.004 - 0.010
		AH725	Threading	-	-