

ISO	Workpiece material	Grade	Chipbreaker	Cutting Speed V_c (m/min)	Depth of cut a_p (mm)	Feed f (mm/rev)
P	Mild and low carbon steels SS400, SM490, etc. E275A, C15E4, etc. < 180 HB	T9225	ML	100 - 300	0.5 - 2.5	0.5 - 2.5
	Carbon and alloy steels S55C, SCM440, etc. C55, 42CrMo4, etc. < 300HB	T9215	ML	120 - 350	0.5 - 2.5	0.5 - 2.5
M	Stainless steels SUS304, SUS316, etc. X5CrNi18-9, X5CrNiMo17-12-3, etc. < 250 HB	T9225	ML	100 - 300	0.5 - 2.5	0.5 - 2.5
K	Grey and ductile cast irons FC250, FCD400, etc. 250, 400-15S, etc.	AH120	ML	100 - 250	0.5 - 2.5	0.5 - 2.5