

## RECOMMENDED CUTTING CONDITIONS

Work Material	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)
<b>P</b> Mild Steel (≤180HB)	Finish	<b>FY</b>	<b>NX3035</b>	260-370
	Light	<b>SY</b>	<b>NX3035</b>	235-335
	Medium	<b>MS</b>	<b>UE6110</b>	260-440
Carbon Steel Alloy Steel (180HB-280HB)	Finish	<b>FH</b>	<b>NX3035</b>	200-280
	Light	<b>LP</b>	<b>UE6110</b>	210-355
	Medium	<b>MP</b>	<b>UE6110</b>	190-325

Work Material	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)
<b>M</b> Stainless Steel (≤200HB)	Finish	<b>FH</b>	<b>US735</b>	105-200
	Light	<b>SH</b>	<b>US735</b>	95-185
	Medium	<b>MS</b>	<b>US735</b>	85-165
<b>K</b> Cast Iron (≤350MPa)	Light	<b>MA</b>	<b>UC5115</b>	160-295
	Medium	<b>Standard</b>	<b>UC5115</b>	160-295
	Rough	<b>Flat Top</b>	<b>UC5115</b>	155-280