

RECOMMENDED CUTTING CONDITIONS

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

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