

RECOMMENDED CUTTING CONDITIONS

Work Material	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)	Work Material	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)
P Mild Steel (≤180HB) Carbon Steel Alloy Steel (180HB-280HB)	Finish	FY	NX3035	260-370	M Stainless Steel (≤200HB)	Finish	FH	US735	105-200
	Light	SY	NX3035	235-335		Light	SH	US735	95-185
	Medium	MS	UE6110	260-440		Medium	MS	US735	85-165
	Finish	FH	NX3035	200-280	K Cast Iron (≤350MPa)	Light	MA	UC5115	160-295
	Light	LP	UE6110	210-355		Medium	Standard	UC5115	160-295
	Medium	MP	UE6110	190-325		Rough	Flat Top	UC5115	155-280