

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 | FS | NX2525 | 260–370 | M Stainless Steel (≤200HB) | Finish | FH | US735 | 105–200 |
| | Light | SH | 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 | | | | | |