

RECOMMENDED CUTTING CONDITIONS

Work Material	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)
P Mild Steel ($\leq 180\text{HB}$)	Finish	FS	NX2525	260–370
	Light	SH	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