

RECOMMENDED CUTTING CONDITIONS

Work Material	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)
P Mild Steel (≤180HB)	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 (≤200HB)	Finish	FH	US735	105–200
	Light	SH	US735	95–185
	Medium	MS	US735	85–165
K Cast Iron (≤350MPa)	Light	MA	UC5115	160–295
	Medium	Standard	UC5115	160–295
	Rough	Flat Top	UC5115	155–280