

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)
P	Mild Steel	$\leq 180\text{HB}$	Medium Cutting	Standard	UE6110	205—350
	Carbon Steel, Alloy Steel	180HB—280HB	Medium Cutting	Standard	UE6110	150—260
M	Stainless Steel	$\leq 200\text{HB}$	Medium Cutting	Standard	US735	70—130