

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	Finish Cutting	FV	NX3035	205–290
			Medium Cutting	Standard	UE6110	205–350
	Carbon Steel, Alloy Steel	180HB–280HB	Finish Cutting	FV	NX3035	160–225
			Medium Cutting	Standard	UE6110	150–260
M	Stainless Steel	≤200HB	Light Cutting	Standard	US735	70–130
K	Cast Iron	Tensile Strength≤350MPa	Medium Cutting	Flat Top	UC5115	130–235