

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 |