

## RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)
<b>P</b>	Mild Steel	≤180HB	<b>UE6020</b>	150—350
	Carbon Steel, Alloy Steel	150HB—250HB	<b>UE6020</b>	100—250
<b>M</b>	Stainless Steel	≤200HB	<b>VP15TF</b>	100 (70—120)

(Note) The above cutting conditions are general guidelines.  
Adjustments may be necessary depending on machine rigidity,  
workpiece geometry and clamping.