

## RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)
<b>P</b>	Mild Steel	≤180HB	Finish Cutting	<b>FY</b>	<b>NX3035</b>	260–370
			Light Cutting	<b>SY</b>	<b>NX3035</b>	235–335
			Medium Cutting	<b>MS</b>	<b>UE6110</b>	260–440
	Carbon Steel Alloy Steel	180HB–350HB	Finish Cutting	<b>FH</b>	<b>NX3035</b>	200–280
			Light Cutting	<b>LP</b>	<b>UE6110</b>	210–355
			Medium Cutting	<b>MP</b>	<b>UE6110</b>	190–325
<b>M</b>	Stainless Steel	≤200HB	Finish Cutting	<b>FH</b>	<b>US735</b>	105–200
			Light Cutting	<b>SH</b>	<b>US735</b>	95–185
			Medium Cutting	<b>MS</b>	<b>US735</b>	85–165
<b>K</b>	Cast Iron	Tensile Strength ≤350MPa	Light Cutting	<b>MA</b>	<b>UC5115</b>	160–295
			Medium Cutting	<b>Standard</b>	<b>UC5115</b>	160–295
			Rough Cutting	<b>Flat Top</b>	<b>UC5115</b>	155–280