

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)
P	Mild Steel	$\leq 180\text{HB}$	Finish Cutting	F	AP25N	250 (150–300)
			Medium Cutting	MV	UE6020	200 (150–250)
	Carbon Steel Alloy Steel	180HB–350HB	Finish Cutting	F	AP25N	210 (150–260)
			Medium Cutting	MV	UE6020	170 (120–210)
M	Stainless Steel	$\leq 200\text{HB}$	Medium Cutting	MV	US735	100 (70–120)
K	Cast Iron	Tensile Strength $\leq 350\text{MPa}$	Medium Cutting	MV	UE6020	170 (140–200)