

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)
P	Mild Steel	$\leq 180\text{HB}$	UP20M	140 (100—180)
			UTi20T	120 (100—150)
	Carbon Steel Alloy Steel	180HB—350HB	UP20M	120 (100—150)
			UTi20T	100 (70—120)
M	Stainless Steel	$\leq 200\text{HB}$	UP20M	120 (80—150)
			UTi20T	100 (70—130)
K	Cast Iron	Tensile Strength $\leq 350\text{MPa}$	UP20M	80 (60—100)
			UTi20T	80 (60—100)
			HTi10	100 (70—130)