

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	Finish Cutting	F	AP25N	250 (150–300)
			Medium Cutting	MP	MC6015	200 (150–250)
	Carbon Steel Alloy Steel	180HB–350HB	Finish Cutting	F	AP25N	210 (150–260)
			Medium Cutting	MP	MC6025	170 (120–210)
M	Stainless Steel	≤200HB	Medium Cutting	MM	MP7035	100 (70–120)
K	Cast Iron	Tensile Strength≤350MPa	Medium Cutting	MK	MC5015	170 (140–200)