

RECOMMENDED CUTTING CONDITIONS

| Workpiece Material | | Hardness | Grade | Cutting Speed (m/min) |
|--------------------|---------------------------|-------------|--------|-----------------------|
| P | Mild Steel | ≤180HB | UE6020 | 250 (150—350) |
| | Carbon Steel, Alloy Steel | 150HB—250HB | UE6020 | 175 (100—250) |
| M | Stainless Steel | ≤200HB | VP15TF | 100 (70—120) |

The above cutting conditions are general guidelines.
Adjustments maybe necessary depending on machine rigidity,
workpiece geometry and clamping.