

RECOMMENDED CUTTING CONDITIONS

Workpiece Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)			
				1.2, 1.5mm	2.0mm	3.0mm	4.0mm
P Carbon Steel Alloy Steel	180–280HB	UP20M • UTi20T	90 (60–120)	0.05 (0.02–0.08)	0.05 (0.02–0.08)	0.05 (0.02–0.08)	0.05 (0.02–0.08)
	280–350HB	UP20M • UTi20T	80 (50–100)	0.03 (0.02–0.04)	0.03 (0.02–0.04)	0.03 (0.02–0.04)	0.03 (0.02–0.04)