

RECOMMENDED CUTTING CONDITIONS

	Workpiece Material	Hardness	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	UP20M	140 (100—180)
			NX2525	200 (150—250)
			UTi20T	120 (100—150)
	Carbon Steel Alloy Steel	180HB—350HB	UP20M	120 (100—150)
			NX2525	170 (150—200)
			UTi20T	100 (70—120)
M	Stainless Steel	≤200HB	UP20M	120 (80—150)
			UTi20T	100 (70—130)
K	Gray Cast Iron	Tensile Strength≤350MPa	UP20M	80 (60—100)
			UTi20T	80 (60—100)
			HTi10	100 (70—130)