

RECOMMENDED CUTTING CONDITIONS

	Workpiece Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	Finish Cutting	F	AP25N	250 (150—300)
			Medium Cutting	MP	UE6020	250 (180—330)
	Carbon Steel Alloy Steel	180HB—350HB	Finish Cutting	F	AP25N	210 (150—260)
			Medium Cutting	MP	UE6020	210 (160—260)
M	Stainless Steel	≤200HB	Medium Cutting	MM	MP7035	100 (70—120)
K	Gray Cast Iron	Tensile Strength≤350MPa	Medium Cutting	MK	UE6020	220 (160—290)