

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardness	Grade	Cutting Speed (m/min)
P Mild Steel	≤180HB	UP20M	140 (100–180)
		NX55	200 (150–250)
		UTi20T	120 (100–150)
Carbon Steel Alloy Steel	180–280HB	UP20M	120 (100–150)
		NX55	170 (150–200)
		UTi20T	100 (70–120)

Work Material	Hardness	Grade	Cutting Speed (m/min)
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)