

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) |