

RECOMMENDED CUTTING CONDITIONS

	Workpiece Material	Hardness	Cutting Speed (m/min)
P	Carbon Steel · Alloy Steel	180HB~280HB	100 (50—150)
	Free Cutting Steel	—	110 (30—180)

	Workpiece Material	Hardness	Cutting Speed (m/min)
M	Stainless Steel	≤200HB	80 (50—120)
N	Non-Ferrous Metal	—	150 (70—230)