

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (SFM)	Feed per Tooth (inch/tooth)	
					Chamfer Milling	Face Milling
P	Carbon Steel Alloy Steel	180–280HB	UTi20T	590 (425–720)	.016	.006
			UP20M	590 (425–720)	.016	.008
			NX2525	590 (425–720)	.016	.008
		280–350HB	UTi20T	330 (230–395)	.012	.006
K	Cast Iron	Tensile Strength ≤450MPa	UTi20T	460 (330–560)	.020	.004
			HTi10	460 (330–560)	.020	.004