

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (SFM)
P	Mild Steel	≤ 180HB	UE6020	490—1150
	General Steel	150HB—250HB	UE6020	330—820

(Note) The above cutting conditions are general guide lines.
Adjustments maybe necessary depending on machine rigidity, workpiece geometry and clamping.