

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardness	Grade	Cutting Speed (SFM)	Feed (inch/rev)
P Carbon Steel Alloy Steel	180–280HB	UP20M • UTi20T	295 (195–390)	.002 (.0008–.003)
	280–350HB	UP20M • UTi20T	260 (165–330)	.001 (.0008–.0015)