



**Indicative cutting speeds for cut-off and grooving inserts**

Material	Indicative cutting speed (m/min)	
	U25 TIN (P25 P30 TIN)	U35 (P30 P45 TIALN)
Steel < 750 N/mm <sup>2</sup>	70 – 120	70 – 140
Steel < 1200 N/mm <sup>2</sup>	60 – 110	60 – 120
Stainless Steel < 900 N/mm <sup>2</sup>	60 – 120	50 - 120