



Indicative cutting speeds for negative turning inserts

Material	U35 (P15 P30 TIALN)	U-C (Uncoated Cermet)	ULC-TIN (Cermet + TIN)
Steel < 750 N/mm ²	120 – 160 m/min	120 – 180 m/min	120 – 200 m/min
Steel < 1200 N/mm ²	80 – 140 m/min	80 – 160 m/min	100 – 180 m/min
Stainless Steel < 900 N/mm ²	/	80 – 140 m/min	100 -180 m/min