



Indicative cutting speeds for positive inserts

Material	Indicative cutting speed (m/min)	
	U908	U25TIN
Steel < 750 N/mm ²	120 – 200 m/min	140 – 220 m/min
Steel < 1200 N/mm ²	100 – 160 m/min	100 – 180 m/min
Stainless Steel < 900 N/mm ²	/	80 – 120 m/min