



Speed $v_c$ (m/min)															
7792VX Series			Wear Resistance												
			Speed min. - max.												
Coolant Recommendation			PVD X Grade		CVD X Grade		PVD Standard		Uncoated Micrograin		CVD Standard		CVD Standard		
ISO	Materials	Rm and Hardness	X400		X500		SP6519		GH2		SC6525		SC3025		
			☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	
P	Unalloyed Steel	<600 N/mm <sup>2</sup> <180 HBN	☹	☹			☹	☹			☹	☹			
		120 - 260													
	<950 N/mm <sup>2</sup> <280 HBN	☹	☹			☹	☹			☹	☹				
	105 - 230														
Alloyed Steel	700-950 N/mm <sup>2</sup> 200-280 HBN	☹	☹	☹	☹	☹	☹			☹	☹				
	950-1200 N/mm <sup>2</sup> 280-355 HBN	☹	☹	☹	☹	☹	☹			☹	☹				
	1200-1400 N/mm <sup>2</sup> 355-415 HBN	☹	☹	☹	☹	☹	☹			☹	☹				
M	Stainless Steel	Austenitic + Ferritic 300 series			☹	☹	☹	☹							
		115 - 250													
		Martensitic 400 series			☹	☹	☹	☹							
		100 - 220													
	PH Stainless	Refractory P.H.			☹	☹	☹	☹							
		50 - 110													
K	Cast Iron	Grey GG-Ft													
		140 - 295													
		Spheroidal-Ductile GGG-FGS			☹	☹	☹	☹			☹	☹		☹	
		110 - 240													
		Malleable GTS - MN/MP													
		100 - 220													
N	Aluminium & Alloys	Aluminium & Alloys < 16% Si 116 HBN													
		305 - 2130													
		Aluminium + Silicon > 16% Si 92 HBN													
		245 - 1760													
S	High Temperature Alloys	Iron Based													
		23 - 48													
		Cobalt Based													
		21 - 44													
		Nickel Based													
		24 - 51													
		Titanium Based													
		35 - 73													
H	Hard Materials	Hard Steel >1400 N/mm <sup>2</sup> >415 HBN	☹	☹											
		45 - 95													
		Chilled Cast Iron >1400 N/mm <sup>2</sup> >400 HBN	☹	☹											
		35 - 80													