








Speed v_c (m/min)									
5230VS Series			Wear Resistance						
			-  +						
			Speed min. - max.						
Coolant Recommendation									
Recommended ● Possible ○									
ISO	Materials	Rm and Hardness	 		CVD X Grade	 		PVD Standard	CVD Standard
					X500			SP6519	MP91M
P	Unalloyed Steel	<600 N/mm ² <180 HBN	○	●	130 - 270	○	●	130 - 295	140 - 345
		<950 N/mm ² <280 HBN	○	●	115 - 240	○	●	115 - 260	120 - 305
	Alloyed Steel	700-950 N/mm ² 200-280 HBN	○	●	100 - 210	○	●	100 - 230	105 - 270
		950-1200 N/mm ² 280-355 HBN	○	●	75 - 160	○	●	75 - 175	80 - 205
		1200-1400 N/mm ² 355-415 HBN	○	●	50 - 100	○	●	50 - 110	50 - 130
M	Stainless Steel	Austenitic + Ferritic 300 series	○	●	115 - 250	○	●	115 - 270	
		Martensitic 400 series	○	●	100 - 220	○	●	105 - 235	
	PH Stainless	Refractory P.H.	○	●	50 - 110	○	●	50 - 120	
K	Cast Iron	Grey GG-Ft	○	●	120 - 280	○	●	140 - 295	145 - 365
		Spheroidal-Ductile GGG-FGS	○	●	105 - 205	○	●	110 - 240	115 - 285
		Malleable GTS - MN/MP	○	●	95 - 170	○	●	100 - 220	105 - 260
N	Aluminium & Alloys	Aluminium & Alloys < 16% Si 116 HBN	○	●		○	●		
		Aluminium + Silicon > 16% Si 92 HBN	○	●		○	●		
S	High Temperature Alloys	Iron Based	○	●	23 - 48	○	●	23 - 55	
		Cobalt Based	○	●	21 - 44	○	●	22 - 48	
		Nickel Based	○	●	24 - 51	○	●	25 - 55	
		Titanium Based	○	●	35 - 73	○	●	36 - 79	
H	Hard Materials	Hard Steel >1400 N/mm ² >415 HBN	○	●		○	●		
		Chilled Cast Iron >1400 N/mm ² > 400 HBN	○	●		○	●		