










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	
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	
		700-950 N/mm ² 200-280 HBN	○ ●	100 - 210	○ ●	100 - 230		105 - 270	
	Alloyed Steel	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							