Speed v_c (m/min)

80_VR00_R20 Series			Wear Resistance – → +					
			Speed min. - max.					
Coolant Recommendation Recommended ● Possible ⦿					CVD X Grade			PVD Standard
ISO	**Materials**	**Rm and Hardness**			X500			SP6519
P	Unalloyed Steel	<600 N/mm² <180 HBN	⦿	●	130 - 270	⦿	●	130 - 295
		<950 N/mm² <280 HBN			115 - 240			115 - 260
	Alloyed Steel	700-950 N/mm² 200-280 HBN	⦿	●	100 - 210	⦿	●	100 - 230
		950-1200 N/mm² 280-355 HBN			75 - 160			75 - 175
		1200-1400 N/mm² 355-415 HBN		●	50 - 100		●	50 - 110
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
		Spheroidal-Ductile GGG-FGS			105 - 205			110 - 240
		Malleable GTS - MN/MP			95 - 170			100 - 220
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/mm² >415 HBN						
		Chilled Cast Iron >1400 N/mm² > 400 HBN						