Speed v_c (m/min)

5210VS Series

Wear Resistance: – ⟵ +

Speed min. - max.

Coolant Recommendation
Recommended ● Possible ⦿

ISO	Materials	Rm and Hardness			PVD X Grade			CVD X Grade			PVD Standard			PVD Standard			CVD Standard
			💧	🚫	X400	💧	🚫	X500	💧	🚫	SP6519	💧	🚫	SP4019	💧	🚫	MP91M
P	Unalloyed Steel	<600 N/mm² <180 HBN	⦿	●	120 - 260	⦿	●	130 - 270	⦿	●	130 - 295					●	140 - 345
		<950 N/mm² <280 HBN			105 - 230			115 - 240			115 - 260						120 - 305
	Alloyed Steel	700-950 N/mm² 200-280 HBN	⦿	●	95 - 200	⦿	●	100 - 210	⦿	●	100 - 230					●	105 - 270
		950-1200 N/mm² 280-355 HBN			70 - 150			75 - 160			75 - 175						80 - 205
		1200-1400 N/mm² 355-415 HBN		●	45 - 95		●	50 - 100		●	50 - 110					●	50 - 130
M	Stainless Steel	Austenitic + Ferritic 300 series															
		Martensitic 400 series															
	PH Stainless	Refractory P.H.															
K	Cast Iron	Grey GG-Ft						120 - 280			140 - 295			145 - 330			145 - 365
		Spheroidal-Ductile GGG-FGS				⦿	●	105 - 205	⦿	●	110 - 240		●	115 - 255		●	115 - 285
		Malleable GTS - MN/MP						95 - 170			100 - 220			105 - 235			105 - 260
N	Aluminium & Alloys	Aluminium & Alloys < 16% Si 116 HBN															
		Aluminium + Silicon > 16% Si 92 HBN															
S	High Temperature Alloys	Iron Based															
		Cobalt Based															
		Nickel Based															
		Titanium Based															
H	Hard Materials	Hard Steel >1400 N/mm² >415 HBN		●	45 - 95								●	50 - 100		●	50 - 105
		Chilled Cast Iron >1400 N/mm² > 400 HBN			35 - 80									40 - 90			40 - 95