Speed v_c (m/min)

5230VS Series			Wear Resistance – → +								
			Speed min. - max.								
Coolant Recommendation Recommended ● Possible ⦿					CVD X Grade			PVD Standard			CVD Standard
ISO	Materials	Rm and Hardness	💧	🚫	X500	💧	🚫	SP6519	💧	🚫	MP91M
P	Unalloyed Steel	<600 N/mm² <180 HBN	⦿	●	130 - 270	⦿	●	130 - 295		●	140 - 345
		<950 N/mm² <280 HBN			115 - 240			115 - 260			120 - 305
	Alloyed Steel	700-950 N/mm² 200-280 HBN	⦿	●	100 - 210	⦿	●	100 - 230		●	105 - 270
		950-1200 N/mm² 280-355 HBN			75 - 160			75 - 175			80 - 205
		1200-1400 N/mm² 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/mm² >415 HBN									
		Chilled Cast Iron >1400 N/mm² > 400 HBN									