Speed v_c (m/min)

5315VA12 Series

Wear Resistance: – ⟵ +

Speed min. - max.

Coolant Recommendation
Recommended ● Possible ⦿

ISO	Materials	Rm and Hardness			CVD X Grade		PVD X Grade			PVD Standard		CVD Standard		CVD Standard		Uncoated Micrograin
			💧	🚫	X500	💧	🚫	X700	💧	🚫	SP6519	💧	🚫	MP91M	💧	🚫	SC3025	💧	🚫	GH1
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 - 260	⦿	●	115 - 270									
		Martensitic 400 series			100 - 220			105 - 230			105 - 235									
	PH Stainless	Refractory P.H.	●		50 - 110	●		50 - 115	●		50 - 120									
K	Cast Iron	Grey GG-Ft									140 - 235			145 - 365			150 - 395			
		Spheroidal-Ductile GGG-FGS							⦿	●	110 - 240		●	115 - 285		●	120 - 335			
		Malleable GTS - MN/MP									100 - 220			105 - 260			105 - 275			
N	Aluminium & Alloys	Aluminium & Alloys < 16% Si 116 HBN																●		400 - 3050
		Aluminium + Silicon > 16% Si 92 HBN																		295 - 2440
S	High Temperature Alloys	Iron Based	●		23 - 48	●		23 - 52	●		23 - 55									
		Cobalt Based			21 - 44			22 - 46			22 - 48									
		Nickel Based			24 - 51			25 - 53			25 - 55									
		Titanium Based			35 - 73			36 - 75			36 - 79									
H	Hard Materials	Hard Steel >1400 N/mm² >415 HBN																		
		Chilled Cast Iron >1400 N/mm² > 400 HBN																		