Speed v_c (m/min)

5315VA16 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	PVD Standard	CVD Standard	Uncoated Micrograin
			X400	X500	SP6519	SP4019	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	⦿ ● 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		⦿ ● 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					145 - 365	150 - 395	135 - 290
		Spheroidal-Ductile GGG-FGS				●	● 115 - 285	● 120 - 335 ⦿ ●	120 - 245
		Malleable GTS - MN/MP					105 - 260	105 - 275	115 - 200
N	Aluminium & Alloys	Aluminium & Alloys < 16% Si 116 HBN			●	400 - 2895		●	400 - 3050
		Aluminium + Silicon > 16% Si 92 HBN				295 - 2320			295 - 2440
S	High Temperature Alloys	Iron Based		● 23 - 48	● 23 - 55	24 - 63			
		Cobalt Based		21 - 44	22 - 48	23 - 52			
		Nickel Based		24 - 51	25 - 55	26 - 59			
		Titanium Based		35 - 73	36 - 79	37 - 84			
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		