Speed v_c (m/min)

5505VX Series					
					Speed min. - max.
Coolant Recommendation Recommended ● Possible ◉					PVD Standard
ISO	Materials	Rm and Hardness			SP6519
P	Unalloyed Steel	<600 N/mm² <180 HBN	◉	●	130 - 295
		<950 N/mm² <280 HBN			115 - 260
	Alloyed Steel	700-950 N/mm² 200-280 HBN	◉	●	100 - 230
		950-1200 N/mm² 280-355 HBN			75 - 175
		1200-1400 N/mm² 355-415 HBN		●	50 - 110
M	Stainless Steel	Austenitic + Ferritic 300 series	◉	●	115 - 270
		Martensitic 400 series			105 - 235
	PH Stainless	Refractory P.H.	●		50 - 120
K	Cast Iron	Grey GG-Ft	◉	●	140 - 295
		Spheroidal-Ductile GGG-FGS			110 - 240
		Malleable GTS - MN/MP			100 - 220
N	Aluminium & Alloys	Aluminium & Alloys < 16% Si 116 HBN			
		Aluminium + Silicon > 16% Si 92 HBN			
S	High Temperature Alloys	Iron Based	●		23 - 55
		Cobalt Based			22 - 48
		Nickel Based			25 - 55
		Titanium Based			36 - 79
H	Hard Materials	Hard Steel >1400 N/mm² >415 HBN			
		Chilled Cast Iron >1400 N/mm² > 400 HBN			