Speed v_c (m/min)

5500V Series					
			Speed min. - max.		
Coolant Recommendation Recommended ● Possible ⦿					PVD Micrograin
ISO	Materials	Rm and Hardness	💧	🚫	SP1019
P	Unalloyed Steel	<600 N/mm² <180 HBN		●	225 - 380
		<950 N/mm² <280 HBN			200 - 335
	Alloyed Steel	700-950 N/mm² 200-280 HBN		●	175 - 295
		950-1200 N/mm² 280-355 HBN			130 - 225
		1200-1400 N/mm² 355-415 HBN		●	85 - 145
M	Stainless Steel	Austenitic + Ferritic 300 series	⦿	●	200 - 335
		Martensitic 400 series			180 - 305
	PH Stainless	Refractory P.H.	●		85 - 145
K	Cast Iron	Grey GG-Ft	⦿	●	240 - 400
		Spheroidal-Ductile GGG-FGS			185 - 340
		Malleable GTS - MN/MP			170 - 285
N	Aluminium & Alloys	Aluminium & Alloys < 16% Si 116 HBN	●		400 - 2745
		Aluminium + Silicon > 16% Si 92 HBN			295 - 2135
S	High Temperature Alloys	Iron Based	●		40 - 67
		Cobalt Based			37 - 63
		Nickel Based			42 - 72
		Titanium Based			61 - 103
H	Hard Materials	Hard Steel >1400 N/mm² >415 HBN		●	50 - 110
		Chilled Cast Iron >1400 N/mm² > 400 HBN			40 - 90