STELLRAM

Contour Mills

Speed v_c (m/min)

7700VR Series

Wear Resistance: – ⟵ +

Speed min. - max.

Coolant Recommendation
Recommended ● Possible ⦿

ISO	Materials	Rm and Hardness	CVD X Grade		PVD X Grade		PVD Standard		Uncoated Micrograin		PVD Standard		CVD Standard		Uncoated Micrograin
			X500		X700		SP6519		GH2		SP4019		MP91M		GH1
P	Unalloyed Steel	<600 N/mm² <180 HBN	130 - 270	⦿ ●			130 - 295	⦿ ●			140 - 315	●	140 - 345		
		<950 N/mm² <280 HBN	115 - 240				115 - 260				120 - 275		120 - 305		
	Alloyed Steel	700-950 N/mm² 200-280 HBN	100 - 210	⦿ ●			100 - 230	⦿ ●			105 - 245	●	105 - 270		
		950-1200 N/mm² 280-355 HBN	75 - 160				75 - 175				80 - 190		80 - 205		
		1200-1400 N/mm² 355-415 HBN	50 - 100	●			50 - 110	●			50 - 120	●	50 - 130		
M	Stainless Steel	Austenitic + Ferritic 300 series	115 - 250	⦿ ●	115 - 260	⦿ ●	115 - 270	⦿ ●			120 - 280	⦿ ●			
		Martensitic 400 series	100 - 220		105 - 230		105 - 235				110 - 250				
	PH Stainless	Refractory P.H.	50 - 110	●	50 - 115	●	50 - 120	●		●	50 - 130				
K	Cast Iron	Grey GG-Ft	120 - 280	⦿ ●			140 - 295	⦿ ●			145 - 330	●	145 - 365		
		Spheroidal-Ductile GGG-FGS	105 - 205				110 - 240				115 - 255		115 - 285		
		Malleable GTS - MN/MP	95 - 170				100 - 220				105 - 235		105 - 260		
N	Aluminium & Alloys	Aluminium & Alloys < 16% Si 116 HBN							400 - 2745	●	400 - 2895			●	400 - 3050
		Aluminium + Silicon > 16% Si 92 HBN						●	295 - 2135		295 - 2320				295 - 2440
S	High Temperature Alloys	Iron Based	23 - 48	●	23 - 52	●	23 - 55	●			24 - 63				
		Cobalt Based	21 - 44		22 - 46		22 - 48				23 - 52				
		Nickel Based	24 - 51		25 - 53		25 - 55				26 - 59				
		Titanium Based	35 - 73		36 - 75		36 - 79				37 - 84				
H	Hard Materials	Hard Steel >1400 N/mm² >415 HBN													
		Chilled Cast Iron >1400 N/mm² > 400 HBN													