Speed v_c (m/min)

7702VRD & 7712VRD Series			Wear Resistance – → +					
			Speed min. - max.					
Coolant Recommendation Recommended ● Possible ⦿					PVD Standard			PVD Standard
ISO	Materials	Rm and Hardness	💧	🚫	SP5419	💧	🚫	SP4019
P	Unalloyed Steel	<600 N/mm² <180 HBN	⦿	●	115 - 205		●	140 - 315
		<950 N/mm² <280 HBN			105 - 185			120 - 275
	Alloyed Steel	700-950 N/mm² 200-280 HBN	⦿	●	90 - 160		●	105 - 245
		950-1200 N/mm² 280-355 HBN			70 - 120			80 - 190
		1200-1400 N/mm² 355-415 HBN		●	45 - 80		●	50 - 120
M	Stainless Steel	Austenitic + Ferritic 300 series						
		Martensitic 400 series						
	PH Stainless	Refractory P.H.						
K	Cast Iron	Grey GG-Ft						145 - 330
		Spheroidal-Ductile GGG-FGS					●	115 - 255
		Malleable GTS - MN/MP						105 - 235
N	Aluminium & Alloys	Aluminium & Alloys < 16% Si 116 HBN				●		400 - 2895
		Aluminium + Silicon > 16% Si 92 HBN						295 - 2320
S	High Temperature Alloys	Iron Based						
		Cobalt Based						
		Nickel Based						
		Titanium Based						
H	Hard Materials	Hard Steel >1400 N/mm² >415 HBN					●	50 - 100
		Chilled Cast Iron >1400 N/mm² > 400 HBN						40 - 90