STELLRAM



## Speed $v_c$ (m/min)

| 7710VRD20 Series | | | Wear Resistance: – ⟷ + | | | | |
|---|---|---|---|---|---|---|---|
| | | | Speed min. - max. | | | | |
| **Coolant Recommendation** Recommended ● Possible ⦿ | | | | | CVD X Grade | | PVD Standard |
| **ISO** | **Materials** | **Rm and Hardness** | 💧 | 🚫 | X500 | 💧 | 🚫 | SP6519 |
| P | Unalloyed Steel | <600 N/mm² <180 HBN | ⦿ | ● | 130 - 270 | ⦿ | ● | 130 - 295 |
| | | <950 N/mm² <280 HBN | | | 115 - 240 | | | 115 - 260 |
| | Alloyed Steel | 700-950 N/mm² 200-280 HBN | ⦿ | ● | 100 - 210 | ⦿ | ● | 100 - 230 |
| | | 950-1200 N/mm² 280-355 HBN | | | 75 - 160 | | | 75 - 175 |
| | | 1200-1400 N/mm² 355-415 HBN | | ● | 50 - 100 | | ● | 50 - 110 |
| 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 | ⦿ | ● | 120 - 280 | ⦿ | ● | 140 - 295 |
| | | Spheroidal-Ductile GGG-FGS | | | 105 - 205 | | | 110 - 240 |
| | | Malleable GTS - MN/MP | | | 95 - 170 | | | 100 - 220 |
| N | Aluminium & Alloys | Aluminium & Alloys < 16% Si 116 HBN | | | | | | |
| | | Aluminium + Silicon > 16% Si 92 HBN | | | | | | |
| S | High Temperature Alloys | Iron Based | ● | | 23 - 48 | ● | | 23 - 55 |
| | | Cobalt Based | | | 21 - 44 | | | 22 - 48 |
| | | Nickel Based | | | 24 - 51 | | | 25 - 55 |
| | | Titanium Based | | | 35 - 73 | | | 36 - 79 |
| H | Hard Materials | Hard Steel >1400 N/mm² >415 HBN | | | | | | |
| | | Chilled Cast Iron >1400 N/mm² > 400 HBN | | | | | | |