Speed v_c (m/min)

7713VR Series

Wear Resistance: – ⟵ +

Speed min. - max.

Coolant Recommendation
Recommended ● Possible ⦿

ISO	Materials	Rm and Hardness			CVD X Grade		PVD X Grade		PVD Standard		PVD Standard		CVD Standard		Uncoated Micrograin
					X500		X700		SP6519		SP4019		MP91M		GH1
P	Unalloyed Steel	<600 N/mm² <180 HBN	⦿	●	130 - 270			⦿	●	130 - 295				●	140 - 345		
		<950 N/mm² <280 HBN			115 - 240					115 - 260					120 - 305		
	Alloyed Steel	700-950 N/mm² 200-280 HBN	⦿	●	100 - 210			⦿	●	100 - 230				●	105 - 270		
		950-1200 N/mm² 280-355 HBN			75 - 160					75 - 175					80 - 205		
		1200-1400 N/mm² 355-415 HBN		●	50 - 100				●	50 - 110				●	50 - 130		
M	Stainless Steel	Austenitic + Ferritic 300 series	⦿	●	115 - 250	⦿	●	115 - 260	⦿ ●	115 - 270							
		Martensitic 400 series			100 - 220			105 - 230		105 - 235							
	PH Stainless	Refractory P.H.	●		50 - 110	●		50 - 115	●	50 - 120							
K	Cast Iron	Grey GG-Ft								140 - 295				●	145 - 365		
		Spheroidal-Ductile GGG-FGS							⦿ ●	110 - 240					115 - 285		
		Malleable GTS - MN/MP								100 - 220					105 - 260		
N	Aluminium & Alloys	Aluminium & Alloys < 16% Si 116 HBN									●	400 - 2895				●	400 - 3050
		Aluminium + Silicon > 16% Si 92 HBN										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												●	50 - 105		
		Chilled Cast Iron >1400 N/mm² > 400 HBN													40 - 95		