STELLRAM

Plunging Mills

Speed v_c (m/min)

7791VS Series

Wear Resistance: – ⟵ +

Speed min. - max.

Coolant Recommendation
Recommended ● Possible ⦿

ISO	Materials	Rm and Hardness	PVD X Grade		PVD X Grade		PVD X Grade		PVD Standard		PVD Standard		CVD Standard		Uncoated Micrograin
			X400		X500		X700		SP6519		SP4019		MP91M		GH1
P	Unalloyed Steel	<600 N/mm² <180 HBN	120 - 260	●	130 - 270	●			130 - 295			●	140 - 345		
		<950 N/mm² <280 HBN	105 - 230		115 - 240				115 - 260				120 - 305		
	Alloyed Steel	700-950 N/mm² 200-280 HBN	95 - 200	●	100 - 210	●			100 - 230			●	105 - 270		
		950-1200 N/mm² 280-355 HBN	70 - 150		75 - 160				75 - 175				80 - 205		
		1200-1400 N/mm² 355-415 HBN	45 - 95	●	50 - 100	●			50 - 110			●	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							140 - 295		145 - 330		145 - 365		135 - 290
		Spheroidal-Ductile GGG-FGS						●	110 - 240	●	115 - 255	●	115 - 285	●	120 - 245
		Malleable GTS - MN/MP							100 - 220		105 - 235		105 - 260		115 - 200
N	Aluminium & Alloys	Aluminium & Alloys < 16% Si 116 HBN												●	400 - 3050
		Aluminium + Silicon > 16% Si 92 HBN													295 - 2440
S	High Temperature Alloys	Iron Based			23 - 48		23 - 52		23 - 55						
		Cobalt Based		●	21 - 44	●	22 - 46	●	22 - 48						
		Nickel Based			24 - 51		25 - 53		25 - 55						
		Titanium Based			35 - 73		36 - 75		36 - 79						
H	Hard Materials	Hard Steel >1400 N/mm² >415 HBN	45 - 95	●						●	50 - 100	●	50 - 105		
		Chilled Cast Iron >1400 N/mm² > 400 HBN	35 - 80								40 - 90		40 - 95		