для размещения заказа - kennametal@kennametal.su



STELLRAM

## Speed $v_c$ (m/min)

| 7745VT & 7760VT Series | | | Wear Resistance – ← → + | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | Speed min. - max. | | | | | | | | | | | | | | | | | |
| Coolant Recommendation Recommended ● Possible ⊙ | | | | | PVD X Grade | | | CVD X Grade | | | PVD Standard | | | PVD Standard | | | CVD Standard | | | Uncoated Micrograin |
| ISO | Materials | Rm and Hardness | | | X400 | | | X500 | | | SP6519 | | | SP4019 | | | MP91M | | | GH1 |
| P | Unalloyed Steel | <600 N/mm² <180 HBN | ⊙ | ● | 120 - 260 | ⊙ | ● | 130 - 270 | ⊙ | ● | 130 - 295 | | ● | 140 - 315 | | ● | 140 - 345 | | | |
| | | <950 N/mm² <280 HBN | | | 105 - 230 | | | 115 - 240 | | | 115 - 260 | | | 120 - 275 | | | 120 - 305 | | | |
| | Alloyed Steel | 700-950 N/mm² 200-280 HBN | ⊙ | ● | 95 - 200 | ⊙ | ● | 100 - 210 | ⊙ | ● | 100 - 230 | | ● | 105 - 245 | | ● | 105 - 270 | | | |
| | | 950-1200 N/mm² 280-355 HBN | | | 70 - 150 | | | 75 - 160 | | | 75 - 175 | | | 80 - 190 | | | 80 - 205 | | | |
| | | 1200-1400 N/mm² 355-415 HBN | | ● | 45 - 95 | | ● | 50 - 100 | | ● | 50 - 110 | | ● | 50 - 120 | | ● | 50 - 130 | | | |
| M | Stainless Steel | Austenitic + Ferritic 300 series | | | | ⊙ | ● | 115 - 250 | ⊙ | ● | 115 - 270 | ⊙ | ● | 120 - 280 | | | | | | |
| | | Martensitic 400 series | | | | | | 100 - 220 | | | 105 - 235 | | | 110 - 250 | | | | | | |
| | PH Stainless | Refractory P.H. | | | | ● | | 50 - 110 | ● | | 50 - 120 | ● | | 50 - 130 | | | | | | |
| K | Cast Iron | Grey GG-Ft | | | | ⊙ | ● | 120 - 280 | ⊙ | ● | 140 - 295 | | ● | 145 - 330 | | ● | 145 - 365 | ⊙ | ● | 135 - 290 |
| | | Spheroidal-Ductile GGG-FGS | | | | | | 105 - 205 | | | 110 - 240 | | | 115 - 255 | | | 115 - 285 | | | 120 - 245 |
| | | Malleable GTS - MN/MP | | | | | | 95 - 170 | | | 100 - 220 | | | 105 - 235 | | | 105 - 260 | | | 115 - 200 |
| 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 - 55 | ● | | 24 - 63 | | | | | | |
| | | Cobalt Based | | | | | | 21 - 44 | | | 22 - 48 | | | 23 - 52 | | | | | | |
| | | Nickel Based | | | | | | 24 - 51 | | | 25 - 55 | | | 26 - 59 | | | | | | |
| | | Titanium Based | | | | | | 35 - 73 | | | 36 - 79 | | | 37 - 84 | | | | | | |
| H | Hard Materials | Hard Steel >1400 N/mm² >415 HBN | | ● | 45 - 95 | | | | | | | | ● | 50 - 100 | | | | | | |
| | | Chilled Cast Iron >1400 N/mm² > 400 HBN | | | 35 - 80 | | | | | | | | | 40 - 90 | | | | | | |

Chamfering Mills



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