STELLRAM

Speed v_c (m/min)

5400VM Series

Wear Resistance: – ⟵ +

Speed min. - max.

Coolant Recommendation
Recommended ● Possible ⦿

ISO	Materials	Rm and Hardness			PVD X Grade			CVD X Grade			PVD Standard			PVD Standard			CVD Standard			Uncoated Micrograin
			💧	🚫	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				
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																							
		Cobalt Based																							
		Nickel Based																							
		Titanium Based																							
H	Hard Materials	Hard Steel >1400 N/mm² >415 HBN																							
		Chilled Cast Iron >1400 N/mm² > 400 HBN																							

T-Slot Mills