STELLRAM

Speed v_c (m/min)

7220VM Series

Wear Resistance: – ⟷ +

Speed min. - max.

Coolant Recommendation
Recommended ● Possible ⦿

ISO	Materials	Rm and Hardness			PVD X Grade X400			CVD X Grade X500			PVD Standard SP6519			PVD Standard SP4019			CVD Standard MP91M			Uncoated Micrograin 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																		
		Chilled Cast Iron >1400 N/mm² > 400 HBN																		

Disc Mills & Cartridges