STELLRAM

Speed v_c (m/min)

For all Families

Wear Resistance: – ⟵ +

Speed min. - max.

Coolant Recommendation
Recommended ● Possible ⦿

ISO	Materials	Rm and Hardness	CVD Standard MP91M	CVD Standard SC6525	CVD Standard SC3025	Uncoated Micrograin GH1*	PVD Micrograin SP1019	Uncoated Cermet SA9808	Uncoated Cermet SA9608
P	Unalloyed Steel	<600 N/mm² <180 HBN	140 - 345	⦿ ● 140 - 370		● 240 - 345	● 225 - 380	● 240 - 345	● 265 - 380
		<950 N/mm² <280 HBN	120 - 305	⦿ ● 120 - 325		● 215 - 305	● 200 - 335	● 215 - 305	● 235 - 335
	Alloyed Steel	700-950 N/mm² 200-280 HBN	105 - 270	⦿ ● 105 - 290		● 190 - 270	● 175 - 295	● 190 - 270	● 205 - 295
		950-1200 N/mm² 280-355 HBN	80 - 205	⦿ ● 80 - 210		● 140 - 205	● 130 - 225	● 140 - 205	● 155 - 225
		1200-1400 N/mm² 355-415 HBN	● 50 - 130	● 50 - 140		● 90 - 130	● 85 - 145	● 90 - 130	● 100 - 145
M	Stainless Steel	Austenitic + Ferritic 300 series			⦿ ●	⦿ ● 215 -305	⦿ ● 200 - 335		⦿ ● 235 -335
		Martensitic 400 series				195 - 275	180 - 305		215 - 305
	PH Stainless	Refractory P.H.			●	● 90 - 180	● 85 - 145		● 100 - 200
K	Cast Iron	Grey GG-Ft	145 - 365	145 - 390	150 - 395	135 - 290	240 - 400		280 -400
		Spheroidal-Ductile GGG-FGS	● 115 - 285	● 115 - 305	● 120 - 335	⦿ ● 120 - 245	⦿ ● 185 - 340		● 220 -315
		Malleable GTS - MN/MP	105 - 260		105 - 275	115 - 200	170 - 285		200 -285
N	Aluminium & Alloys	Aluminium & Alloys < 16% Si 116 HBN			●	400 - 3050	● 400 - 2745		
		Aluminium + Silicon > 16% Si 92 HBN				295 - 2440	295 - 2135		
S	High Temperature Alloys	Iron Based					40 - 67		50 - 75
		Cobalt Based					● 37 - 63	●	48 - 70
		Nickel Based					42 - 72		52 - 75
		Titanium Based					61 - 103		60 - 95
H	Hard Materials	Hard Steel >1400 N/mm² >415 HBN	● 50 - 105				● 50 - 110		
		Chilled Cast Iron >1400 N/mm² > 400 HBN	40 - 95				45 - 100		

* Note: Wiper Insert SPHX12M512EN GH1 can be used for Steel, Steel Alloys, Stainless Steel and Cast Iron.
* Note: All other GH1 Grade Inserts are only for Aluminium or Cast Iron depending on the selected Geometry.

Technical