Recommended Speeds

Speed v_c (m/min)					
XE / XER Series					Speed min. - max.
Coolant Recommendation Recommended ● Possible ⦿					PVD Standard
ISO	**Materials**	**Rm and Hardness**			SP4060
P	Unalloyed Steel	<600 N/mm² <180 HBN			
		<950 N/mm² <280 HBN			
	Alloyed Steel	700-950 N/mm² 200-280 HBN			
		950-1200 N/mm² 280-355 HBN	●	⦿	50 - 280
		1200-1400 N/mm² 355-415 HBN			45 - 160
M	Stainless Steel	Austenitic + Ferritic 300 series	●	⦿	95 - 200
		Martensitic 400 series			70 - 145
	PH Stainless	Refractory P.H.	●		60 - 110
K	Cast Iron	Grey GG-Ft			
		Spheroidal-Ductile GGG-FGS			
		Malleable GTS - MN/MP			
N	Aluminium & Alloys	Aluminium & Alloys < 16% Si 116 HBN			
		Aluminium + Silicon > 16% Si 92 HBN			
S	High Temperature Alloys	Iron Based			60 - 140
		Cobalt Based	●	⦿	20 - 75
		Nickel Based			25 - 80
		Titanium Based			40 - 120
H	Hard Materials	Hard Steel >1400 N/mm² >415 HBN			
		Chilled Cast Iron >1400 N/mm² > 400 HBN			