Recommended Speeds

Speed v_c (m/min)

HE Series					
			Speed min. - max.		
Coolant Recommendation Recommended ● Possible ⦿					PVD Standard
ISO	Materials	Rm and Hardness	💧	⊘	SP4035
P	Unalloyed Steel	<600 N/mm² <180 HBN			
		<950 N/mm² <280 HBN			
	Alloyed Steel	700-950 N/mm² 200-280 HBN	●	⦿	70 - 320
		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			
		Martensitic 400 series			
	PH Stainless	Refractory P.H.			
K	Cast Iron	Grey GG-Ft	●	⦿	100 - 225
		Spheroidal-Ductile GGG-FGS			70 - 155
		Malleable GTS - MN/MP			65 - 130
N	Aluminium & Alloys	Aluminium & Alloys < 16% Si 116 HBN			
		Aluminium + Silicon > 16% Si 92 HBN			
S	High Temperature Alloys	Iron Based			
		Cobalt Based			
		Nickel Based			
		Titanium Based			
H	Hard Materials	Hard Steel >1400 N/mm² >415 HBN		⦿	60 - 140
		Chilled Cast Iron >1400 N/mm² > 400 HBN			50 - 130