STELLRAM

HSM

Solid Carbide
Rapide End Mill

Recommended Speeds

Speed v_c (m/min)					
HMR Series					Speed min. - max.
Coolant Recommendation Recommended ● Possible ⦿					PVD Standard
ISO	**Materials**	**Rm and Hardness**			SP4035
P	Unalloyed Steel	<600 N/mm² <180 HBN	●	⦿	100 - 450
		<950 N/mm² <280 HBN			90 - 400
	Alloyed Steel	700-950 N/mm² 200-280 HBN	●	⦿	90 - 400
		950-1200 N/mm² 280-355 HBN			60 - 350
		1200-1400 N/mm² 355-415 HBN			55 - 200
M	Stainless Steel	Austenitic + Ferritic 300 series			
		Martensitic 400 series			
	PH Stainless	Refractory P.H.			
K	Cast Iron	Grey GG-Ft	●	⦿	120 - 280
		Spheroidal-Ductile GGG-FGS			90 - 190
		Malleable GTS - MN/MP			80 - 160
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		⦿	80 - 175
		Chilled Cast Iron >1400 N/mm² > 400 HBN			70 - 160