STELLRAM

Solid Carbide

General Purpose - Eng Milling

Recommended Speeds

Speed v_c (m/min)

E_NN2 Series			Speed min. - max.		
Coolant Recommendation Recommended ● Possible ⦿					PVD Micrograin
ISO	**Materials**	**Rm and Hardness**	💧	⊘	SP4556
P	Unalloyed Steel	<600 N/mm² <180 HBN	●	⦿	125 - 180
		<950 N/mm² <280 HBN			100 - 170
	Alloyed Steel	700-950 N/mm² 200-280 HBN	●	⦿	100 - 170
		950-1200 N/mm² 280-355 HBN			90 - 140
		1200-1400 N/mm² 355-415 HBN			80 - 120
M	Stainless Steel	Austenitic + Ferritic 300 series	●	⦿	85 - 120
		Martensitic 400 series			65 - 90
	PH Stainless	Refractory P.H.	●		50 - 80
K	Cast Iron	Grey GG-Ft	●	⦿	90 - 150
		Spheroidal-Ductile GGG-FGS			60 - 120
		Malleable GTS - MN/MP			50 - 100
N	Aluminium & Alloys	Aluminium & Alloys < 16% Si 116 HBN			
		Aluminium + Silicon > 16% Si 92 HBN			
S	High Temperature Alloys	Iron Based	●	⦿	40 - 90
		Cobalt Based			20 - 40
		Nickel Based			25 - 45
		Titanium Based			30 - 60
H	Hard Materials	Hard Steel >1400 N/mm² >415 HBN			
		Chilled Cast Iron >1400 N/mm² > 400 HBN			