Speed vc (feet/min)			
ISO	**Materials**	**Rm**	Kc:N/mm^2
P	Unalloyed Steel	400-600 N/mm^2 120-180 HBN	2050
		600-950 N/mm^2 180-200 HBN	2300
	Alloyed Steel	700-950 N/mm^2 200-280 HBN	2599
		950-1200 N/mm^2 280-355 HBN	2851
		1200-1400 N/mm^2 355-415 HBN	3172
	Tool Steel	1200-1400 N/mm^2 355-415 HBN	3895
M	Stainless Steel	Austenitic + Ferritic 300 series	1847
		Martensitic 400 series	2599
	PH Stainless	Refractory P.H.	3199
K	Cast Iron	Grey GG-Ft	1200
		Spheroidal-Ductile GGG-FGS	1500
		Nodular GGGNi - L- N	1600
		Malleable GTS - MN/MP	1050
N	Aluminium & Alloys	Aluminium & Alloys < 16% 116 HBN	827
		Aluminium + Silicon > 16% 92 HBN	965
S	High Temperature Alloys	Iron Based	2999
		Cobalt Based	3799
		Nickel Based	3500
		Titanium Based 425-456 HBN	1500