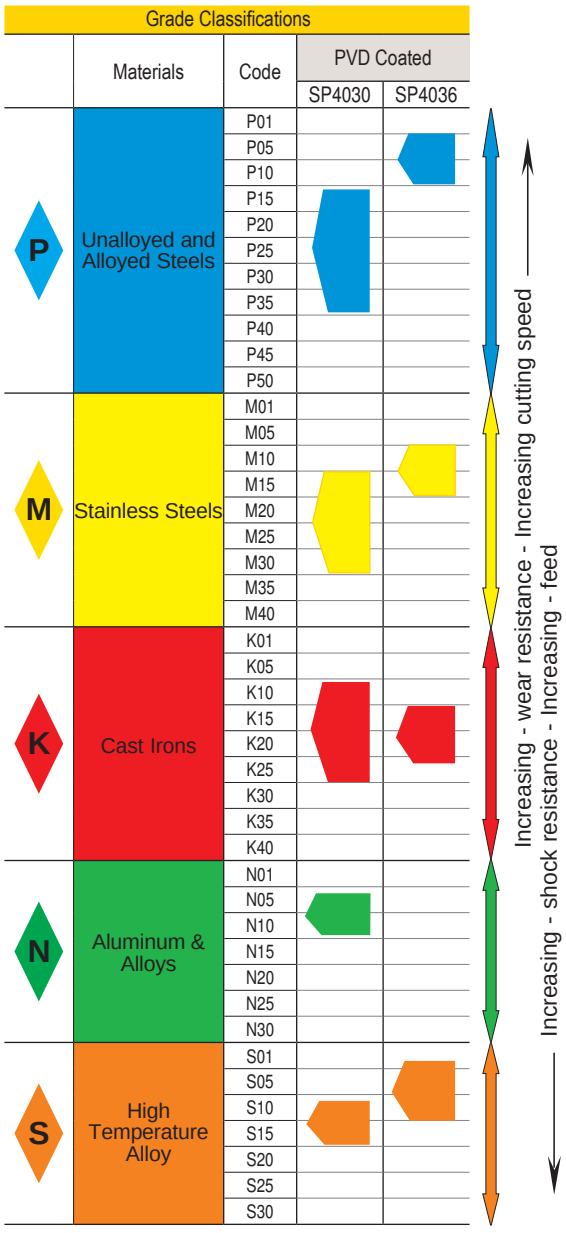
STELLRAM

Grooving Grades

SP4030 and SP0436 are PVD coated grades with a micrograin substrate for machining at higher speeds with lower feed. Ideal for Stainless Steels and Ductile materials.

Optimum Grade Performance



Cutting Speed v_c

ISO	Materials	Rm and Hardness	PVD SP4030 m/min min. - max.	PVD SP4036 m/min min. - max.
P	Unalloyed Steel	<600 N/mm² <180 HBN	135 - 271	162 - 325
		<950 N/mm² <280 HBN	88- 176	105- 211
	Alloyed Steel	700-950 N/mm² 200-280 HBN	80 - 161	97 - 193
		950-1200 N/mm² 280-355 HBN	73 - 146	88 - 176
		1200-1400 N/mm² 355-415 HBN	50 - 100	60 - 120
M	Stainless Steel	Austenitic + Ferritic 300 series	107 - 229	128 - 274
		Martensitic 400 series	102 - 220	123 - 263
	PH Stainless	Refractory P.H.	57 - 122	68 - 146
K	Cast Iron	Grey GG-Ft	134 - 268	161 - 322
		Spheroidal-Ductile GGG-FGS	116 - 232	139 - 278
		Malleable GTS - MN/MP	78 - 156	94 - 187
N	Aluminium & Alloys	Aluminium & Alloys < 16% 116 HB	366 - 915	439 - 1098
		Aluminium + Silicon > 16% 92 HB	244 - 610	293 - 732
S	High Temperature Alloys	Iron Based	20 - 39	23 - 47
		Cobalt Based	16 - 32	19 - 38
		Nickel Based	17 - 34	20 - 41
		Titanium Based	27 - 54	32 - 64