STELLRAM

Part-Off Grade Description

MP91M CVD Coated grade offering good wear, and shock resistance. Ideal for Steels and Cast Irons



Cutting Speed v_c

ISO	Materials	Rm and Hardness	CVD MP91M m/min min. - max.
P	Unalloyed Steel	<600 N/mm² <180 HBN	140- 345
		<950 N/mm² <280 HBN	125 - 300
	Alloyed Steel	700-950 N/mm² 200-280 HBN	105 - 270
		950-1200 N/mm² 280-355 HBN	80 - 205
		1200-1400 N/mm² 355-415 HBN	50 - 130
K	Cast Iron	Grey GG-Ft	145 - 365
		Spheroidal-Ductile GGG-FGS	115 - 285
		Malleable GTS - MN/MP	105 - 260
H	Hard Materials	Hard Steel >1400 N/mm² >415 HBN	50 - 80
		Chilled Cast Iron² 1400 N/mm² 400 HBN	40 - 65



Optimum Grade Performance

