



Speed v_c (m/min)																	
7792VX Series			Wear Resistance														
			-  +														
			Speed min. - max.														
Coolant Recommendation Recommended ● Possible ◎				PVD X Grade		CVD X Grade		PVD Standard		Uncoated Micrograin		CVD Standard		CVD Standard			
ISO	Materials	Rm and Hardness	 	X400	 	X500	 	SP6519	 	GH2	 	SC6525	 	SC3025			
P	Unalloyed Steel	<600 N/mm ² <180 HBN	◎	●	120 - 260			◎	●	130 - 295			◎	●	140 - 370		
		<950 N/mm ² <280 HBN			105 - 230										120 - 325		
	Alloyed Steel	700-950 N/mm ² 200-280 HBN	◎	●	95 - 200	◎	●	◎	●	100 - 230			◎	●	105 - 290		
		950-1200 N/mm ² 280-355 HBN			70 - 150					75 - 175					80 - 210		
1200-1400 N/mm ² 355-415 HBN			●	45 - 95		●		●	50 - 110				●	50 - 140			
M	Stainless Steel	Austenitic + Ferritic 300 series				◎	●	◎	●	115 - 270							
		Martensitic 400 series								105 - 235							
	PH Stainless	Refractory P.H.				●		●		50 - 120							
K	Cast Iron	Grey GG-Ft								140 - 295					145 - 390		150 - 395
		Spheroidal-Ductile GGG-FGS						◎	●				●		115 - 305	●	120 - 335
		Malleable GTS - MN/MP								100 - 220							105 - 275
N	Aluminium & Alloys	Aluminium & Alloys < 16% Si 116 HBN						●		305 - 2130	●						
		Aluminium + Silicon > 16% Si 92 HBN								245 - 1760					295 - 2135		
S	High Temperature Alloys	Iron Based						23 - 48		23 - 55							
		Cobalt Based				●		21 - 44	●	22 - 48							
		Nickel Based						24 - 51		25 - 55							
		Titanium Based						35 - 73		36 - 79							
H	Hard Materials	Hard Steel >1400 N/mm ² >415 HBN		●	45 - 95												
		Chilled Cast Iron >1400 N/mm ² > 400 HBN			35 - 80												