

Cutting Data

ISO Standard	Material	Cutting Speed m/min	Cutting Diameter = D Feed mm/tooth		
			D ≤ 4	4 < D < 9	D ≥ 9
P	Low & Medium Carbon Steels < 0.55%C	100-250	0.03-0.04	0.03-0.08	0.08-0.12
	High Carbon Steels ≥ 0.55%C	110-180	0.02-0.03	0.02-0.07	0.07-0.10
	Alloy Steels, Treated Steels	90-160	0.02-0.03	0.03-0.06	0.05-0.08
M	Stainless Steel-Free Cutting	60-160	0.02-0.03	0.03-0.06	0.05-0.08
	Stainless Steel-Austenitic	60-120	0.02-0.03	0.03-0.05	0.04-0.07
	Cast Steels	130-170	0.02-0.03	0.03-0.05	0.04-0.07
K	Cast Iron	70-150	0.03-0.04	0.05-0.08	0.08-0.12
N	Aluminum ≤ 12%Si, Copper	150-350	0.03-0.04	0.05-0.08	0.08-0.12
	Aluminum > 12%Si	100-250	0.02-0.03	0.03-0.05	0.04-0.07
	Synthetics, Duroplastics, Thermoplastics	100-400	0.05-0.07	0.07-0.11	0.10-0.15
S	Nickel alloys, Titanium alloys.	20-80	0.02-0.03	0.02-0.03	0.02-0.04
H	Hardened Steel 45-50 HRc	60-70	0.02-0.03	0.02-0.03	0.02-0.04
	Hardened Steel 50-55 HRc	50-60	0.01-0.02	0.01-0.02	0.01-0.03