

Grades, Speeds & Feeds

MATERIAL	RECOMMENDED CARBIDE GRADE	FEED MM REV			
		0,025	0,05	0,1	0,2
CUTTING SPEED M/MIN					
Low carbon steel	P30C	130	100	90	90
Carbon steel	P30C	160	140	110	
Alloyed steel	P30C		110	80	75
Stainless steel	P30C		100	90	70
Cast steel	P30C		80	65	50
Heat resistant Iron-based alloys	K10C	100	65	60	40
Hard steel (Manganese steel)	K10		20	15	
Malleable Iron	K10C	130	130	110	
Cast Iron	K10C	110	110	95	
Aluminium alloys	K10		240	200	
Heat resistant Nickel-based alloys	K10	30	20	12	
Heat resistant Cobalt-based alloys	K10	30	20	12	
Non-Ferrous materials	K10	240	160	120	

NOTE

The above data are for guidance only.
Actual performance depends on various factors,
such as mounting stability, workpiece shape
and specific material characteristics.