

| Material groups           |  |  | Application                           | Cutting speed m/min |
|---------------------------|--|--|---------------------------------------|---------------------|
| Non-ferrous metals        | Soft non-ferrous metals  | Alu alloys, brass copper, zinc                             | Coarse machining = high stock removal | 600 - 1100          |
|                           |  |  | Fine machining = low stock removal    | 900 - 1100          |
|                           | Hard non-ferrous metals  | Bronze, titanium, hard aluminium alloys, (high Si content) | Coarse machining = high stock removal | 600 - 1100          |
|                           |  |  | Fine machining = low stock removal    | 900 - 1100          |
| Plastics, other materials | Fibre-reinforced plastic (GRP/CRP) thermoplastics, hard rubber |  | Coarse machining = high stock removal | 500 - 1100          |
|                           |  |  | Fine machining = low stock removal    | 500 - 1100          |



| Cutting speed (m/min) |                        |        |         |         |
|-----------------------|------------------------|--------|---------|---------|
|                       | 500                    | 600    | 900     | 1100    |
| ∅ (mm)                | Rotational speed (rpm) |        |         |         |
| 2                     | 80,000                 | 95,000 | 143,000 | 175,000 |
| 3                     | 53,000                 | 64,000 | 95,000  | 116,000 |
| 4                     | 40,000                 | 48,000 | 72,000  | 88,000  |
| 6                     | 27,000                 | 32,000 | 48,000  | 59,000  |
| 8                     | 20,000                 | 24,000 | 36,000  | 44,000  |
| 10                    | 16,000                 | 19,000 | 29,000  | 35,000  |
| 12                    | 13,000                 | 16,000 | 24,000  | 30,000  |
| 16                    | 10,000                 | 12,000 | 18,000  | 22,000  |
| 20                    | 8,000                  | 10,000 | 14,000  | 17,000  |
| 25                    | 6,000                  | 8,000  | 11,000  | 13,500  |

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