

| 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 |

