

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

