

Material groups			Application	Cutting speed m/min
Stainless steel INOX	Rust- and acid-resistant steels	Austenitic and ferritic stainless steels	Coarse machining = high stock removal	450 - 600
			Fine machining = low stock removal	



Cutting speed (m/min)			
		450	600
∅ (mm)	Rotational speed (rpm)		
3		48,000	64,000
6		24,000	32,000
8		18,000	24,000
10		14,000	19,000
12		12,000	16,000
16		9,000	12,000

