

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

