

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

