

Material groups		Application	Cutting speed m/min
Steel, cast steel	Non-hardened, non-heat treated steels up to 1200 N/mm <sup>2</sup> (< 38 HRC)	Construction steels, carbon steels, tool steels, non-alloyed steels, case-hardened steels, cast steels	450 - 750
	Hardened, heat treated steels exceeding 1200 N/mm <sup>2</sup> (> 38 HRC)	tool steels, tempering steels, alloyed steels, cast steels	



Cutting speed (m/min)		
	450	750
∅ (mm)	Rotational speed (rpm)	
3	48,000	80,000
6	24,000	40,000
8	18,000	30,000
10	14,000	24,000
12	12,000	20,000
16	9,000	17,000

