

STANDARD CUTTING CONDITIONS

ISO	Workpiece materials	Cutting speed Vc (m/min)	Feed: f (mm/rev)		
			øDc (mm)		
			26 - 29.9	30.0 - 35.9	36.0 - 41.0
P	Low carbon steel (C15, C20, etc.)	80 - 140	0.2 - 0.5	0.2 - 0.5	0.2 - 0.55
	Carbon steel and alloy steel (S55C / C55, SCM440 / 42CrMo4, etc.)	80 - 130	0.2 - 0.5	0.2 - 0.5	0.2 - 0.55
	Prehardend steel (NAK80, PX5, etc.)	50 - 100	0.2 - 0.5	0.2 - 0.5	0.2 - 0.55
M	Stainless steel (SUS304 / X5CrNi18-9, SUS316 / X5CrNiMo17-12-3, etc.)	40 - 80	0.15 - 0.3	0.15 - 0.3	0.2 - 0.35
K	Grey cast iron (FC250 / 250, FC300 / 300, etc.)	80 - 180	0.25 - 0.55	0.25 - 0.55	0.3 - 0.6
	Ductile cast iron (400-15, 600-3, etc.)	80 - 140	0.25 - 0.55	0.25 - 0.55	0.3 - 0.6
N	Non ferrous materials	100 - 200	0.4 - 0.6	0.4 - 0.6	0.5 - 0.7
S	Heat-resistant alloys (Inconel718, etc.)	20 - 50	0.1 - 0.2	0.1 - 0.2	0.1 - 0.25
	Titanium alloys (Ti-6Al-4V, etc.)	20 - 50	0.1 - 0.2	0.1 - 0.2	0.1 - 0.25
H	Hardened materials	20 - 60	0.1 - 0.2	0.1 - 0.2	0.1 - 0.25