

Cutting Data

ISO Standard	Materials	Cutting Speed ft/min	
		K20	BLU
P	Low & Medium Carbon Steels <0.55%C	---	262-492
	High Carbon Steels ≥0.55%C	---	230-394
	Alloy Steels, Treated Steels	---	131-262
M	Stainless Steel-Free Cutting	98-262	197-394
	Stainless Steel-Austenitic	66-230	98-295
	Cast Steels	98-262	164-394
K	Cast Iron	164-394	---
N	Aluminium ≤12%Si, Copper	394-820	---
	Aluminium >12%Si	295-656	---
	Synthetics, Duroplastics, Thermoplastics	230-492	---
S	Nickel alloys, Titanium alloys.	66-164	98-230
H	Hardened Steel, 45-50HRc	---	66-164