

## Cutting Data

### FMT - Fast MT type

**MT8** Sub Micron grade with advanced PVD triple coating (ISO K10-K20).  
Extremely high heat resistant and smooth cutting operation, for high performance and normal machining conditions. General purpose for all materials.

ISO Standard	Materials	Cutting Speed m/min	Feed mm/tooth Cutting Diameter = D				
			Ø5	Ø6	Ø8	Ø10	Ø12
<b>P</b>	Low and Medium Carbon Steels < 0.55%C	100 - 250	0.03	0.06	0.07	0.08	0.09
	High Carbon Steels ≥ 0.55%C	110 - 180	0.03	0.05	0.06	0.07	0.08
	Alloy Steels, Treated Steels	90 - 60	0.02	0.03	0.04	0.05	0.05
<b>M</b>	Stainless Steel - Free Cutting	60 - 160	0.03	0.04	0.05	0.06	0.06
	Stainless Steel - Austenitic	60 - 120	0.01	0.03	0.04	0.05	0.05
	Cast Steels	130 - 170	0.02	0.03	0.04	0.05	0.05
<b>K</b>	Cast Iron	70 - 150	0.04	0.06	0.07	0.08	0.09
<b>N</b>	Aluminum ≤ 12%Si, Copper	150 - 350	0.04	0.06	0.07	0.08	0.09
	Aluminum > 12%Si	100 - 250	0.03	0.03	0.04	0.05	0.05
	Synthetics, Duroplastics, Thermoplastics	100 - 400	0.06	0.08	0.10	0.11	0.12
<b>S</b>	Nickel Alloys, Titanium Alloys.	20 - 80	0.02	0.03	0.03	0.03	0.03
<b>H</b>	Hardened Steel, 45-50HRc	60 - 70	0.02	0.03	0.03	0.03	0.03