

# CUTTING DATA



## Nominal cutting speeds with HORN grades

			Feed rate IPR						
			Supermini®		Mini				
				.0004"-.0008"		.0004"-.0012"			
				.0008"-.002"		.0012"-.004"			
				.0008"-.002"		.0004"-.003"			
ISO	Material	Hardness Brinell	Cutting speed *v <sub>c</sub> ft/m						
			MG12	TN35	T125	TF45	TH35	CB10/50	
<b>P</b>	Carbon steel	C < 0,4%	125						
		C > 0,4% < 0,6 %	150	46-361	46-590	46-590	46-590	46-590	
		C > 0,4% < 0,6 %	200						
	low alloyed steel	annealed	180						
		quenched	275	53-295	53-492	53-492		53-590	
		quenched	300						
	high alloyed steel	annealed	200		63-295	63-295		63-400	
		quenched	325						
	Cast steel	unalloyed	180						
		low alloyed	220	63-361	63-590	63-590		63-590	
high alloyed		225							
<b>M</b>	Stainless steel	martensitic, ferritic	200		63-295	63-295		63-295	
		austenitic	180		53-263		53-263		
<b>K</b>	Cast iron	180-260	53-295	53-492	53-492	53-492	53-492		
	Spheroidal graphite cast iron	180-260	53-295	53-425	53-425	53-492	53-492		
	Malleable cast iron	130-230		53-425	53-425	53-492	53-492		
<b>S</b>	Heat resistant alloy	NiFe			59-246	59-246	59-246		
		NiCo			59-131	59-131	59-131		
<b>N</b>	Al-alloy		46-722	53-1970	53-1970		53-1970		
	Copper and brass alloys		46-722	46-2300	46-2300		46-2300		
<b>H</b>	hardened material	> 54 HRC						65-455	



V<sub>c</sub> is depending on the tool diameter and therefore of the maximum numbers of revolutions of the machine.