

## STANDARD CUTTING CONDITIONS

ISO	Workpiece materials	Grade	Cutting speed Vc (sfm)
<b>P</b>	Low carbon steels Alloy steels (1015, etc.)	NS9530	492 - 820
		GT9530	492 - 984
		T9115	492 - 984
		T9125	394 - 820
	Medium carbon steels Alloy steels (1045, 4140, etc.)	NS9530	262 - 722
		GT9530	262 - 820
		T9115	492 - 984
		T9125	262 - 656
	High carbon steels Alloy steels (D2, etc.)	NS9530	262 - 591
		GT9530	262 - 656
		T9115	394 - 820
		T9125	262 - 492
<b>M</b>	Austenitic (S30400, S31600, etc.)	T6120	459 - 787
		T6130	328 - 656
		AH630	295 - 623
		AH645	230 - 492
	Ferritic / Martensitic (S4300, S4200, etc.)	T6120	525 - 919
		T6130	394 - 787
		AH630	361 - 689
		AH645	295 - 558
	Precipitation hardened (S17400, etc.)	T6120	262 - 492
		T6130	230 - 361
		AH630	197 - 295

Note: See page 9 for more information about grades.