

Material	Cutting Speed m/min	Ø <3	Ø 3-6	Ø 8-10	Ø 12-16	Ø 16-20
Low Alloy Steel <25Hrc	80-200	0.010-0.030	0.020-0.040	0.030-0.060	0.030-0.070	0.040-0.100
High Alloy Steel >25Hrc	60-110	0.010-0.025	0.015-0.030	0.025-0.050	0.030-0.060	0.040-0.080
Hardened Steel	20-50	0.010-0.020	0.015-0.030	0.020-0.040	0.030-0.050	0.030-0.050
Stainless Steel	40-100	0.010-0.020	0.020-0.040	0.030-0.050	0.030-0.060	0.030-0.080
Cast Iron (GGG)	65-150	0.010-0.020	0.020-0.040	0.030-0.050	0.030-0.060	0.030-0.080
Cast Iron (GG)	80-200	0.010-0.025	0.020-0.045	0.030-0.055	0.035-0.055	0.040-0.090
Titanium	30-60	0.010-0.020	0.020-0.040	0.030-0.050	0.030-0.060	0.030-0.080
Inconel	15-40	0.010-0.020	0.015-0.030	0.025-0.040	0.030-0.045	0.030-0.050
Aluminium	270-600	0.030-0.050	0.040-0.060	0.050-0.100	0.06-0.120	0.080-0.250