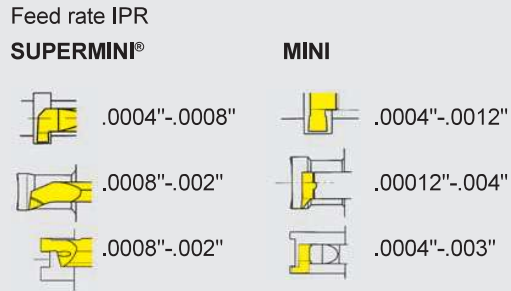


Nominal cutting speeds with HORN grades

ISO	Material	Hardness Brinell	Cutting speed *v _c ft/m					
			SUPERMINI®			MINI		
			MG12	TN35	Ti25	TF45	TH35	CB10/50
P	Carbon steel	C < 0,4%						
		C > 0,4% < 0,6 %	46-361	46-590	46-590	46-590	46-590	
		C > 0,4% < 0,6 %						
	low alloyed steel	annealed	180					
		quenched	275	53-295	53-492	53-492		53-590
		quenched	300					
	high alloyed steel	annealed	200					
		quenched	325		63-295	63-295		63-400
	Cast steel	unalloyed	180					
		low alloyed	220	63-361	63-590	63-590		63-590
high alloyed		225						
M	Stainless steel	martensitic, ferritic		63-295	63-295		63-295	
		austenitic	180		53-263		53-263	
K	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	
S	Heat resistant alloy	NiFe			59-246	59-246	59-246	
		NiCo			59-131	59-131	59-131	
N	Al-alloy		46-722	53-1970	53-1970		53-1970	
	Copper and brass alloys		46-722	46-2300	46-2300		46-2300	
H	hardened material	> 54 HRC						65-455



v_c is depending on the tool diameter and therefore of the maximum numbers of revolutions of the machine.