

Application values (Art. no. 1014309 108-115)



Material groups for cutting values	Strength Class [N/mm ²]	Description regarding DIN	Vc [m/min]
1. Steels			
1.1 Free machining steel	< 900	9 S 20	10-18
1.2 Structural steel	<500	ST 37-2	10-18
1.3 Structural steel	> 500	ST 60-2	10-15
1.4 Heat-treated steel	<1000	42 CrMo 4	8-12
1.5 Cast iron	<1000	GS-45	8-12
1.6 Case-hardened steel	<1200	16 MnCr 5	8-12
1.7 Ferritic/martensitic stainless steel	<1100	X 10 Cr 13	6-8
1.8 Heat-treated steel	>1000	43 CrMo 4	8-12
1.9 Nitriding steel	<1300	31 CrMoV 9	8-12
1.10 Tool steel	<1300	X 38 CrMoV 5 1	6-12
2. Stainless steels			
2.1 Austenitic stainless steel	<1100	G-X 2 CrNiMo 18 15	6-8
3. Non-ferrous metals			
3.1 Long-chipping aluminium	<500	Al99.9	15-25
3.2 Short-chipping aluminium	<500	G-AlSi12	15-20
3.3 Copper alloy bronze, long-chipping	<1200	CuSn4	10-20
3.4 Copper alloy bronze, short-chipping	<850	CuNi12Zn24	10-20
3.5 Copper alloy brass, long-chipping	<600	Cu Zn 20	10-25
3.7 Thermoplastic	<600	Cu Zn 39 Pb 3	10-25
	<100	PVC, Acrylglas	10-20
3.8 Duroplast	<150	Bakelit, Melamin	8-15
3.9 Fibre-reinforced plastics	<1500	CFK, GFK	5-12
3.10 Graphite	<60	C8000	15-25
3.11 Composite materials			5-12
4. Cast metal			
4.1 Grey cast iron	<260 HB	GG10	15-20
4.2 Spheroidal graphite iron	<310 HB	GGG 40	12-20
4.3 Ductile iron	<280 HB	GTW-55	12-18

