RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

ISO	VDI 3323	Material Description	HB	HRc	TD703 TD733 TD704	TE703 TE733 TE704	TY703	TQ703	TD713	TE713	TQ723	TE723	TD723
					Vc (m/min)								
P	1	Non-alloy steel	125		15-20	15-20	15-20	15-20	15-20	15-20	15-20	15-20	15-20
	2		190	13	15-20	15-20	15-20	15-20	15-20	15-20	15-20	15-20	15-20
	3		250	25	12-18	12-18	12-18	12-18	12-18	12-18	12-18	12-18	12-18
	4		270	28									
	5		300	32									
	6	Low alloy steel	180	10	10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15
	7		275	29									
	8		300	32									
	9		350	38									
	10	High alloyed steel, and tool steel	200	15									
	11		325	35									
M	12	Stainless steel	200	15	10-13	7-10	10-13	7-10	10-13	7-10	7-10	7-10	10-13
	13		240	23	8-11	5-8	8-11	5-8	8-11	5-8	5-8	5-8	8-11
	14		180	10	6-8	4-6	6-8	4-6	6-8	4-6	4-6	4-6	6-8
K	15	Grey cast iron	180	10									
	16		260	26									
	17	Nodular cast iron	160	3									
	18		250	25									
	19	Malleable cast iron	130										
	20		230	21									
N	21	Aluminum-wrought alloy	60		10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15
	22		100		10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15
	23	Aluminum-cast, alloyed	75		15-20	15-20	15-20	15-20	15-20	15-20	15-20	15-20	15-20
	24		90		10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15
	25		130										
	26	Copper and Copper Alloys (Bronze / Brass)	110		25-35	25-35	25-35	25-35	25-35	25-35	25-35	25-35	25-35
	27		90										
	28		100		15-20	15-20	15-20	15-20	15-20	15-20	15-20	15-20	15-20
	29	Non Metallic Materials											
	30												
S	31	Heat Resistant Super Alloys	200	15									
	32		280	30									
	33		250	25									
	34		350	38									
	35		320	34									
	36	Titanium Alloys	400 Rm										
	37		1050 Rm										
H	38	Hardened steel	550	55									
	39		630	60									
	40	Chilled Cast Iron	400	42									
	41	Hardened Cast Iron	550	55									