

Recommended Cutting Speeds Vc [m/min] for MACH TT

Material Group	Vargus No.	Material	Hardness Brinell HB	Vc [m/min]	
				VK8	
P Steel	1	Unalloyed Steel	Low Carbon (C=0.1-0.25%)	125	115-175
	2		Medium Carbon (C=0.25-0.55%)	150	100-165
	3		High Carbon (C=0.55-0.85%)	170	90-155
	4	Low Alloy Steel (alloying elements ≤5%)	Non Hardened	180	100-165
	5		Hardened	275	75-130
	6		Hardened	350	70-125
	7	High Alloy Steel (alloying elements >5%)	Annealed	200	80-110
	8		Hardened	325	50-95
	9	Cast Steel	Low Alloy (alloying elements <5%)	200	70-120
	10		High Alloy (alloying elements >5%)	225	60-110
M Stainless Steel	11	Stainless Steel Ferritic	Non Hardened	200	70-120
	12		Hardened	330	60-105
	13	Stainless Steel Austenitic	Austenitic	180	90-130
	14		Super Austenitic	200	40-100
	15	Stainless Steel Cast Ferritic	Non Hardened	200	90-110
	16		Hardened	330	65-100
	17	Stainless Steel Cast Austenitic	Austenitic	200	85-100
	18		Hardened	330	60-100
K Cast Iron	28	Malleable Cast Iron	Ferritic (short chips)	130	60-70
	29		Pearlitic (long chips)	230	60-135
	30	Grey Cast Iron	Low Tensile Strength	180	70-120
	31		High Tensile Strength	260	60-105
	32	Nodular Sg Iron	Ferritic	160	125-145
	33		Pearlitic	260	90-110
N Non-Ferrous Metals	34	Aluminum Alloys Wrought	Non Aging	60	100-325
	35		Aged	100	80-205
	36	Aluminum Alloys	Cast	75	200-370
	37		Cast & Aged	90	200-260
	38	Aluminum Alloys	Cast Si 13-22%	130	60-165
	39	Copper and Copper Alloys	Brass	90	80-210
	40		Bronze And Non Lead Copper	100	80-235
	S Heat Resistant Material	19	High Temperature Alloys	Annealed (iron based)	200
20		Aged (iron based)		280	30-50
21		Annealed (nickel or cobalt based)		250	20-30
22		Aged (nickel or cobalt based)		350	15-25
23		Titanium Alloys	Pure 99.5 Ti	400Rm	140-160
24			α+β Alloys	1050Rm	50-70
H Hardened Material	25	Extra Hard Steel	Hardened & Tempered	45-50HRC	45-60
	26			51-55HRC	40-50

Grade	Application	Sample
VK8	High wear resistance for general purpose applications. AlTiN+TiN PVD Coating	