

Recommended cutting data for SCCD-ACF

ISO	Material No.	Material	Material Condition	Cutting Speed V _c , m/min	Cutting Diameter					
					Feed f, mm/rev					
					Ø4-Ø5	Ø5.1-Ø6	Ø6.1-Ø8	Ø8.1-Ø10	Ø10.1-Ø12	
P	1	Non-alloy steel and cast steel, free cutting steel	<0.25% C	Annealed	80-140	0.15-0.25	0.20-0.35	0.25-0.45	0.30-0.55	0.35-0.60
	2		≥0.25% C	Annealed	80-130					
	3		<0.55% C	Quenched and tempered	80-120					
	4		≥0.55% C	Annealed	70-110					
	5			Quenched and tempered	50-90					
	6	Low alloy steel and cast steel (less than 5% of alloying elements)	Annealed	80-120	0.25-0.40			0.30-0.50	0.35-0.55	
	7		Quenched and tempered	70-110						
	8			50-90						
	9			40-70						
	10	High alloyed steel, cast steel, and tool steel	Annealed	50-90	0.15-0.20	0.20-0.30	0.25-0.35	0.30-0.45	0.35-0.50	
	11		Quenched and tempered	40-80						
K	15	Grey cast iron (GG)	Ferritic/pearlitic	80-140	0.20-0.30	0.25-0.45	0.35-0.55	0.40-0.60	0.45-0.65	
	16		Pearlitic/martensitic	70-120						
	17	Nodular cast iron (GGG)	Ferritic	80-120		0.20-0.40	0.30-0.50	0.35-0.55	0.40-0.60	
	18		Pearlitic	70-110						
	19	Malleable cast iron	Ferritic	80-120						
	20		Pearlitic	70-110						