Cutting data SDKT12

Starting parameters:
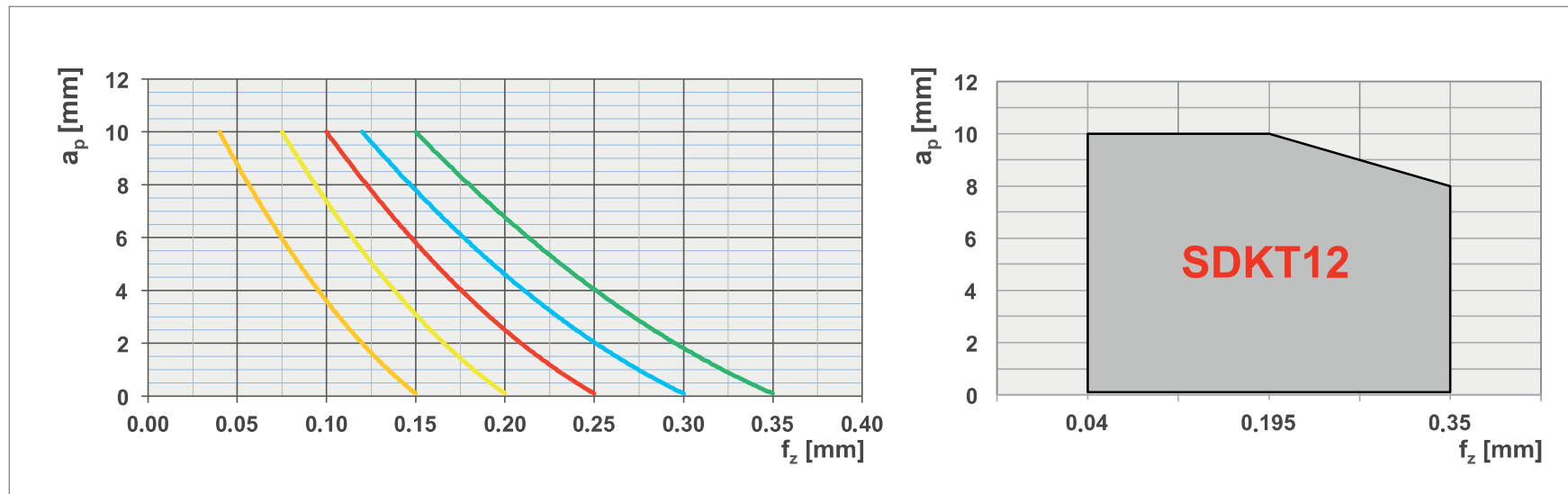
Grades and materials:

	Material group	Chipbreaker	Grade	v_c [m/min]	f_z [mm]	a_p [mm]
					Cutting data	
P	Steel	HCM	CTCP230 / CTPP235	220 – 60	0.12 – 0.3	10 – 0.1
M	Stainless steel	SCM	CTPM235HP / CTC5235	200 – 60	0.075 – 0.2	10 – 0.1
K	Cast iron	CCM	CTCK215	320 – 100	0.1 – 0.25	10 – 0.1
N	Non-ferrous	LMM	H216T	< 2000	0.15 – 0.35	10 – 0.1
S	Heat resistant alloys	SCM	CTC5235	75 – 25	0.04 – 0.15	10 – 0.1
S	Titanium	SCM	CTC5240			