

Technical Information

Recommended cutting speed, coolants and lubricants



Material	Lubricant	Cutting Speed m/min.
Steel, unalloyed and low alloyed, short-chipping	S/E	10-20
non abrasive material, short-chipping	S/E	6-15
Steel, heat resistant, long-chipping	S	4- 8
Steel, heat resistant, short-chipping	S	4- 8
Steel, cementation and heat treatable, short-chipping	S	4- 8
Steel, Tool Steel up to 1200 N/mm ²	S	2- 5
Steel, Tool Steel over 1200 N/mm ²	S	2- 5
Steel stainless, short-chipping	S	5-10
Steel stainless, long-chipping	S	5-10
Iron, Cast	P/T	6-20
Iron, spheroidal graphite	P/T	6-20
Iron, Malleable Cast	E	6-12
Brass, short-chipping	E	20-30
Brass, long-chipping	S/E	10-15
Bronze, short-chipping	S/E	6-15
Bronze, long-chipping	S/E	6-15
Copper	S/E	10-15
Aluminium-alloys, short-chipping	S/E	15-30
Aluminium-alloys, long-chipping	E	10-20
Zinc Alloys	S/E	10-15
Magnesium Alloys	E/T	10-20
Titanium, short-chipping	S	3- 4
Titanium, long-chipping	S	3- 4
Plastics, thermoplastics	E/T	5-15
Plastics, thermosetting	T	5-15

S = cutting oil E = oil emulsion P = kerosene T = dry/secco