

Technical Data and Settings

Cutting data DL2

Material	Condition	Tensile strength	Hardness	Cutting speed	Feed
		(N/mm ²)	HB		
Unalloyed steel		<500	<150	30-50	0.005-0.015
Cast steel		500 - 850	150 - 250	30-50	0.005-0.015
Grey cast iron		<500	<150	40-60	0.005-0.015
Ductile cast iron		300 - 800	90 - 240	30-50	0.005-0.015
Low alloy steel	annealed	<850	<250	30-50	0.005-0.015
	tempered	850 - 1000	250 - 300	25-45	0.005-0.015
	tempered	>1000 - 1200	>300 - 350	20-40	0.005-0.015
High alloy steel	annealed	<850	<250	20-40	0.005-0.015
	tempered	850 - 1100	250 - 320	15-25	0.005-0.015
Stainless steel	ferritic	450 - 650	130 - 190	20-40	0.005-0.015
	austenitic	650 - 900	190 - 270	15-30	0.005-0.015
	martensitic	500 - 700	150 - 200	15-25	0.005-0.015
Special alloy (Inconel, titanium)		<1200	<350	10-15	0.005-0.015
Wrought or cast aluminium alloys				60-80	0.005-0.015
Copper alloy	Brass			50-60	0.005-0.015
	Bronze short-chipping			40-50	0.005-0.015
	Bronze long-chipping			30-40	0.005-0.015

WARNING NOTICE

All listed cutting data are standard values only! The cutting values depend on the amount of slope of the uneven bore edge (i.e. high slope ► low cutting value). The feed also depends on the sloping ratio. In case of hard to machine materials or uneven bore edges, we recommend to apply cutting speeds that are at the lower end of the range for uneven bore edges.