

ROUGH STATIONARY ANTI VIBRATION TOOLS

CUTTING PARAMETERS

MATERIAL GROUP	MATERIAL	MATERIAL PROPERTIES / HARDNESS HB	Vc (m/min)	FEED (mm/rev)	DEPTH OF CUT (mm)
P STEEL 	Unalloyed Steel	125 – 170 HB	100 – 200	0.15 – 0.40	0.5 – 3.0
	Low Alloy Steel	180 – 350 HB	100 – 180	0.15 – 0.40	0.5 – 3.0
	High Alloy Steel	200 – 325 HB	100 – 180	0.15 – 0.40	0.5 – 3.0
	Cast Steel	~200 HB	100 – 180	0.15 – 0.40	0.5 – 3.0
M STAINLESS STEEL 	Ferritic Stainless Steel	200 – 300 HB	50 – 130	0.05 – 0.15	0.5 – 1.5
	Austenitic Stainless Steel	180 – 200 HB	60 – 130	0.05 – 0.15	0.5 – 1.5
	Special Stainless Steel (Cast)	200 – 330 HB	50 – 130	0.05 – 0.15	0.5 – 1.5
K CAST IRON 	Grey Cast Iron	180 – 260 HB	60 – 160	0.15 – 0.35	0.5 – 3.0
	Nodular Graphite Cast Iron	160 – 260 HB	60 – 160	0.15 – 0.35	0.5 – 3.0
	Malleable Cast Iron	130 – 230 HB	60 – 160	0.15 – 0.35	0.5 – 3.0
N NON-FERROUS MATERIALS 	Aluminium Alloys (Forge / Rolled)	60 – 75 HB	120 – 400	0.10 – 0.20	0.5 – 4.0
	Copper Alloys	~90 – 100 HB	100 – 300	0.10 – 0.20	0.5 – 4.0
	Brass / Bronze	—	100 – 300	0.10 – 0.20	0.5 – 4.0
S HEAT-RESISTANT ALLOYS 	Heat-Resistant Alloys (Fe based)	200 – 350 HB	60 – 130	0.05 – 0.15	0.5 – 1.5
	Titanium Alloys	400 – 1050 Rm	50 – 90	0.05 – 0.15	0.5 – 1.5
H HARDENED MATERIALS HRC	Hardened Steel	45 – 60 HRC	60 – 140	0.10 – 0.15	0.5 – 1.0



NOTE :

- Vc = Cutting Speed (m/min)
- Feed = Feed per revolution (mm/rev)
- DOC = Depth of Cut (mm)

MORE PRODUCTIVE MACHINING



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CUTTING PARAMETERS FOR FINISH STATIONARY ANTI VIBRATION TOOLS

STABLE MACHINING
SUPERIOR FINISH

MATERIAL GROUP	MATERIAL	MATERIAL PROPERTIES / HARDNESS HB	Vc (m/min)	FEED (mm/rev)	DEPTH OF CUT (mm)
P STEEL 	Unalloyed Steel	125 – 170 HB	100 – 200	0.10 – 0.15	0.1 – 0.3
	Low Alloy Steel	180 – 350 HB	100 – 180	0.10 – 0.15	0.1 – 0.3
	High Alloy Steel	200 – 325 HB	100 – 180	0.10 – 0.15	0.1 – 0.3
	Cast Steel	~200 HB	100 – 180	0.10 – 0.15	0.1 – 0.3
M STAINLESS STEEL 	Ferritic Stainless Steel	200 – 300 HB	50 – 130	0.05 – 0.10	0.1 – 0.2
	Austenitic Stainless Steel	180 – 200 HB	60 – 130	0.05 – 0.10	0.1 – 0.2
	Special Stainless Steel (Cast)	200 – 330 HB	50 – 130	0.05 – 0.10	0.1 – 0.2
K CAST IRON 	Grey Cast Iron	180 – 260 HB	60 – 160	0.15 – 0.25	0.1 – 0.2
	Nodular Graphite Cast Iron	160 – 260 HB	60 – 160	0.15 – 0.25	0.1 – 0.2
	Malleable Cast Iron	130 – 230 HB	60 – 160	0.15 – 0.25	0.1 – 0.2
N NON-FERROUS MATERIALS 	Aluminium Alloys (Forge / Rolled)	60 – 75 HB	120 – 400	0.05 – 0.10	0.1 – 0.2
	Aluminium Alloys (Cast / Non Hardenable)	75 HB	180 – 400	0.05 – 0.10	0.1 – 0.2
	Copper and Copper Alloys	~90 – 100 HB	100 – 280	0.05 – 0.10	0.1 – 0.2
	Brass	—	100 – 300	0.05 – 0.10	0.1 – 0.2
	Bronze, Non Leaded Copper	—	100 – 300	0.05 – 0.10	0.1 – 0.2
S HEAT-RESISTANT ALLOYS 	Heat Resistance Alloys (Fe based heat treated)	200 – 350 HB	60 – 130	0.05 – 0.15	0.1 – 0.2
	(Fe based aged)	280 HB	60 – 130	0.05 – 0.15	0.1 – 0.2
	(Ni or Co based Heat Treated)	250 HB	60 – 130	0.05 – 0.15	0.1 – 0.2
	(Ni or Co based aged)	350 HB	60 – 130	0.05 – 0.15	0.1 – 0.2
	Titanium Alloys (Pure Titanium)	400 Rm	50 – 90	0.05 – 0.15	0.1 – 0.2
	Titanium Alloys (Alpha & Beta Alloys Hardened)	1050 Rm	50 – 90	0.05 – 0.15	0.1 – 0.2
H HARDENED MATERIALS 	Heat Treated	45 – 50 HRC	60 – 140	0.05 – 0.10	0.1 – 0.2
	Hardened Steel	50 – 60 HRC	60 – 140	0.05 – 0.10	0.1 – 0.2



NOTE :

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