

ISO	Material	Condition	Tensile strength (N/mm ²)	Hardness HB	Material No.	Cutting speed Vc(m/min)			
						CBN			
						TB730	TB7015	TB7020	KB90A
K	Gray cast iron (GG)	Ferritic		160	15	300-1200	300-1200	300-800	300-1200
		Pearlitic		250	16	200-1000	200-1000	500-1000	200-1000
	Cast iron nodular (GGG)	Ferritic		180	17				
		Pearlitic		260	18				
	Malleable cast iron	Ferritic		130	19				
		Pearlitic		230	20				