

ISO	Material	Condition	Tensile strength (N/mm ²)	Hardness HB	Material No.	Cutting speed Vc(m/min)			
						CBN			
						TB610	TB2015	TB650	TB670
H	Hardened steel	Hardened		55HRC	38	90-280	80-230	80-230	70-180
		Hardened		60HRC	39	80-250	70-200	70-200	60-150
	Chilled cast iron	Cast		400	40				100-200
	Cast iron nodular	Hardened		55HRC	41				