

ISO	Material	Condition	Tensile strength (N/mm <sup>2</sup> )	Hardness HB	Material No.	Cutting speed Vc(m/min)						
						Coated						
						TT9215	TT9225	TT9235	TT5080	TT9080	TT8080	TT8020
M	Stainless steel and cast steel	Ferritic / martensitic	680	200	12	160-250	120-200	110-170	160-390	120-290	110-260	100-250
		Martensitic	820	240	13	150-230	110-180	100-150	160-280	120-270	110-240	100-230
		Austenitic	600	180	14	130-220	100-170	90-150	100-250	90-240	80-200	80-200