

ISO	Material	Condition	Tensile strength (N/mm ²)	Hardness HB	Material No.	Cutting speed Vc(m/min)						
						Coated						
						TT8105B	TT8115B	TT8125B	TT8135B	TT5100	TT7100	
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	310-580	280-530	230-480	190-400	200-450	170-380
		>=0.25%C	Annealed	650	190	2	270-530	240-480	200-420	170-360	170-390	150-340
		<0.55%C	Quenched and tempered	850	250	3	230-490	200-440	160-380	130-320	130-350	110-300
		>=0.55%C	Annealed	750	220	4	250-500	220-450	190-400	160-340	160-370	140-320
			Quenched and tempered	1000	300	5	210-470	180-420	150-350	120-300	120-320	100-280
	Low alloy steel and cast steel (less than 5% of alloying elements)	Annealed	600	200	6	230-550	200-500	170-400	130-280	140-370	110-260	
		Quenched and tempered	930	275	7	180-330	150-280	140-250	80-170	110-220	60-150	
			1000	300	8	160-300	130-250	120-230	70-150	90-200	50-120	
			1200	350	9	150-280	120-230	110-200	60-140	80-170	40-120	
	High alloy steel, cast steel and tool steel	Annealed	680	200	10	210-420	190-380	140-280	100-220	110-250	80-200	
		Quenched and tempered	1100	325	11	100-200	90-180	70-130	45-100	40-100	40-90	