

ISO	Material	Condition	Tensile strength (N/mm <sup>2</sup> )	Hardness HB	Material No.	Cutting speed Vc(m/min)						
						Coated						
						TT3005	TT5080	TT3010	TT3020	TT9080	TT8020	
S	High temp. alloys	Fe based	Annealed		200	31	60-200	50-180	50-170	40-165	40-160	20-70
			Cured		280	32	50-180	40-160	40-150	30-145	30-130	10-50
		Ni or Co based	Annealed		250	33	55-120	45-100	45-90	35-85	35-80	10-40
			Cured		350	34	45-110	35-90	35-80	30-75	30-70	10-30
			Cast		320	35	40-100	30-80	30-70	30-65	30-60	10-20
	Titanium, Ti alloys		Rm 400		36	120-220	110-200	110-190	100-185	90-180	70-150	
		Alpha+beta alloys cured	Rm 1050		37	60-120	50-100	50-90	40-85	40-80	20-40	