

ISO	Material	Condition	Tensile strength (N/mm ²)	Hardness HB	Material No.	Cutting speed Vc(m/min)			
						Ceramic			
						AW120	AB30	AS500	AS10
K	Gray cast iron (GG)	Ferritic		160	15		600-1200	600-1000	500-900
		Pearlitic		250	16		500-900	550-900	450-800
	Cast iron nodular (GGG)	Ferritic		180	17	600-1200	450-610	400-650	345-580
		Pearlitic		260	18	500-900	350-510	300-550	250-480
	Malleable cast iron	Ferritic		130	19	600-800	600-800	550-800	500-740
		Pearlitic		230	20	500-700	500-700	450-750	400-640