

ISO	Material	Condition	Tensile strength (N/mm ²)	Hardness HB	Material No.	Cutting speed Vc(m/min)			
						Ceramic			
						TC430	TC3020	TC3030	
S	High temp. alloys	Fe based	Annealed		200	31		200-350	150-250
			Cured		280	32		200-350	150-250
	Ni or Co based		Annealed		250	33	270-400	200-350	150-250
			Cured		350	34	230-330	200-350	150-250
			Cast		320	35	210-300	200-350	150-250
	Titanium, Ti alloys			Rm 400		36			
			Alpha+beta alloys cured	Rm 1050		37			