

ISO	Material	Condition	Tensile strength (N/mm ²)	Hardness HB	Material No.	Cutting speed Vc(m/min)			
						PCD			
						TD810	KP300	TD830	
N	Aluminum - wrought alloy	Not cureable		60	21	300-2500	300-2300	300-2000	
		Cured		100	22	300-2500	300-2300	300-2000	
	Aluminum-cast, alloyed	<=12% Si	Not cureable		75	23	200-1500	200-1400	200-1300
			Cured		90	24	200-1500	200-1400	200-1300
		>12% Si	High temp.		130	25	80-1000	80-900	80-800
	Copper alloys	>1% Pb	Free cutting		110	26	60-600	60-550	60-500
			Brass		90	27	60-600	60-550	60-500
			Electrolitic copper		100	28	30-400	30-380	30-360
	Non-metallic		Duroplastics, fiber plastics			29	100-1000	100-900	100-800
			Hard rubber			30	100-600	100-550	100-500