

ISO	Material	Condition	Tensile Strength [N/mm²]	Hardness HB	Material Group No.	Cutting Speed V <sub>c</sub> (SFM)	Cutting Diameter				
							Feed (mm/rev)				
							.1181" - .1969"	.2008" - .3150"	.3189" - .3937"	.3976" - .6299"	.6339" - .7874"
K	Gray cast iron (GG)	Ferritic / pearlitic		180	15	295-394	.0071-.0118	.0083-.0134	.0095-.0158	.0102-.0177	.0126-.0217
		Pearlitic / martensitic		260	16						
	Nodular cast iron (GGG)	Ferritic		160	17						
		Pearlitic		250	18						
	Malleable cast iron	Ferritic		130	19						
		Pearlitic		230	20						