

# Technical Data and Settings

## Cutting Data SOLO

Material	Condition	Tensile strength (N/mm <sup>2</sup> )	Cutting speed (m/min)	Feed (mm/rev.)
Unalloyed steel		<500	50-90	0.03-0.1
Cast steel		500-850	50-90	0.03-0.08
Grey cast iron		<500	50-110	0.03-0.1
Ductile cast iron		300-800	50-90	0.03-0.08
Low alloy steel	annealed	<850	50-90	0.03-0.08
	tempered	850-1000	40-80	0.03-0.08
	tempered	>1000-1200	30-50	0.02-0.05
High alloy steel	annealed	<850	30-70	0.03-0.08
	tempered	850-1100	30-50	0.02-0.05
Stainless steel	ferritic	450-650	30-50	0.03-0.08
	austenitic	650-900	15-25	0.02-0.05
	martensitic	500-700	30-50	0.02-0.05
Special alloy (Inconel, titanium, ...)		<1200	15-25	0.02-0.05
Wrought or cast aluminium alloys			100-200	0.03-0.12
Copper alloy	Brass		50-90	0.03-0.08
	Bronze short-chipping		30-70	0.03-0.08
	Bronze long-chipping		20-30	0.02-0.05

### WARNING NOTICE

All listed cutting data are standard values only! The cutting values depend on the amount of slope of the uneven bore edge. (i.e. high slope ► low cutting value). The feed also depends on the sloping ratio. In case of hard to machine materials or uneven bore edges, we recommend to apply cutting speeds that are at the lower end of the range for uneven bore edges.