

Technical Data and Settings

Cutting Data COFA

Material	Condition	Tensile strength (N/mm ²)	Hardness HB	COFA C2 / C3		COFA 4M to C12	
				Cutting speed (m/min)	Feed (mm/rev)	Cutting speed (m/min)	Feed (mm/rev)
Unalloyed steel		<500	<150	20-60	0.05-0.15	20-60	0.1-0.3
Cast steel		500 - 850	150 - 250	20-60	0.05-0.15	20-60	0.1-0.3
Grey cast iron		<500	<150	30-80	0.05-0.15	30-80	0.1-0.3
Ductile cast iron		300 - 800	90 - 240	20-60	0.05-0.15	20-60	0.1-0.3
Low alloy steel	annealed	<850	<250	20-60	0.05-0.15	20-60	0.1-0.3
	tempered	850 - 1000	250 - 300	20-40	0.05-0.15	20-40	0.1-0.3
	tempered	>1000 - 1200	>300 - 350	15-30	0.05-0.15	15-30	0.1-0.3
High alloy steel	annealed	<850	<250	15-30	0.05-0.15	15-30	0.1-0.3
	tempered	850 - 1100	250 - 320	10-20	0.05-0.15	10-20	0.1-0.3
Stainless steel	ferritic	450 - 650	130 - 190	15-30	0.05-0.15	15-30	0.1-0.3
	austenitic	650 - 900	190 - 270	10-20	0.05-0.15	10-20	0.1-0.3
	martensitic	500 - 700	150 - 200	15-30	0.05-0.15	15-30	0.1-0.3
Special alloy (Inconel, titanium)		<1200	<350	10-20	0.05-0.15	10-20	0.1-0.3
Wrought or cast aluminium alloys				30-70	0.05-0.15	30-70	0.1-0.3
Copper alloy	Brass			30-70	0.05-0.15	30-70	0.1-0.3
	Bronze short-chipping			20-60	0.05-0.15	20-60	0.1-0.3
	Bronze long-chipping			20-40	0.05-0.15	20-40	0.1-0.3

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.