



Average Cutting Data for FFX4 Fast Feed Cutters Size 04

ISO class DIN/ ISO 513	Description	Workpiece material				Insert type	Carbide grade	D.O.C. ap (mm)	Cutting Speed & Feed		Coolant
		ISCAR mat. group*	Hardness HB	Typical materials					vc (m/min)	fz (mm/tooth)	
				AISI/SAE/ASTM	DIN W.-Nr.						
P	non-alloy steel	1-5	130-180	1020	1.040	T/RM-T	IC808	T/RM-T	150-220	0.40-1.00	Dry
	low alloy steel	6-8	260-300	4340	1.658		IC830		150-200	0.40-1.20	Dry/Wet
							IC808		150-200	0.40-0.90	Dry/Wet
							IC830		120-180	0.40-1.10	Dry/Wet
							IC808		130-180	0.40-0.80	Dry
		IC830	120-160	0.40-1.00	Dry/Wet						
	high alloy steel	10-11	200-220	H13	1.234		IC808		120-170	0.40-0.80	Dry
							IC830		100-150	0.40-0.90	Dry/Wet
	ferritic/martensitic stainless steel	12-13	200	420	1.402		IC808		110-160	0.40-0.80	Dry
							IC830		100-150	0.40-0.90	Dry/Wet
M	austenitic stainless steel	14	200	304L	1.431	HP/ RM-HP	IC830	0.20-0.80	80-120	0.20-0.80	Wet
							IC840		80-140	0.20-0.80	
							IC5820		100-160	0.20-0.80	
							IC882		80-130	0.20-0.80	
K	grey cast iron	15-16	250	Class 40	0.6025 (GG25)	T/RM-T	IC810	0.20-0.80	150-220	0.40-1.20	Dry
	nodular cast iron	17-18	200	Class 65-45-12	0.7050 (GGG50)		IC810		120-200	0.40-1.20	
S	high temperature alloys and titanium	31-32	220	330	1.486	HP/ RM-HP	IC882	0.20-0.80	40-60	0.20-0.70	Wet
							IC5820		40-80	0.20-0.70	
							IC840		40-80	0.20-0.70	
							IC830		40-75	0.20-0.70	
		33-35	340	Inconel 718	2.467		IC882		20-30	0.20-0.70	
							IC5820		25-35	0.20-0.70	
							IC840		25-35	0.20-0.70	
							IC830		25-30	0.20-0.70	
		36-37	30-32	AMS R56400	(Ti6Al4V ELI)		IC882		25-35	0.20-0.70	
							IC5820		25-40	0.20-0.70	
							IC840		25-35	0.20-0.70	
							IC830		20-30	0.20-0.70	
H	hardened steel	38	HRC 45-49	HARDOX 450 plate		XNMW	IC808	0.20-0.60	45-65	0.20-0.70	Dry

* ISCAR material group in accordance with VDI 3323 standard ** Quenched and tempered
For machining under unstable conditions, the recommended cutting data should be reduced by 20-30%