

Cutting data for Reamer 830

ISO	CMC No.	Material		HB	Grade	Cutting speed	Feed	Radial depth of cut
						V_c (m/min)	f_z (mm/insert)	a_p (mm)
P	01.1	Unalloyed steel	Non-hardened (C=0.1-0.25%)	90-200	P10R	150-200	0.15-0.25	0.1-0.3
	01.2		Non-hardened (C=0.25-0.55%)	125-225		150-200	0.15-0.25	
	01.3		Non-hardened (C=0.55-0.8%)	150-225		140-180	0.15-0.25	
	01.4		High carbon & carbon tool steel	180-225		140-180	0.15-0.25	
	02.1	Low alloy steel	Non-hardened	150-260	P10R	110-180	0.15-0.25	0.1-0.3
	02.2		Hardened and tempered	220-400		70-130	0.10-0.20	
	06.1	Steel castings	Unalloyed	90-225	P10R	140-180	0.15-0.25	0.1-0.3
	06.2		Low alloyed	150-250		100-150	0.15-0.25	
K	07.2	Malleable cast iron	Pearlitic	150-270	P10R	150-200	0.15-0.25	0.1-0.3
	09.2	Nodular cast iron	Pearlitic	200-300		110-190	0.15-0.25	