



**Indicative cutting speeds for HSS M35 interchangeable blades**

		Feed mm/rev depending on $\phi$			
Material	Vc (m/min)	$\phi$ 18-24	$\phi$ 25-35	$\phi$ 36-47	$\phi$ 48-65
Steel 500-700 N/mm <sup>2</sup>	45	0.3	0.4	0.5	0.55
Steel 700-1000 N/mm <sup>2</sup>	35	0.3	0.4	0.45	0.5
Steel 1000-1400 N/mm <sup>2</sup>	20	0.25	0.3	0.35	0.4
Stainless Steel serie 400, 416, 420	25	0.25	0.3	0.35	0.4
Stainless Steel serie 300, 304, 316, 17 :4PH	20	0.25	0.3	0.35	0.4
Brass	90	0.35	0.4	0.45	0.5
Copper	40	0.2	0.25	0.25	0.25
Bronze	45	0.25	0.3	0.35	0.4