

CUTTING PARAMETER CHART

S NO.	UK	CATEGORY	INDIAN STD	CARBON %	Cutting Rate cm ² / min	Cutting Speed mtr/ min
1	F1	CARBON COLD DRAWN STEEL	F1	0.2	60-70	60-70
2	C45	CARBON COLD DRAWN STEEL	C45	0.5	60-70	60-70
3	C55	CARBON COLD DRAWN STEEL	C55	0.5	60-70	60-70
4	S355J2	CASE HARDENING STEEL	DH36 & EH36		50-60	50-65
5	S355J0	CASE HARDENING STEEL	DIN 0 1.0553		50-60	50-65
6	ST52	SEAMLESS TUBE	S355JR(1.0045) / E355	0.22	Please confirm tube dia and thickness	
7	42CRMO4	QUENCHING & TEMPERING ALLOYED STEEL	EN-9		45-55	50-60
8	F1270	QUENCHING & TEMPERING ALLOYED STEEL	35NiCrM07		45-55	50-60
9	36CRNIMO4	BEARING STEEL			35-45	45-55
10	100CR6	BEARING STEEL	EN31		35-45	45-55
11	51CRV4	SPRING STEEL	51CRV4	0.55	35-45	45-55
12	16MNCR5	CASE HARDENING STEEL	16MNCR5	0.19	50-60	50-60
13	20NICRM02-2	CASE HARDENING STEEL		0.23	50-60	50-60
14	15NICR13	CASE HARDENING STEEL		0.20	50-60	50-60

15	18CRMO4	CASE HARDENING STEEL		21	50-60	50-60
16	F1580	CASE HARDENING STEEL		0.20	50-60	50-60
17	11SMN30	FREE CUTTING STEEL	19Mn28	0.14	60-75	60-75
18	11SMNPB30	FREE CUTTING STEEL	95Mnpb28	0.14	60-75	60-75
19	1.2344ESR	HOT WORK TOOL STEEL	40CrMOV5-1	0.42	25-35	35-40
20	1.2738	HOT WORK TOOL STEEL	40CrMnNiMo 8-6-4	0.45	25-35	35-40
21	UNIMAX				Please provide some more information for this material	
22	1.2379	COLD WORK TOOLS STEEL		1.6	15-25	25-30
23	1.251	COLD WORK TOOLS STEEL		1.6	15-25	25-30
24	AISI304	COLD DRAWN STEEL	SS304		15-25	30-40
25	AISI316	COLD DRAWN STEEL	SS316		15-25	30-40
26	GG25				Please provide some more information for this material	