

Turning Grade, Cutting and Speed Information

Steel:	ISO	Cut	Recommendation (vc m/min)
• CECP15T	P10 – P15	Continuous Cut	180 - 300
• CECP25T	P25	Lightly Interrupted Cut	120 - 220
• CEC240F	P40	Heavy Interrupted Cut	60 – 110
Stainless:			
• CECM20T	M20	Continuous Cut	180 - 220
• CEC435D	M35	Interrupted Cut	100 – 170
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Superalloys:			
• CEC415Z	S15	Continuous and Lightly Interrupted Cut	40 - 60
• CEC415X	S15	Continuous Cut for smallest parts	60 – 140
Cast iron:			
• CEC610H	K10	Continuous Cut	110 - 330
• CEC620H	K20	Interrupted Cut	110 – 300
Aluminium/Non-ferrous:			
• CEW610	K10	Continuous Cut	> 500
• CEC610T	K10	Interrupted Cut	> 500