



TECHNICAL INFORMATION

Material	Green Ring	Blue Ring	White Ring	Black Ring	Red Ring	Lubricant	Cutting-speed m/min
Steel, unalloyed and low alloyed, short-chipping	●					S/E	10-20
non abrasive material, short-chipping	●					S/E	6-15
Steel, heat resistant, long-chipping			⬇			S	4-8
Steel, heat resistant, short-chipping		●				S	4-8
Steel, cementation and heat treatable, short-chipping		●				S	4-8
Steel, Tool Steel up to 1200 N/mm ²		●				S	2-5
Steel, Tool Steel over 1.200 N/mm ²					●	S	2-5
Steel stainless, short-chipping		●				S	5-10
Steel stainless, long-chipping			⬇			S	5-10
Iron, Cast				●		P/T	6-20
Iron, spheroidal graphite		●				P/T	6-20
Iron, Malleable Cast	●					E	6-12
Brass, short-chipping		●		●		E	20-30
Brass, long-chipping	●					S/E	10-15
Bronze, short-chipping		●		●		S/E	6-15
Bronze, long-chipping	●					S/E	6-15
Copper	●					S/E	10-15
Aluminium-alloys, short-chipping		●				S/E	15-30
Aluminium-alloys, long-chipping	●					F	10-20
Zinc Alloys	●					S/E	10-15
Magnesium Alloys	●	●				E/T	10-20
Titanium, short-chipping		●				S	3-4
Titanium, long-chipping			⬇			S	3-4
Plastics, thermoplastics	●					E/T	5-15
Plastics, thermosetting				●	●	T	5-15

S = Cutting Oil E = Oil Emulsion P = Kerosene T = Dry

