

ISO	Materiale da lavorare		Condizioni	Resistenza alla trazione	Durezza	Velocità di taglio	Velocità (mm/giro) vs. diametro punta lunghezza punta 2,3,4xD						
				Rm(N/mm²)	HB	Vc (m/min)	SPGX05	SPGX06	SPGX07	SPGX09	SPGX11	SPGX14	
P	Acciaio non legato, acciaio automatico	< 0.25%C	Ricotto	420	125	200-280	0.04-0.06	0.04-0.06	0.04-0.08	0.04-0.08	0.06-0.10	0.06-0.12	
		> =0.25%C	Ricotto	650	190	120-190	0.05-0.08	0.06-0.10	0.06-0.12	0.07-0.13	0.08-0.15	0.08-0.16	
		< 0.55%C	Bonificato	850	250	110-180	0.06-0.12	0.08-0.15	0.10-0.18	0.12-0.22	0.12-0.24	0.13-0.25	
		> =0.55%C	Ricotto	750	220	110-180	0.06-0.12	0.08-0.15	0.10-0.18	0.12-0.22	0.12-0.24	0.13-0.25	
		0.55-0.80%	Bonificato	1000	300	110-180	0.06-0.12	0.08-0.15	0.10-0.18	0.12-0.22	0.12-0.24	0.13-0.25	
	Acciaio poco legato	Ricotto			600	200	120-190	0.06-0.12	0.08-0.14	0.10-0.18	0.12-0.20	0.12-0.20	0.13-0.20
				Bonificato			930	275	120-160	0.06-0.15	0.06-0.15	0.08-0.18	0.08-0.18
			1000			300	120-160	0.06-0.15	0.06-0.15	0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18
			1200	350	120-160	0.06-0.15	0.06-0.15	0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18		
	Acciaio alto legato e acciaio per utensili			Ricotto	680	200	120-180	0.06-0.10	0.06-0.10	0.08-0.12	0.08-0.14	0.08-0.14	0.08-0.14
Bonificato				1100	325	120-180	0.06-0.10	0.08-0.12	0.10-0.15	0.12-0.15	0.12-0.18	0.13-0.18	
M	Acciaio inossidabile		Ferritico/ martensitico	680	200	170-230	0.05-0.10	0.06-0.12	0.08-0.15	0.09-0.16	0.10-0.17	0.11-0.18	
			Martensitico	820	240	170-230	0.05-0.10	0.06-0.12	0.08-0.15	0.09-0.16	0.10-0.17	0.11-0.18	
			Austenitico	600	180	170-230	0.05-0.10	0.06-0.12	0.08-0.15	0.09-0.16	0.10-0.17	0.11-0.18	
K	Ghisa grigia		-	-	250	120-200	0.09-0.3	0.09-0.33	0.1-0.36	0.1-0.37	0.1-0.38	0.12-0.48	
N	Leghe di alluminio		-	-	-	200-320	0.06-0.17	0.06-0.17	0.06-0.18	0.07-0.20	0.07-0.20	0.08-0.22	
	Leghe di rame		-	-	-	200-320	0.06-0.17	0.06-0.17	0.06-0.18	0.07-0.20	0.07-0.20	0.08-0.22	