

P				M	K			N			S				H		page(s)	recommended cutting parameters
1, 2, 3, 4, 6, 7	5, 9, 10, 11	12, 13.1	13.2	14.1, 14.2, 14.3, 14.4	15, 16, 17, 18, 19	20		21	22, 23, 24, 25	26, 27, 28	31, 32	33, 34, 35	36	37	38.1, 38.2, 40.1, 40.2, 41.1	39.1, 41.2		
Steel <35 HRC	Steel 36–48 HRC	PH and Ferritic Stainless Steel <35 HRC	PH and Ferritic Stainless Steel >35 HRC	Stainless Steel	Cast Iron			Wrought Aluminium	Cast Aluminium	Copper, Copper Alloys	Iron Based	Cobalt Based	Nickel Based	Titanium Alloys	Hardened Steels 49–55 HRC	Hardened Steels 56–68 HRC		
★★★★	★★★★	★★★★	★★★★	★★★★	★★★★	★★★★		★★★★	★★★★	★★★★	★	★	★	★			Y69	Y77
★★★★	★★★★	★★★★	★★★★	★★★★	★★★★	★★★★		★★★★	★★★★	★★★★	★★★★	★★★★	★★★★	★★★★			Y71	Y77
					★★★★	★★★★		★★★★	★★★★	★★★★							Y73	Y77
★★★★	★★★★	★★★★	★★★★	★★★★	★★★★	★★★★		★★★★	★★★★	★★★★					★★★★	★★★★	Y75	Y78
											★★★★	★★★★	★★★★	★★★★	★★★★	★★★★	Y76	Y78

P				M	K			N			S				H		page(s)	recommended cutting parameters
1, 2, 3, 4, 6, 7	5, 9, 10, 11	12, 13.1	13.2	14.1, 14.2, 14.3, 14.4	15, 16, 17, 18, 19	20		21	22, 23, 24, 25	26, 27, 28	31, 32	33, 34, 35	36	37	38.1, 38.2, 40.1, 40.2, 41.1	39.1, 41.2		
Steel <35 HRC	Steel 36–48 HRC	PH and Ferritic Stainless Steel <35 HRC	PH and Ferritic Stainless Steel >35 HRC	Stainless Steel	Cast Iron			Wrought Aluminium	Cast Aluminium	Copper, Copper Alloys	Iron Based	Cobalt Based	Nickel Based	Titanium Alloys	Hardened Steels 49–55 HRC	Hardened Steels 56–68 HRC		
★★★★	★★★★	★★★★	★★★★	★★★★	★★★★	★★★★		★★★★	★★★★	★★★★	★★★★	★★★★	★★★★	★★★★			Y70	Y77
					★★★★	★★★★		★★★★	★★★★	★★★★							Y72	Y77
★★★★	★★★★	★★★★	★★★★	★★★★	★★★★	★★★★		★★★★	★★★★	★★★★					★★★★	★★★★	Y74	Y78