

## Cutting Data

### CMT Milling cutter



**MT7** Sub-Micron Grade with Titanium Aluminum Nitride multi-layer coating (ISO K10 - K20). This is a general purpose grade, which can be used with all materials; it should be run at medium to high cutting speeds.

ISO Standard	Material	Cutting Speed m/min	Feed mm/tooth
<b>P</b>	Low and Medium Carbon Steels <0.55%C	60-120	0.05-0.15
	High Carbon Steels ≥0.55%C	60-90	0.05-0.10
	Alloy Steels, Treated Steels	50-80	0.05-0.10
<b>M</b>	Stainless Steel-Free Cutting	70-100	0.04-0.13
	Stainless Steel-Austenitic	60-90	0.04-0.10
	Cast Steels	70-90	0.04-0.13
<b>K</b>	Cast Iron	40-80	0.05-0.15
<b>N</b>	Aluminum ≤12%Si, Copper	100-200	0.05-0.25
	Aluminum >12%Si	60-140	0.03-0.10
	Synthetics, Duroplastics, Thermoplastics	50-200	0.05-0.25
<b>S</b>	Nickel alloys, Titanium Alloys.	20-40	0.03-0.10
<b>H</b>	Hardened Steel, ≤ 45 HRc	60-70	0.03-0.10