

# Cutting data recommendations

Optimized CoroMill® Plura ball nose for ISO S

ISO	MC code	Material description	HB	Semi-finishing ( $a_e = 0.05 \times DC$ )			Finishing ( $a_e = 0.01 \times DC$ )			
				$v_c$ m/min	$v_c$ ft/min	$f_z$	$v_c$ m/min	$v_c$ ft/min	$f_z$ mm	$f_z$ inch
S	S1.0.U.AG	Iron-based alloys	280	50	164	$0.004 \times DC$	70	230	0.05–0.03–0.01	0.002–0.0012–0.0004
	S2.0.Z.AN	Nickel-based alloys	250	50	164	$0.004 \times DC$	130	427		
	S2.0.Z.AG	Nickel-based alloys	350	65	213	$0.004 \times DC$	90	295		
	S4.3.Z.AN	Titanium-based alloys	330	110	361	$0.005 \times DC$	200	656		
	S4.4.Z.AN	Titanium-based alloys	410	55	180	$0.005 \times DC$	100	328		
M	P5.0.Z.AN	Ferritic/martensitic stainless steel	200	90	295	$0.008 \times DC$	100	328		
	M1.0.Z.AQ	Austenitic stainless steel	200	110	361	$0.008 \times DC$	130	427		
	M3.2.Z.AQ	Duplex (austenitic/ferritic) stainless steel	260	90	295	$0.008 \times DC$	100	328		
H	H1.1.Z.HA	Steel – hardness level 50	50HRC	145	476	$0.003 \times DC$	175	574		
	H1.2.Z.HA	Steel – hardness level 55	55HRC	145	476	$0.002 \times DC$	175	574		
	H1.3.Z.HA	Steel – hardness level 60	60HRC	85	279	$0.002 \times DC$	100	328		

For optimized cutting data, see CoroPlus® Tool Guide.