

CTN3105	CTS3105	CTBK102	CTBK104	CTM3110	CTN3110	CTC3110	CTCK120	CTD4110
v_c	v_c	v_c	v_c	v_c	v_c	v_c	v_c	v_c
[m/min]	[m/min]	[m/min]	[m/min]	[m/min]	[m/min]	[m/min]	[m/min]	[m/min]
							230 - 450	
							200 - 340	
							160 - 270	
							200 - 360	
							150 - 290	
							130 - 260	
							150 - 290	
							100 - 260	
							160 - 290	
							130 - 250	
							180 - 250	
300 - 1500	***400 - 1200		500 - 2000	500 - 1100	500 - 1100	250 - 450	150 - 400	
200 - 800	***150 - 500			300 - 800	300 - 800	220 - 350	180 - 350	
200 - 700	***250 - 600			200 - 600	200 - 600	220 - 380	200 - 380	
200 - 700		**200 - 700		250 - 450	250 - 450	200 - 350	160 - 300	
300 - 1000				300 - 800	300 - 800	200 - 400	200 - 350	
250 - 700				250 - 600	250 - 600	180 - 320	160 - 300	
								300 - 4000
								300 - 1500
								300 - 4000
								300 - 2000
								200 - 700
								100 - 700
								100 - 1500
								300 - 3000
								80 - 300
								80 - 300
								50 - 200
		100 - 250						
		100 - 250						
	40 - 200	100 - 200						
	30 - 180	100 - 200						
	70 - 200		30 - 120					
	60 - 70		30 - 120					

The cutting data are non-binding indications for the operator. It is recommended to adapt them to the current conditions.
 ** From cast iron GGG60 onwards / *** For finishing only