

ISO	Material Group	Workpiece Material	Brinell Hardness HB	Rockwell Hardness HRC	Tensile Strength MPa	Recommended Starting Speeds $v_c$ (ft/min)											
						GK1115			GK1125								
						$f_n$ (inch/rev)			$f_n$ (inch/rev)								
						.004	.008	.016	.004	.012	.020						
K Cast Iron	K1	Gray Cast Iron Ex. Class 20, 25, 30, 35, 40, 45, 50, 55, 60, G1800, G3000, G3500, G4000	120-290	<32	125-500	1800	1180	885	1540	885	655						
	K2	Ductile Cast Irons (Nodular Irons) and Compacted Graphite Irons (CGI) Ex. 60-40-18, 65-45-12, 80-55-06, SAE J434: D4018, D4512, D5506	130-260	<28	<600	1215	885	690	885	655	490						
	K3	High-Strength Ductile Irons and Austempered Ductile Irons (ADI) Ex. ASTM A536: 100-70-03, 120-90-02, SAE J434: D7003	180-350	<43	>600	885	690	560	655	490	400						