TPUN 160308 LT 30

Speeds & Feeds

Material Group		Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		V_c [sfm]		Suggested Starting Parameters		
						min	max	min	max	min	max	D.O.C.	Feed	V_c
Steel	Non-alloyed	1	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.020	0.474	0.006	0.011	620	1080	0.118	0.008	820
			2		190 HB		0.474		0.011		980			720
			3		250 HB		0.474		0.011		820			650
	Low alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.020	0.474	0.005	0.008	490	780	0.118	0.007	650
			4,6		230 HB		0.474		0.008	490	680		0.007	590
			5,7		280 HB		0.474		0.007	420	620		0.006	490
			8		350 HB		0.474		0.007	420	550		0.006	450
	High alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.020	0.339	0.004	0.007	290	490	0.089	0.006	420
			10		280 HB		0.339		0.007	290	420		0.006	390
			11		320 HB		0.339		0.006	190	360		0.005	320
			11		350 HB		0.339		0.006	190	290		0.005	260
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.020	0.474	0.006	0.011	490	780	0.118	0.008	650
			15		200 HB		0.474		0.011		720			590
			16		250 HB		0.474		0.011		620			520
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.020	0.474	0.005	0.009	320	650	0.118	0.007	590
			17,19		200 HB		0.474		0.009		590			490
			18,20		250 HB		0.474		0.009		490			420
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.020	0.169	0.003	0.006	130	260	0.059	0.005	190
			38		50 HRc		0.119		0.005		220	0.044	0.004	180
			38		55 HRc		0.102		0.005		190	0.030	0.004	160
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.020	0.135	0.003	0.006	130	260	0.044	0.005	160
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.020	0.102	0.003	0.005	90	190	0.030	0.004	130