

# CCMT 433 NN LT 10 & LT 1000

## Speeds & Feeds

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/rev]		Amax	V <sub>c</sub> [sfm]		Suggested Starting Parameters				
					min	max	min	max		min	max	D.O.C.	Feed	V <sub>c</sub>		
Steel	Non-alloyed	1	C35, Ck45, 1020,	125 HB	0.020	0.197	0.008	0.024	0.0033	590	1080	0.118	0.017	780		
		2	1045, 1060,	190 HB		0.197		0.024	0.0033		910			720		
		3	28Mn6	250 HB		0.197		0.021	0.0028		820			650		
	Low alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.020	0.197	0.008	0.021	0.0022	390	910	0.118	0.015	650	
		4,6	230 HB		0.157		0.008	0.021	0.0022	820		590				
		5,7	280 HB		0.157		0.007	0.019	0.0022	680		490				
		8	350 HB		0.138		0.007	0.019	0.0019	590		420				
	High alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.020	0.007	0.157	0.019	0.0022	220	620	0.098	0.014	450	
		10	280 HB		0.157			0.019	0.0022	490		390				
		11	320 HB		0.118			0.017	0.0015	420		320				
		11	350 HB		0.118			0.017	0.0015	360		290				
	Stainless Steel	Austenitic	4	304, 316, X5CrNi18-9	180 HB	0.020	0.008	0.197	0.019	0.0022	550	880	0.118	0.014	620	
14			240 HB		0.197			0.019	0.0019	520		720			550	
Duplex		5	X2CrNiN23-4, S31500	290 HB	0.020	0.007	0.157	0.017	0.0015	260	490	0.098	0.011	320		
		14		310 HB			0.157	0.017	0.0015		220			450	290	
Ferritic & Martensitic		6	410, X6Cr17, 17-4 PH, 430	200 HB	0.020	0.009	0.009	0.197	0.019	0.0019	550	820	0.118	0.014	620	
		13		42 HRc				0.157	0.019	0.0019		390			620	0.098
Cast Iron	Grey	7	GG20, GG40, EN-GJL-250, No30B	150 HB	0.020	0.006	0.197	0.028	0.0037	550	820	0.118	0.017	650		
		15		200 HB			0.197	0.028	0.0033		520			750	590	
		16		250 HB			0.197	0.026	0.0033		490			680	520	
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.020	0.006	0.197	0.024	0.0028	390	820	0.118	0.014	590		
		17,19		200 HB			0.197	0.024	0.0024		750			520		
		18,20		250 HB			0.197	0.024	0.0022		620			450		
High Temp. Alloys	Fe, Ni & Co based	9	31,32	Incoloy 800	0.020	0.008	0.118	0.017	0.0013	80	140	0.079	0.012	100		
		33	Inconel 700	250 HB			0.118	0.017		80	140			90		
		34	Stellite 21	350 HB			0.118	0.017		70	130			90		
	Ti based	10	36	TiAl6V4	-	0.020	0.008	0.157	0.019	0.0015	140	210	0.079	0.014	180	
		37	T40	-	0.118			0.017	0.0013	110	180	0.012		140		
	Hardened Mat.	Steel	11	38	X100CrMo13,	0.020	0.004	0.098	0.014	0.0011	160	320	0.079	0.012	260	
38			440C,	50 HRc	0.079			0.012	0.0007	130	290	0.059			0.009	220
38			G-X260NiCr42	55 HRc	0.059			0.009	0.0006	130	260	0.039			0.009	190
Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.020	0.079	0.004	0.012	0.0007	130	190	0.059	0.009	160		
White Cast Iron		41	G-X300CrMo15	55 HRc	0.020	0.059	0.004	0.009	0.0006	90	160	0.039	0.007	130		
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.020	0.236	0.008	0.028	0.0034	650	1310	0.118	0.019	910	



(800) 597-3921 or (317) 803-8000 for Application Support.  
For additional suggested Speeds & Feeds: <http://delivr.com/1kppm>

