

ODMW 060508 TN 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,	125 HB	0.020	0.157	0.009	0.023	620	1080	0.118	0.016	820	
			2	1045, 1060,	190 HB									720	
			3	28Mn6	250 HB									650	
	Low alloyed	2	6, 4,6, 5,7, 8	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.020	0.157	0.007	0.018	490	780	0.118	0.014	650	
					230 HB					490	680			0.014	590
					280 HB					420	620			0.013	490
					350 HB					420	550			0.013	450
	High alloyed	3	10, 10, 11, 11	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.020	0.112	0.006	0.016	290	490	0.089	0.013	420	
					280 HB					290	420			0.013	390
					320 HB					190	360			0.011	320
					350 HB					190	290			0.011	260
	Cast Iron	Grey	7	GG20, GG40, EN-GJL-250, No30B	150 HB	0.020	0.157	0.009	0.023	490	780	0.118	0.016	650	
200 HB					720									590	
250 HB					620									520	
Malleable & Nodular		8	17,19, 17,19, 18,20	GGG40, GGG70, 50005	150 HB	0.020	0.157	0.007	0.020	320	650	0.118	0.014	590	
					200 HB									590	490
					250 HB									490	420
Hardened Mat.	Steel	11	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.016	0.034	0.005	0.013	130	260	0.059	0.010	190		
				50 HRc									220	180	
				55 HRc									190	160	
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.016	0.045	0.005	0.013	130	260	0.044	0.010	160		
				White Cast Iron									41	G-X300CrMo15	55 HRc



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

