

OFMT 070405 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, 1045, 1060, 28Mn6	125 HB	0.020	0.176	0.009	0.020	620	1080	0.117	0.014	820
			2		190 HB									720
			3		250 HB									650
	Low alloyed	2	6, 4,6, 5,7, 8	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.020	0.176	0.007	0.016	490	780	0.117	0.013	650
					230 HB									590
					280 HB									490
					350 HB									420
	High alloyed	3	10, 10, 11, 11	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.020	0.126	0.006	0.014	290	490	0.087	0.011	420
					280 HB									390
					320 HB									320
					350 HB									260
	Stainless Steel	Austenitic	4	14, 14	304, 316, X5CrNi18-9	180 HB	0.020	0.176	0.007	0.014	620	820	0.117	0.011
240 HB						620								
Duplex		5	14, 14	X2CrNiN23-4, S31500	290 HB	0.020	0.126	0.006	0.011	220	420	0.087	0.010	320
					310 HB									290
Ferritic & Martensitic		6	12, 13	410, X6Cr17, 17-4 PH, 430	200 HB	0.020	0.176	0.007	0.014	490	680	0.117	0.011	620
					42 HRc									420
Cast Iron	Grey	7	15, 15, 16	GG20, GG40, EN-GJL-250, No30B	150 HB	0.020	0.176	0.009	0.020	490	780	0.117	0.014	650
					200 HB									590
					250 HB									520
	Malleable & Nodular	8	17,19, 17,19, 18,20	GGG40, GGG70, 50005	150 HB	0.020	0.176	0.007	0.018	320	650	0.117	0.013	590
					200 HB									490
					250 HB									420
High Temp. Alloys	Fe, Ni & Co based	9	31,32, 33, 34	Incoloy 800, Inconel 700, Stellite 21	240 HB	0.020	0.126	0.006	0.011	80	140	0.087	0.010	100
					250 HB									90
					350 HB									90
	Ti based	10	36, 37	TiAl6V4, T40	-	0.020	0.126	0.006	0.013	130	210	0.087	0.011	180
					-									130
	Hardened Mat.	Steel	11	38, 38, 38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.016	0.063	0.005	0.011	130	260	0.058	0.009
50 HRc						180								
55 HRc						160								
Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.016	0.050	0.005	0.011	130	260	0.044	0.009	160	
White Cast Iron		41	G-X300CrMo15	55 HRc	0.016	0.019	0.005	0.009	90	190	0.029	0.008	130	
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.020	0.176	0.009	0.020	650	1310	0.117	0.016	910



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

