

WNMP 332 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 _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	0.098	0.008	0.020	0.0018	590	1080	0.086	0.014	780
			2	1045, 1060,	190 HB		0.098		0.020	0.0018		910			720
			3	28Mn6	250 HB		0.098		0.018	0.0015		820			650
	Low alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.020	0.098	0.008	0.018	0.0012	390	910	0.086	0.013	650
			4,6		230 HB		0.079		0.018	0.0012		820	0.071	0.013	590
			5,7		280 HB		0.079		0.016	0.0012		680	0.071	0.012	490
			8		350 HB		0.069		0.016	0.0010		590	0.063	0.012	420
	High alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.020	0.079	0.007	0.016	0.0012	220	620	0.072	0.012	450
			10		280 HB		0.079		0.016	0.0012		490	0.072	0.012	390
			11		320 HB		0.059		0.014	0.0008		420	0.059	0.011	320
			11		350 HB		0.059		0.014	0.0008		360	0.059	0.011	290
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.020	0.098	0.008	0.016	0.0012	550	880	0.086	0.014	620
			14		240 HB		0.098		0.016	0.0010	520	720		0.013	550
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.020	0.079	0.007	0.014	0.0008	260	490	0.072	0.011	320
			14		310 HB		0.079		0.014		220	450			290
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.020	0.098	0.009	0.016	0.0010	550	820	0.086	0.013	620
			13		42 HRc		0.079		0.016		390	620			420
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.020	0.098	0.006	0.024	0.0020	550	820	0.086	0.014	650
			15		200 HB		0.098		0.024	0.0018	520	750			590
			16		250 HB		0.098		0.022	0.0018	490	680			520
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.020	0.098	0.006	0.020	0.0015	390	820	0.086	0.012	590
			17,19		200 HB		0.098		0.020	0.0013		750			520
			18,20		250 HB		0.098		0.020	0.0012		620			450
High Temp. Alloys	Fe, Ni & Co based	9	31,32	Incoloy 800	240 HB	0.020	0.059	0.008	0.014	0.0007	80	140	0.057	0.011	100
			33	Inconel 700	250 HB		0.059		0.014		80	140			90
			34	Stellite 21	350 HB		0.059		0.014		70	130			90
	Ti based	10	36	TiAl6V4	-	0.020	0.079	0.008	0.016	0.0008	140	210	0.057	0.013	180
			37	T40	-		0.059		0.014	0.0007	110	180		0.012	140
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.020	0.063	0.004	0.012	0.0006	160	320	0.057	0.010	260
			38		50 HRc		0.051		0.010	0.0004	130	290	0.039	0.008	220
			38		55 HRc		0.051		0.008	0.0003	130	260	0.039	0.007	190
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.020	0.051	0.004	0.010	0.0004	130	190	0.039	0.007	160
	White Cast Iron		41	G-X300CrMo15	55 HRc	0.020	0.051	0.004	0.008	0.0003	90	160	0.039	0.006	130
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.020	0.118	0.008	0.024	0.0028	650	1310	0.086	0.016	910

