

WNMG 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 _c [sfm]		Suggested Starting Parameters							
					min	max	min	max		min	max	D.O.C.	Feed	V _c					
Steel	Non-alloyed	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.029	0.236	0.010	0.027	0.0047	590	1080	0.158	0.018	780					
				190 HB							0.236			0.027	0.0047	910	720		
				250 HB							0.236			0.024	0.0040	820	650		
	Low alloyed	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.029	0.236	0.010	0.024	0.0032	390	910	0.158	0.017	0.017	650				
				230 HB							0.189				0.010	0.024	0.0032	820	590
				280 HB							0.189				0.009	0.021	0.0032	680	490
				350 HB							0.165				0.009	0.021	0.0026	590	420
	High alloyed	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.029	0.189	0.009	0.021	0.0032	220	620	0.132	0.016	0.016	450				
				280 HB							0.189				0.021	0.0032	490	390	
				320 HB							0.142				0.019	0.0021	420	320	
				350 HB							0.142				0.019	0.0021	360	290	
	Stainless Steel	Austenitic	4	304, 316, X5CrNi18-9	180 HB	0.029	0.236	0.010	0.021	0.0032	550	880	0.158	0.011	620				
240 HB					0.236						0.021	0.0026			520	720	550		
Duplex		5	X2CrNiN23-4, S31500	290 HB	0.029	0.189	0.009	0.019	0.0021	260	490	0.132	0.013	320					
				310 HB						0.189	0.019			0.0021	220	450	290		
Ferritic & Martensitic		6	410, X6Cr17, 17-4 PH, 430	200 HB	0.029	0.236	0.011	0.021	0.0026	550	820	0.158	0.016	0.016	620				
				42 HRc						0.189	0.021				0.0026	390	620	420	
Cast Iron	Grey	7	GG20, GG40, EN-GJL-250, No30B	150 HB	0.029	0.236	0.008	0.032	0.0053	550	820	0.158	0.018	650					
				200 HB										0.236	0.032	0.0047	520	750	590
				250 HB										0.236	0.029	0.0047	490	680	520
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.029	0.236	0.008	0.027	0.0040	390	820	0.158	0.016	0.016	590				
				200 HB							0.236				0.027	0.0034	750	520	
				250 HB							0.236				0.027	0.0032	620	450	
High Temp. Alloys	Fe, Ni & Co based	9	Incoloy 800	240 HB	0.029	0.142	0.010	0.019	0.0018	80	140	0.106	0.015	100					
				250 HB						0.142	0.019			0.0018	80	140	90		
				350 HB						0.142	0.019			0.0018	70	130	90		
	Ti based	10	TiAl6V4 T40	-	0.029	0.189	0.010	0.021	0.0021	140	210	0.106	0.017	180					
				-						0.142	0.019			0.0018	110	180	140		
				-						0.142	0.019			0.0018	110	180	140		
Hardened Mat.	Steel	11	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.029	0.118	0.005	0.016	0.0016	160	320	0.106	0.013	260					
				50 HRc						0.094	0.013			0.0011	130	290	220		
				55 HRc						0.071	0.011			0.0008	130	260	190		
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.029	0.094	0.005	0.013	0.0011	130	190	0.079	0.009	160					
	White Cast Iron	41	G-X300CrMo15	55 HRc	0.029	0.071	0.005	0.011	0.0008	90	160	0.053	0.008	130					
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.029	0.276	0.010	0.032	0.0048	650	1310	0.158	0.020	910				



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

