

CNMM 432 NR 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	0.020	0.276	0.008	0.024	0.0050	590	1080	0.195	0.018	780
				190 HB		0.276		0.024	0.0045		910		0.017	720
				250 HB		0.276		0.021	0.0037		820		0.016	650
	Low alloyed	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.020	0.276	0.008	0.021	0.0040	390	910	0.195	0.015	650
				230 HB		0.220		0.021	0.0035		820		0.015	590
				280 HB		0.220		0.019	0.0030		680		0.014	490
				350 HB		0.193		0.019	0.0025		590		0.014	420
	High alloyed	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.020	0.220	0.007	0.019	0.0030	220	620	0.162	0.014	450
				280 HB		0.220		0.019	0.0030		490		0.014	390
				320 HB		0.165		0.017	0.0020		420		0.013	320
				350 HB		0.165		0.017	0.0020		360		0.013	290
Stainless Steel	Austenitic	4	304, 316, X5CrNi18-9	180 HB	0.020	0.276	0.008	0.019	0.0030	550	880	0.195	0.013	620
				240 HB		0.276		0.019	0.0027		720		0.012	550
	Duplex	5	X2CrNiN23-4, S31500	290 HB	0.020	0.220	0.007	0.017	0.0022	260	490	0.162	0.010	320
				310 HB		0.220		0.017	0.0022		450			290
	Ferritic & Martensitic	6	410, X6Cr17, 17-4 PH, 430	200 HB	0.020	0.276	0.009	0.019	0.0030	550	820	0.195	0.013	620
				42 HRC		0.220		0.019	0.0030		390			420
Cast Iron	Grey	7	GG20, GG40, EN-GJL-250, No30B	150 HB	0.020	0.276	0.006	0.028	0.0050	550	820	0.195	0.017	650
				200 HB		0.276		0.028	0.0045		750			590
				250 HB		0.276		0.026	0.0045		680			520
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.020	0.276	0.006	0.024	0.0037	390	820	0.195	0.014	590
				200 HB		0.276		0.024	0.0032		750			520
				250 HB		0.276		0.024	0.0030		620			450
High Temp. Alloys	Fe, Ni & Co based	9	31,32 Incoloy 800	240 HB	0.020	0.165	0.008	0.017	0.0022	80	160	0.130	0.013	100
			33 Inconel 700	250 HB		0.165		0.017	0.0022		80			90
			34 Stellite 21	350 HB		0.165		0.017	0.0020		70			90
	Ti based	10	36 TiAl6V4	-	0.020	0.193	0.008	0.019	0.0025	140	210	0.130	0.015	180
			37 T40	-		0.165		0.017	0.0020		110		0.013	140
Hardened Mat.	Steel	11	X100CrMo13, 440C, G-X260NiCr42	45 HRC	0.020	0.138	0.004	0.014	0.0015	160	320	0.130	0.012	260
				50 HRC		0.110		0.012	0.0012		290			220
				55 HRC		0.088		0.009	0.0007		130			190
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.020	0.110	0.004	0.012	0.0012	130	190	0.097	0.009	160
	White Cast Iron	41	G-X300CrMo15	55 HRC	0.020	0.088	0.004	0.009	0.0007	90	160	0.065	0.007	130
NF	Al (>8%Si)	12	AlSi12	130 HB	0.020	0.331	0.008	0.028	0.0050	650	1310	0.195	0.019	910



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

