

CNMG 432 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	0.020	0.197	0.008	0.020	0.0031	590	1080	0.118	0.015	780
				190 HB		0.197		0.020	0.0028		910		0.014	720
				250 HB		0.197		0.018	0.0023		820		0.013	650
	Low alloyed	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.020	0.197	0.008	0.018	0.0025	390	910	0.118	0.013	650
				230 HB		0.157		0.018	0.0022		820		0.013	590
				280 HB		0.157		0.016	0.0019		680		0.012	490
				350 HB		0.138		0.016	0.0016		590		0.012	420
	High alloyed	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.020	0.157	0.007	0.016	0.0019	220	620	0.098	0.012	450
				280 HB		0.157		0.016	0.0019		490		0.012	390
				320 HB		0.118		0.014	0.0012		420		0.011	320
				350 HB		0.118		0.014	0.0012		360		0.011	290
Stainless Steel	Austenitic	4	304, 316, X5CrNi18-9	180 HB	0.020	0.197	0.008	0.016	0.0016	550	880	0.118	0.010	620
				240 HB		0.197		0.016	0.0014		720		0.009	550
	Duplex	5	X2CrNiN23-4, S31500	290 HB	0.020	0.157	0.007	0.014	0.0011	260	490	0.098	0.011	320
				310 HB		0.157		0.014			450			290
	Ferritic & Martensitic	6	410, X6Cr17, 17-4 PH, 430	200 HB	0.020	0.197	0.009	0.016	0.0016	550	820	0.118	0.013	620
				42 HRc		0.157		0.016			390			420
Cast Iron	Grey	7	GG20, GG40, EN-GJL-250, No30B	150 HB	0.020	0.197	0.006	0.024	0.0031	550	820	0.118	0.014	650
				200 HB		0.197		0.024	0.0028		750			590
				250 HB		0.197		0.022	0.0028		490			520
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.020	0.197	0.006	0.020	0.0023	390	820	0.118	0.012	590
				200 HB		0.197		0.020	0.0020		750			520
				250 HB		0.197		0.020	0.0019		620			450
High Temp. Alloys	Fe, Ni & Co based	9	31,32 Incoloy 800	240 HB	0.020	0.118	0.008	0.014	0.0011	80	160	0.079	0.011	100
			33 Inconel 700	250 HB		0.118		0.014			160			90
			34 Stellite 21	350 HB		0.118		0.014			70			90
	Ti based	10	36 TiAl6V4	-	0.020	0.138	0.008	0.016	0.0012	140	210	0.079	0.013	180
			37 T40	-		0.118		0.014	0.0011		190			140
Hardened Mat.	Steel	11	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.020	0.098	0.004	0.012	0.0009	160	320	0.079	0.010	260
				50 HRc		0.079		0.010	0.0008		290			220
				55 HRc		0.063		0.008	0.0005		130			190
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.020	0.079	0.004	0.010	0.0008	130	190	0.059	0.007	160
	White Cast Iron	41	G-X300CrMo15	55 HRc	0.020	0.063	0.004	0.008	0.0005	90	160	0.039	0.006	130
NF	Al (>8%Si)	12	25 AlSi12	130 HB	0.020	0.236	0.008	0.024	0.0031	650	1310	0.118	0.016	910



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

