

DNUX 442 R11 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	0.197	0.008	0.020	0.0028	590	1080	0.118	0.014	780
			2 1045, 1060,	190 HB		0.197		0.020	0.0028		910			720
			3 28Mn6	250 HB		0.197		0.018	0.0023		820			650
	Low alloyed	2	6 42CrMo4, St50,	180 HB	0.020	0.197	0.008	0.018	0.0019	390	910	0.118	0.013	650
			4,6 Ck60, 4140, 4340,	230 HB		0.157		0.018	0.0019		820		0.013	590
			5,7 100Cr6	280 HB		0.157		0.016	0.0019		680		0.012	490
			8	350 HB		0.138		0.016	0.0016		590		0.012	420
	High alloyed	3	10 X40CrMoV5,	220 HB	0.020	0.157	0.007	0.016	0.0019	220	620	0.098	0.012	450
			10 H13, M42, D3,	280 HB		0.157		0.016	0.0019		490		0.012	390
			11 S6-5-2, 12Ni19	320 HB		0.118		0.014	0.0012		420		0.011	320
			11	350 HB		0.118		0.014	0.0012		360		0.011	290
Stainless Steel	Austenitic	4	14 304, 316,	180 HB	0.020	0.197	0.008	0.016	0.0019	550	880	0.118	0.014	620
			14 X5CrNi18-9	240 HB		0.197		0.016	0.0016		720		0.013	550
	Duplex	5	14 X2CrNiN23-4,	290 HB	0.020	0.157	0.007	0.014	0.0012	260	490	0.098	0.011	320
			14 S31500	310 HB		0.157		0.014			450			290
	Ferritic & Martensitic	6	12 410, X6Cr17,	200 HB	0.020	0.197	0.009	0.016	0.0016	550	820	0.118	0.013	620
			13 17-4 PH, 430	42 HRC		0.157		0.016			390			420
Cast Iron	Grey	7	15 GG20, GG40,	150 HB	0.020	0.197	0.006	0.024	0.0031	550	820	0.118	0.014	650
			15 EN-GJL-250,	200 HB		0.197		0.024	0.0028		750			590
			16 No30B	250 HB		0.197		0.022	0.0028		490			520
	Malleable & Nodular	8	17,19 GGG40, GGG70,	150 HB	0.020	0.197	0.006	0.020	0.0023	390	820	0.118	0.012	590
			17,19 50005	200 HB		0.197		0.020	0.0020		750			520
			18,20	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	140	0.079	0.011	100
			33 Inconel 700	250 HB		0.118		0.014			80			90
			34 Stellite 21	350 HB		0.118		0.014			70			90
	Ti based	10	36 TiAl6V4	-	0.020	0.157	0.008	0.016	0.0012	140	210	0.079	0.013	180
			37 T40	-		0.118		0.014	0.0011		180		0.012	140
Hardened Mat.	Steel	11	38 X100CrMo13,	45 HRC	0.020	0.098	0.004	0.012	0.0009	160	320	0.079	0.010	260
			38 440C,	50 HRC		0.079		0.010	0.0006		290			220
			38 G-X260NiCr42	55 HRC		0.059		0.008	0.0005		130		0.007	190
	Chilled Cast Iron		40 Ni-Hard 2	400 HB	0.020	0.079	0.004	0.010	0.0006	130	190	0.059	0.007	160
	White Cast Iron		41 G-X300CrMo15	55 HRC	0.020	0.059	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	0.0028	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>

