

APKT 160432 PDTR LT30

Speeds & Feeds

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/tooth]		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,	125 HB	0.020	0.590	0.007	0.013	620	1080	0.217	0.009	820
			2 1020, 1045,	190 HB	0.020	0.590	0.007	0.013	620	980	0.217	0.009	720
			3 1060, 28Mn6	250 HB	0.020	0.590	0.007	0.013	620	820	0.217	0.009	650
	Low alloyed	2	6 42CrMo4, St50,	180 HB	0.020	0.590	0.006	0.010	490	780	0.217	0.008	650
			4,6 Ck60, 4140,	230 HB	0.020	0.590	0.006	0.010	490	680	0.217	0.008	590
			5,7 4340, 100Cr6	280 HB	0.020	0.590	0.006	0.009	420	620	0.217	0.007	490
			8	350 HB	0.020	0.590	0.006	0.009	420	550	0.217	0.007	450
	High alloyed	3	10 X40CrMoV5,	220 HB	0.020	0.422	0.005	0.009	290	490	0.162	0.007	420
			10 H13, M42, D3,	280 HB	0.020	0.422	0.005	0.009	290	420	0.162	0.007	390
			11 S6-5-2, 12Ni19	320 HB	0.020	0.422	0.005	0.007	190	360	0.162	0.006	320
				350 HB	0.020	0.422	0.005	0.007	190	290	0.162	0.006	260
Stainless Steel	Austenitic	4	14 304, 316,	180 HB	0.020	0.590	0.006	0.010	620	820	0.217	0.008	720
			14 X5CrNi18-9	240 HB	0.020	0.590	0.005	0.009	520	680	0.217	0.008	620
	Duplex	5	14 X2CrNiN23-4,	290 HB	0.020	0.422	0.005	0.007	220	420	0.162	0.006	320
			14 S31500	310 HB	0.020	0.422	0.005	0.007	220	390	0.162	0.006	290
	Ferritic & Martensitic	6	12 410, X6Cr17,	200 HB	0.020	0.590	0.006	0.010	490	680	0.217	0.008	620
			13 17-4 PH, 430	42 HRC	0.020	0.422	0.006	0.008	290	490	0.162	0.006	420
Cast Iron	Grey	7	15 GG20, GG40,	150 HB	0.020	0.590	0.007	0.013	490	780	0.217	0.009	650
			15 EN-GJL-250,	200 HB	0.020	0.590	0.007	0.013	490	720	0.217	0.009	590
			16 No30B	250 HB	0.020	0.590	0.007	0.013	490	620	0.217	0.009	520
	Malleable & Nodular	8	17,19 GGG40, GGG70,	150 HB	0.020	0.590	0.006	0.011	320	650	0.217	0.008	590
			17,19 50005	200 HB	0.020	0.590	0.006	0.011	320	590	0.217	0.008	490
			18,20	250 HB	0.020	0.590	0.006	0.011	320	490	0.217	0.008	420
High Temp. Alloys	Fe, Ni & Co based	9	31,32 Incoloy 800	240 HB	0.020	0.422	0.005	0.007	80	140	0.162	0.006	100
			33 Inconel 700	250 HB	0.020	0.422	0.005	0.007	80	140	0.162	0.006	90
			34 Stellite 21	350 HB	0.020	0.422	0.005	0.007	80	140	0.162	0.006	90
	Ti based	10	36 TiAl6V4	-	0.020	0.422	0.005	0.008	130	210	0.162	0.007	180
			37 T40	-	0.020	0.422	0.005	0.007	90	180	0.162	0.006	130
Hardened Mat.	Steel	11	38 X100CrMo13,	45 HRC	0.020	0.211	0.004	0.007	130	260	0.108	0.006	190
			38 440C,	50 HRC	0.020	0.126	0.004	0.006	130	220	0.081	0.005	180
			38 G-X260NiCr42	55 HRC	0.020	0.063	0.004	0.006	130	190	0.054	0.005	160
	Chilled Cast Iron		40 Ni-Hard 2	400 HB	0.020	0.169	0.004	0.007	130	260	0.081	0.006	160
	White Cast Iron		41 G-X300CrMo15	55 HRC	0.020	0.063	0.004	0.006	90	190	0.054	0.005	130
NF	Al (>8%Si)	12	25 AlSi12	130 HB	0.020	0.590	0.007	0.013	650	1310	0.217	0.010	910

