

SNKX 1205-45° 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, 1020, 1045, 1060, 28Mn6	125 HB	0.020	0.256	0.006	0.023	620	1080	0.126	0.015	820
			2		190 HB		0.256		0.023		980			720
			3		250 HB		0.256		0.023		820			650
	Low alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.020	0.256	0.006	0.020	490	780	0.126	0.013	650
			4,6		230 HB		0.256		0.020		680			590
			5,7		280 HB		0.256		0.017		420			490
			8		350 HB		0.256		0.017		420			450
	High alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.020	0.256	0.004	0.017	290	490	0.094	0.011	420
			10		280 HB		0.256		0.017		420			390
			11		320 HB		0.256		0.014		360			320
			11		350 HB		0.256		0.014		290			260
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.020	0.256	0.006	0.017	620	820	0.126	0.011	720
			14		240 HB		0.256		0.016		680			620
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.020	0.197	0.004	0.014	220	420	0.094	0.009	320
			14		310 HB		0.197		0.014		390			290
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.020	0.256	0.006	0.017	490	680	0.126	0.011	620
			13		42 HRc		0.198		0.016		490			420
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.020	0.256	0.007	0.023	490	720	0.126	0.015	590
			16		200 HB		0.256		0.023		620			520
			16		250 HB		0.256		0.023		620			520
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.020	0.256	0.006	0.020	320	650	0.126	0.013	590
			17,19		200 HB		0.256		0.020		590			490
			18,20		250 HB		0.256		0.020		490			420
High Temp. Alloys	Fe, Ni & Co based	9	31,32	Incoloy 800	240 HB	0.020	0.197	0.004	0.014	80	140	0.094	0.009	100
			33	Inconel 700	250 HB		0.197		0.014		140			90
			34	Stellite 21	350 HB		0.197		0.014		140			90
	Ti based	10	36	TiAl6V4	-	0.020	0.197	0.004	0.016	130	210	0.094	0.011	180
			37	T40	-		0.197		0.014		90			130
	Ti based	10	36	TiAl6V4	-	0.020	0.197	0.004	0.016	130	210	0.094	0.011	180
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.016	0.119	0.004	0.014	130	260	0.063	0.009	190
			38		50 HRc		0.119		0.013		220			180
			38		55 HRc		0.059		0.011		190			160
	Chilled Cast Iron	11	40	Ni-Hard 2	400 HB	0.016	0.119	0.004	0.014	130	260	0.039	0.009	160
			41	G-X300CrMo15	55 HRc		0.059		0.011		90			130
	White Cast Iron	11	41	G-X300CrMo15	55 HRc	0.016	0.059	0.004	0.011	90	190	0.031	0.007	130
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.020	0.256	0.007	0.024	650	1310	0.126	0.016	910



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

