

SDKX 1205 HF LT 30

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	0.098	0.012	0.118	620	1080	0.098	0.102	820
			2	1020, 1045,	190 HB		0.098		0.118		980			720
			3	1060, 28Mn6	250 HB		0.098		0.118		820			650
	Low alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.020	0.087	0.012	0.110	490	780	0.087	0.094	650
			4,6		230 HB		0.087		0.110		680			590
			5,7		280 HB		0.087		0.110		620			490
			8		350 HB		0.087		0.110		550			450
	High alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.020	0.079	0.012	0.098	290	490	0.079	0.079	420
			10		280 HB		0.079		0.098		420			390
			11		320 HB		0.079		0.098		360			320
			11		350 HB		0.079		0.098		290			260
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	0.020	0.079	0.012	0.059	620	820	0.079	0.047	720
			14		240 HB		0.079		0.059		680			620
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.020	0.079	0.012	0.039	220	420	0.079	0.031	320
			14		310 HB		0.079		0.039		390			290
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.020	0.079	0.012	0.047	490	680	0.079	0.031	620
			13		42 HRC		0.079		0.039		490			420
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	0.020	0.098	0.012	0.118	490	780	0.098	0.102	650
			15		200 HB		0.098		0.118		720			590
			16		250 HB		0.098		0.118		620			520
	Malleable & Nodular	8	17, 18, 18, 20, 20, 25	GGG40, GGG70, 50005	150 HB	0.020	0.098	0.012	0.098	320	650	0.098	0.079	590
			17, 18, 18, 20, 20, 25		200 HB		0.098		0.098		590			490
			18, 20, 20, 25		250 HB		0.098		0.098		490			420
High Temp. Alloys	Fe, Ni & Co based	9	33	Incoloy 800	240 HB	0.020	0.059	0.012	0.035	80	140	0.059	0.028	100
			33	Inconel 700	250 HB		0.059		0.035		140			90
			34	Stellite 21	350 HB		0.059		0.035		140			90
	Ti based	10	36	TiAl6V4	-	0.020	0.059	0.012	0.031	130	210	0.059	0.024	180
			37	T40	-		0.059		0.031		180			130
Hardened Mat.	Steel	11	38	X100CrMo13,	45 HRC	0.012	0.055	0.012	0.055	130	260	0.047	0.039	190
			38	440C,	50 HRC		0.047		0.047		220			180
			38	G-X260NiCr42	55 HRC		0.039		0.039		190			160
			40	Ni-Hard 2	400 HB		0.047		0.035		260			160
			41	G-X300CrMo15	55 HRC		0.039		0.035		90			130
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.020	0.118	0.012	0.079	650	1310	0.098	0.063	910



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

