

TCMT 3(2.5)2 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					
					7	max	min	max		min	max	D.O.C.	Feed	V _c			
Steel	Non-alloyed	1	C35, Ck45, 1020,	125 HB	0.020	0.197	0.008	0.017	0.0025	590	1080	0.118	0.012	780			
		2	1045, 1060,	190 HB		0.197		0.017	0.0025		910			720			
		3	28Mn6	250 HB		0.197		0.015	0.0021		820			650			
	Low alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.020	0.197	0.008	0.015	0.0017	390	910	0.118	0.011	650		
			4,6		230 HB		0.157		0.015	0.0017		820		590			
			5,7		280 HB		0.157		0.007	0.013		0.0017		680	490		
			8		350 HB		0.138		0.007	0.013		0.0014		590	420		
	High alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.020	0.157	0.007	0.013	0.0017	220	620	0.098	0.010	450		
			10		280 HB		0.157		0.013	0.0017		490		390			
			11		320 HB		0.118		0.012	0.0011		420		320			
			11		350 HB		0.118		0.012	0.0011		360		290			
	Stainless Steel	Austenitic	4	304, 316, X5CrNi18-9	180 HB	0.020	0.197	0.008	0.013	0.0017	550	880	0.118	0.012	650		
14			240 HB		0.197		0.013		0.0014	520		720		0.011	590		
Duplex		5	X2CrNiN23-4, S31500	290 HB	0.020	0.157	0.007	0.012	0.0011	260	490	0.098	0.009	320			
		14		310 HB		0.157		0.012			0.0011		220	450	0.000	290	
Ferritic & Martensitic		6	410, X6Cr17, 17-4 PH, 430	200 HB	0.020	0.197	0.009	0.013	0.0014	550	820	0.118	0.011	620			
				42 HRc		0.157		0.013			0.0014			390	620	0.098	420
Cast Iron	Grey	7	GG20, GG40, EN-GJL-250, No30B	150 HB	0.020	0.197	0.006	0.020	0.0028	550	820	0.118	0.012	650			
		15		200 HB		0.197		0.020	0.0025		520			750	590		
		16		250 HB		0.197		0.018	0.0025		490			680	520		
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.020	0.197	0.006	0.017	0.0021	390	820	0.118	0.010	590			
				17,19		200 HB		0.197	0.017		0.0018			750	520		
				18,20		250 HB		0.197	0.017		0.0017			620	450		
High Temp. Alloys	Fe, Ni & Co based	9	Incoloy 800	240 HB	0.020	0.118	0.008	0.012	0.0010	80	140	0.079	0.009	100			
		33		Inconel 700		250 HB		0.118			0.012			0.0010	80	140	90
		34		Stellite 21		350 HB		0.118			0.012			0.0010	70	130	90
	Ti based	10	TiAl6V4	-	0.020	0.157	0.008	0.013	0.0011	140	210	0.079	0.011	180			
				-		0.118		0.012	0.0010		110		180	0.010	140		
	Hardened Mat.	Steel	11	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.020	0.098	0.004	0.010	0.0008	160	320	0.079	0.008	260		
38			50 HRc		0.079		0.008		0.0006	130		290			0.059	0.007	220
38			55 HRc		0.059		0.007		0.0004	130		260			0.039	0.006	190
Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.020	0.079	0.004	0.008	0.0006	130	190	0.059	0.006	160			
White Cast Iron		41	G-X300CrMo15	55 HRc	0.020	0.059	0.004	0.007	0.0004	90	160	0.039	0.005	130			
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.020	0.236	0.008	0.020	0.0025	650	1310	0.118	0.013	910		



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

