

CCMT 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					
					min	max	min	max		min	max	D.O.C.	Feed	V _c			
Steel	Non-alloyed	1	1	C35, Ck45, 1020,	125 HB	0.020	0.157	0.008	0.020	0.0025	590	1080	0.118	0.012	780		
		2	2	1045, 1060,	190 HB		0.157		0.020	0.0025		910			720		
		3	3	28Mn6	250 HB		0.157		0.018	0.0021		820			650		
	Low alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.020	0.157	0.008	0.018	0.0017	390	910	0.118	0.011	650		
			4,6		230 HB		0.126		0.008	0.018		0.0017			820	590	
			5,7		280 HB		0.126		0.007	0.016		0.0017			680	490	
			8		350 HB		0.110		0.007	0.016		0.0014			590	420	
	High alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.020	0.126	0.007	0.016	0.0017	220	620	0.098	0.011	450		
			10		280 HB		0.126		0.016	0.0017		490			390		
			11		320 HB		0.094		0.014	0.0011		420			320		
			11		350 HB		0.094		0.014	0.0011		360			290		
	Stainless Steel	Austenitic	4	14	304, 316,	180 HB	0.020	0.157	0.008	0.016	0.0017	550	880	0.118	0.012	650	
X5CrNi18-9					240 HB	0.157				0.016	0.0014		520			720	590
Duplex		5	14	X2CrNiN23-4, S31500	290 HB	0.020	0.126	0.007	0.014	0.0011	260	490	0.098	0.010	320		
					310 HB				0.126	0.014		0.0011			220	450	290
Ferritic & Martensitic		6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.020	0.157	0.009	0.016	0.0014	550	820	0.118	0.011	620		
					42 HRc				0.126	0.016		0.0014			390	620	420
Cast Iron	Grey	7	15	GG20, GG40,	150 HB	0.020	0.157	0.006	0.024	0.0028	550	820	0.118	0.012	650		
				EN-GJL-250, No30B	200 HB				0.157	0.024		0.0025			520	750	590
				250 HB	0.157				0.022	0.0025		490			680	520	
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.020	0.157	0.006	0.020	0.0021	390	820	0.118	0.011	590		
					200 HB				0.157	0.020		0.0018			750	520	
					250 HB				0.157	0.020		0.0017			620	450	
High Temp. Alloys	Fe, Ni & Co based	9	31,32	Incoloy 800	240 HB	0.020	0.094	0.008	0.014	0.0010	80	140	0.079	0.010	100		
				Inconel 700	250 HB				0.094		0.014	0.0010			80	140	90
				Stellite 21	350 HB				0.094		0.014	0.0010			70	130	90
	Ti based	10	36	TiAl6V4	-	0.020	0.126	0.008	0.016	0.0011	140	210	0.079	0.012	180		
					T40				-	0.094		0.014			0.0010	110	180
Hardened Mat.	Steel	11	38	X100CrMo13,	45 HRc	0.020	0.079	0.004	0.012	0.0008	160	320	0.079	0.009	260		
				440C,	50 HRc				0.063	0.010		0.0006			130	290	220
				G-X260NiCr42	55 HRc				0.047	0.008		0.0004			130	260	190
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.020	0.063	0.004	0.010	0.0006	130	190	0.059	0.006	160			
	White Cast Iron	41	G-X300CrMo15	55 HRc	0.020	0.047	0.004	0.008	0.0004	90	160	0.039	0.005	130			
	NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.020	0.189	0.008	0.024	0.0025	650	1310	0.118	0.014	910	



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

