

CNMP 432 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	C35, Ck45, 1020,	125 HB	0.020	0.197	0.008	0.020	0.0028	590	1080	0.118	0.014	780		
		2	1045, 1060,	190 HB		0.197		0.020	0.0028		910			720		
		3	28Mn6	250 HB		0.197		0.018	0.0023		820			650		
	Low alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.020	0.197	0.008	0.018	0.0019	390	910	0.118	0.013	650	
			4,6		230 HB		0.157	0.008	0.018	0.0019		820		0.013	590	
			5,7		280 HB		0.157	0.007	0.016	0.0019		680		0.012	490	
			8		350 HB		0.138	0.007	0.016	0.0016		590		0.012	420	
	High alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.020	0.157	0.007	0.016	0.0019	220	620	0.098	0.012	450	
			10		280 HB		0.157		0.016	0.0019		490		0.012	390	
			11		320 HB		0.118		0.014	0.0012		420		0.011	320	
			11		350 HB		0.118		0.014	0.0012		360		0.011	290	
	Stainless Steel	Austenitic	4	304, 316, X5CrNi18-9	180 HB	0.020	0.197	0.008	0.016	0.0019	550	880	0.118	0.010	620	
14			240 HB		0.197		0.016		0.0016	520		720		0.009	550	
Duplex		5	X2CrNiN23-4, S31500	290 HB	0.020	0.157	0.007	0.014	0.0012	260	490	0.098	0.011	320		
		14		310 HB		0.157		0.014			220			450	290	
Ferritic & Martensitic		6	410, X6Cr17, 17-4 PH, 430	200 HB	0.020	0.197	0.009	0.016	0.0016	550	820	0.118	0.013	620		
		13		42 HRC		0.157		0.016			390			620	0.098	420
Cast Iron	Grey	7	GG20, GG40, EN-GJL-250, No30B	150 HB	0.020	0.197	0.006	0.024	0.0031	550	820	0.118	0.014	650		
		15		200 HB		0.197		0.024	0.0028		520			750	590	
		16		250 HB		0.197		0.022	0.0028		490			680	520	
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.020	0.197	0.006	0.020	0.0023	390	820	0.118	0.012	590		
		17,19		200 HB		0.197		0.020	0.0020		750			520		
		18,20		250 HB		0.197		0.020	0.0019		620			450		
High Temp. Alloys	Fe, Ni & Co based	9	Incoloy 800	240 HB	0.020	0.118	0.008	0.014	0.0011	80	140	0.079	0.011	100		
		33		Inconel 700		250 HB		0.118			0.014			80	140	90
		34		Stellite 21		350 HB		0.118			0.014			70	130	90
	Ti based	10	TiAl6V4 T40	-	0.020	0.157	0.008	0.016	0.0012	140	210	0.079	0.013	180		
		37		-		0.118		0.014	0.0011		110		180	0.012	140	
	Hardened Mat.	Steel	11	X100CrMo13, 440C, G-X260NiCr42	45 HRC	0.020	0.098	0.004	0.012	0.0009	160	320	0.079	0.010	260	
38			50 HRC		0.079		0.010		0.0006	130		290		0.059	0.008	220
38			55 HRC		0.059		0.008		0.0005	130		260		0.039	0.007	190
Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.020	0.079	0.004	0.010	0.0006	130	190	0.059	0.007	160		
White Cast Iron		41	G-X300CrMo15	55 HRC	0.020	0.059	0.004	0.008	0.0005	90	160	0.039	0.006	130		
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.020	0.236	0.008	0.024	0.0028	650	1310	0.118	0.016	910	



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

