

DNMG 431 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	0.008	0.118	0.004	0.009	0.0009	590	1080	0.079	0.007	980		
		2	1045, 1060,	190 HB		0.098		0.009	0.0008		910			850		
		3	28Mn6	250 HB		0.098		0.008	0.0007		820			780		
	Low alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.008	0.098	0.004	0.008	0.0008	390	910	0.079	0.006	850	
			4,6		230 HB		0.098		0.008	0.0007		820			780	
			5,7		280 HB		0.079		0.007	0.0006		680			650	
			8		350 HB		0.079		0.007	0.0006		590			590	
	High alloyed	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.008	0.098	0.004	0.007	0.0006	220	620	0.079	0.005	590		
				280 HB		0.098		0.006	0.0006		490			450		
				320 HB		0.079		0.006	0.0005		420			390		
				350 HB		0.079		0.006	0.0004		360			360		
	Stainless Steel	Austenitic	4	304, 316, X5CrNi18-9	180 HB	0.008	0.098	0.004	0.007	0.0005	550	880	0.079	0.005	850	
240 HB					0.098				0.007	0.0004	520	720			680	
Duplex		5	X2CrNiN23-4, S31500	290 HB	0.008	0.079	0.004	0.006	0.0003	260	490	0.079	0.005	450		
				310 HB				0.079	0.006	0.0003	220			450	450	
Ferritic & Martensitic		6	410, X6Cr17, 17-4 PH, 430	200 HB	0.008	0.098	0.004	0.007	0.0005	550	820	0.079	0.006	780		
				42 HRc				0.079	0.006	0.0004	390			620	590	
Cast Iron	Grey	7	GG20, GG40, EN-GJL-250, No30B	150 HB	0.008	0.118	0.003	0.008	0.0010	550	820	0.079	0.007	780		
				200 HB				0.118	0.008	0.0009	520			750	720	
				250 HB				0.118	0.008	0.0009	490			680	650	
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.008	0.098	0.003	0.007	0.0007	390	820	0.079	0.006	780		
				200 HB				0.098	0.007	0.0006	750			720		
				250 HB				0.098	0.007	0.0006	620			590		
High Temp. Alloys	Fe, Ni & Co based	9	31,32	Incoloy 800	0.008	0.079	0.004	0.006	0.0004	80	160	0.079	0.005	130		
			33	Inconel 700				250 HB	0.079	0.006	0.0004			80	160	130
			34	Stellite 21				350 HB	0.079	0.006	0.0004			70	140	110
	Ti based	10	36	TiAl6V4	0.008	0.079	0.004	0.006	0.0005	140	210	0.079	0.006	190		
			37	T40				-	0.079	0.006	0.0004			110	190	160
Hardened Mat.	Steel	11	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.008	0.071	0.002	0.005	0.0003	160	320	0.059	0.004	290		
				50 HRc				0.059	0.004	0.0003	130			290	260	
				55 HRc				0.055	0.004	0.0002	130			260	220	
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.008	0.063	0.002	0.005	0.0003	130	190	0.047	0.004	160		
	White Cast Iron	41	G-X300CrMo15	55 HRc	0.008	0.055	0.002	0.004	0.0002	90	160	0.039	0.003	130		
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.008	0.157	0.004	0.012	0.0011	650	1310	0.079	0.008	1140	



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

