

MACHINING CONDITIONS

SPKN 1504 EDTR – LT 3000

Catalog N°: M0004037

Material Group	Gr. N°	VDI Group	Material Examples	Hardness	DOC [mm]		Feed [mm/rev]		V _c [m/min]		Suggested Starting Parameters			
					min	max	min	max	min	max	DOC	Feed	V _c	
P	Non Alloyed	1	C35, Ck45,	125 HB	0.5	9	0.18	0.43	190	330	4	0.3	250	
		2	1020, 1045,	190 HB	0.5	9	0.18	0.43	190	300	4	0.3	220	
		3	1060, 28Mn6	250 HB	0.5	9	0.18	0.43	190	250	4	0.3	200	
	Low Alloyed	2	4, 6	42CrMo4,	180 HB	0.5	9	0.15	0.34	150	210	4	0.26	180
		5, 7	St50, Ck60,	230 HB	0.5	9	0.15	0.3	130	190	4	0.23	150	
		6	4140, 4340,	280 HB	0.5	9	0.15	0.34	150	240	4	0.26	200	
		8	100Cr06	350 HB	0.5	9	0.15	0.3	130	170	4	0.23	140	
	High Alloyed	3	10	X40CrMoV5,	220 HB	0.5	6.5	0.12	0.3	90	150	3	0.23	130
		10	H13, M42, D3,	280 HB	0.5	6.5	0.12	0.3	90	130	3	0.23	120	
		11	S6-5-2, 12Ni19	320 HB	0.5	6.5	0.12	0.24	60	110	3	0.21	100	
		11		350 HB	0.5	6.5	0.12	0.24	60	90	3	0.21	80	
K	Grey	7	15	GG20, GG40,	150 HB	0.5	9	0.18	0.43	150	240	4	0.3	200
		15	EN-GJL-250	200 HB	0.5	9	0.18	0.43	150	220	4	0.3	180	
		16		250 HB	0.5	9	0.18	0.43	150	190	4	0.3	160	
	Malleable & Nodular	8	17, 19	GG20, GG70,	150 HB	0.5	9	0.15	0.38	100	200	4	0.26	180
		17, 19	50005	200 HB	0.5	9	0.15	0.38	100	180	4	0.26	150	
		18, 20		250 HB	0.5	9	0.15	0.38	100	150	4	0.26	130	
H	Steel	11	38	X100 CrMo13,	45 HRC	0.5	3.2	0.1	0.24	40	80	2	0.18	60
		38	440C,	50 HRC	0.5	2.3	0.1	0.22	40	70	1.5	0.17	55	
		38	G-X260NiCr42	55 HRC	0.5	1.9	0.1	0.19	40	60	1	0.16	50	
	Chilled Cast Iron	12	40	Ni-Hard 2	400 HB	0.5	2.6	0.1	0.24	40	80	1.5	0.18	50
	White Cast Iron	13	41	G-X300CrMo15	55 HRC	0.5	1.9	0.1	0.19	30	60	1	0.16	40

