

MACHINING CONDITIONS - MILLING - DEPTH OF CUT AND FEED

SPKN 1203 EDTR

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Material Group	Lamina Gr. N°	Material Examples	Hardness	DOC [mm]		Feed [mm/z]		Suggested Starting Parameters		
				min	max	min	max	DOC	Feed	
P	Non Alloyed	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.50	7.00	0.18	0.43	3.00	0.30	
			190 HB							
			250 HB							
	Low Alloyed	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.50	7.00	0.15	0.34	3.00	0.26	
			230 HB				0.30		0.23	
			280 HB							
			350 HB							
	High Alloyed	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.50	5.00	0.12	0.30	2.30	0.23	
			280 HB				0.24		0.21	
			320 HB							
			350 HB							
K	Grey	GG20, GG40, EN-GJL-250, N030B	150 HB	0.50	7.00	0.18	0.43	3.00	0.30	
			200 HB							
			250 HB							
	Malleable & Nodular	GGG40, GGG70, 50005	150 HB	0.50	7.00	0.15	0.38	3.00	0.26	
			200 HB							
			250 HB							
H	Steel	X100 CrMo13, 440C, G-X260NiCr42	45 HRc	0.50	2.50	0.10	0.24	1.50	0.18	
			50 HRc		1.80		0.22	1.10	0.17	
			55 HRc		1.50		0.19	0.80	0.16	
		Chilled Cast Iron	Ni-Hard 2		400 HB		2.00	0.24	1.10	0.18
			White Cast Iron		G-X300CrMo15		55 HRc	1.50	0.19	0.80

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Material Group	Lamina Gr. N°	Material Examples	Hardness	DOC [mm]		Feed [mm/z]		Suggested Starting Parameters			
				min	max	min	max	DOC	Feed		
P	Non Alloyed	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.50	9.00	0.18	0.43	4.00	0.30		
			190 HB								
			250 HB								
	Low Alloyed	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.50	9.00	0.15	0.34	4.00	0.26		
			230 HB				0.30		0.23		
			280 HB								
			350 HB								
	High Alloyed	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.50	6.40	0.12	0.30	3.00	0.23		
			280 HB				0.24		0.21		
			320 HB								
			350 HB								
K	Grey	GG20, GG40, EN-GJL-250, N030B	150 HB	0.50	9.00	0.18	0.43	4.00	0.30		
			200 HB								
			250 HB								
	Malleable & Nodular	GGG40, GGG70, 50005	150 HB	0.50	9.00	0.15	0.38	4.00	0.26		
			200 HB								
			250 HB								
H	Steel	X100 CrMo13, 440C, G-X260NiCr42	45 HRc	0.50	3.20	0.10	0.24	2.00	0.18		
			50 HRc		2.30		0.22	1.50	0.17		
			55 HRc		1.90		0.19	1.00	0.16		
			Ni-Hard 2		400 HB		2.60	0.24	1.50	0.18	
					G-X300CrMo15		55 HRc	1.90	0.19	1.00	0.16
		Chilled Cast Iron	G-X300CrMo15		55 HRc		1.90		0.24	1.50	0.18
		White Cast Iron							0.19	1.00	0.16

The depth of cut and feed rate tables are for the geometry and corner radius specified above the table. Refer to cutting speed tables on page 226 for recommended materials per grade.