TPKN 1603 PDTR

	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	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.50	12.00	0.14	0.27	3.00	0.19
				190 HB						
				250 HB						
	Low Alloyed	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.50	12.00	0.12	0.21	3.00	0.17
				230 HB						
				280 HB				0.19		0.15
				350 HB						
	High Alloyed	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.50	8.60	0.10	0.19	2.30	0.15
				280 HB						
				320 HB				0.15		0.14
				350 HB						
K	Grey	7	GG20, GG40, EN-GJL-250, N030B	150 HB	0.50	12.00	0.14	0.27	3.00	0.19
				200 HB						
				250 HB						
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.50	12.00	0.12	0.24	3.00	0.17
				200 HB						
				250 HB						
H	Steel	11	X100 CrMo13, 440C, G-X260NiCr42	45 HRc	0.50	4.30	0.08	0.15	1.50	0.12
				50 HRc		3.00		0.14	1.10	0.11
				55 HRc		2.60		0.12	0.80	0.10
	Chilled Cast Iron		Ni-Hard 2	400 HB		3.40		0.15	1.10	0.12
	White Cast Iron		G-X300CrMo15	55 HRc		2.60		0.12	0.80	0.10

TPKN 2204 PDTR

	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	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.50	18.00	0.16	0.27	4.00	0.19
				190 HB						
				250 HB						
	Low Alloyed	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.50	18.00	0.14	0.21	4.00	0.17
				230 HB						
				280 HB				0.19		0.15
				350 HB						
	High Alloyed	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.50	12.90	0.11	0.19	3.00	0.15
				280 HB						
				320 HB				0.15		0.13
				350 HB						
K	Grey	7	GG20, GG40, EN-GJL-250, N030B	150 HB	0.50	18.00	0.16	0.27	4.00	0.19
				200 HB						
				250 HB						
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.50	18.00	0.14	0.24	4.00	0.17
				200 HB						
				250 HB						
H	Steel	11	X100 CrMo13, 440C, G-X260NiCr42	45 HRc	0.50	6.40	0.09	0.15	2.00	0.12
				50 HRc		4.50		0.14	1.50	0.11
				55 HRc		3.90		0.12	1.00	0.10
	Chilled Cast Iron		Ni-Hard 2	400 HB		5.10		0.15	1.50	0.12
	White Cast Iron		G-X300CrMo15	55 HRc		3.90		0.12	1.00	0.10

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.