

CCMT 120404 NN LT 10 & LT 1000

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [mm]		Feed [mm/rev]		Amax [mm ²]	V _c [m/min]		Optimal cutting conditions								
					min	max	min	max		min	max	D.O.C.	Feed	V _c						
Steel	Non-alloyed	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.2	3.0	0.11	0.23	0.60	180	330	2.0	0.18	300						
		190 HB		2.5										0.22	0.52	280	260			
		250 HB		2.5										0.20	0.48	250	240			
	Low alloyed	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.2	2.5	0.10	0.20	0.50	120	280	2.0	0.15	260						
		230 HB		2.5										0.20	0.48	250	240			
		280 HB		2.0										0.18	0.40	210	200			
		350 HB		2.0										0.18	0.36	180	180			
	High alloyed	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.2	2.5	0.09	0.16	0.40	70	190	2.0	0.12	180						
		280 HB		2.5										0.16	0.40	150	140			
		320 HB		2.0										0.14	0.32	130	120			
		350 HB		2.0										0.14	0.26	110	110			
Stainless Steel	Austenitic	4	304, 316, X5CrNi18-9	180 HB	0.2	2.5	0.10	0.18	0.32	170	270	2.0	0.12	260						
		240 HB		2.5										0.18	0.26	160	220	210		
	Duplex	5	X2CrNiN23-4, S31500	290 HB	0.2	2.0	0.09	0.14	0.20	80	150	2.0	0.12	140						
		310 HB		2.0										0.14	0.20	70	140	140		
	Ferritic & Martensitic	6	410, X6Cr17, 17-4 PH, 430	200 HB	0.2	2.5	0.10	0.18	0.32	170	250	2.0	0.15	240						
		42 HRc		2.0										0.16	0.26	120	190	180		
Cast Iron	Grey	7	GG20, GG40, EN-GJL-250, No30B	150 HB	0.2	3.0	0.08	0.20	0.64	170	250	2.0	0.18	240						
		200 HB		3.0										0.20	0.60	160	230	220		
		250 HB		3.0										0.20	0.60	150	210	200		
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.2	2.5	0.08	0.18	0.48	120	250	2.0	0.15	240						
		200 HB		2.5										0.18	0.40	230	220			
250 HB	2.5	0.18	0.40	190	180															
High Temp. Alloys	Fe, Ni & Co based	9	Incoloy 800, Inconel 700, Stellite 21	240 HB	0.2	2.0	0.09	0.15	0.26	25	50	2.0	0.12	40						
		250 HB		2.0										0.15	0.26	25	50	40		
		350 HB		2.0										0.15	0.26	23	45	35		
	Ti based	10	TiAl6V4, T40	-	0.2	2.0	0.09	0.16	0.32	45	65	2.0	0.15	60						
-		2.0		0.14										0.26	35	60	50			
Hardened Mat.	Steel	11	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.2	1.8	0.05	0.12	0.20	50	100	1.5	0.11	90						
		50 HRc		1.5										0.10	0.17	40	90	1.2	0.09	80
		55 HRc		1.4										0.09	0.13	40	80	1.0	0.07	70
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.2	1.6	0.05	0.12	0.17	40	60	1.2	0.11	50						
		55 HRc		1.4										0.09	0.13	30	50	1.0	0.07	40
White Cast Iron	41	G-X300CrMo15	55 HRc	0.2	1.4	0.05	0.09	0.13	30	50	1.0	0.07	40							
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.2	4.0	0.10	0.30	0.70	200	400	2.0	0.20	350					