

# VBMT 160408 NN LT 10 & LT 1000

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [mm]		Feed [mm/rev]		Amax [mm <sup>2</sup> ]	V <sub>c</sub> [m/min]		Optimal cutting conditions						
					min	max	min	max		min	max	D.O.C.	Feed	V <sub>c</sub>				
Steel	Non-alloyed	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.5	3.5	0.19	0.40	1.26	180	330	2.5	0.30	240				
				190 HB				0.40	1.26					220				
				250 HB				0.36	1.05					200				
	Low alloyed	2	42CrMo4, S150, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	3.5	0.19	0.36	0.84	120	280	2.5	0.27	200				
				230 HB				0.36	0.84					180				
				280 HB				0.28	0.16					0.32	0.84	210	0.26	150
				350 HB				0.25	0.16					0.32	0.70	180	0.26	130
	High alloyed	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	2.8	0.16	0.32	0.84	70	190	2.1	0.26	140				
				280 HB				0.32	0.84					150				
				320 HB				0.28	0.56					130	0.24	100		
				350 HB				0.28	0.56					110	0.24	90		
Stainless Steel	Austenitic	4	304, 316, X5CrNi18-9	180 HB	0.5	3.5	0.18	0.32	0.84	170	270	2.5	0.30	190				
				240 HB				0.32	0.70					160	220	0.27	170	
	Duplex	5	X2CrNiN23-4, S31500	290 HB	0.5	2.8	0.16	0.28	0.56	80	150	2.1	0.24	100				
				310 HB				0.28	0.56					70	140	90		
	Ferritic & Martensitic	6	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	3.5	0.20	0.32	0.70	170	250	2.5	0.27	190				
				42 HRC				0.32	0.70					120	190	130		
Cast Iron	Grey	7	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	3.5	0.14	0.48	1.40	170	250	2.5	0.30	200				
				200 HB				0.48	1.26					160	230	180		
				250 HB				0.44	1.26					150	210	160		
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.5	3.5	0.14	0.40	1.05	120	230	2.5	0.26	160				
				200 HB				0.40	0.91					190	140			
High Temp. Alloys	Fe, Ni & Co based	9	Incoloy 800, Inconel 700, Stellite 21	240 HB	0.5	2.1	0.18	0.28		25	45	2.0	0.24	32				
				250 HB				0.28	0.49					25	45	30		
				350 HB				0.28						23	40	28		
	Ti based	10	TiAl6V4, T40	-	0.5	2.8	0.18	0.32	0.56	45	65	2.0	0.28	55				
				-				0.28	0.49					35	55	45		
Hardened Mat.	Steel	11	X100CrMo13, 440C, G-X260NiCr42	45 HRC	0.5	1.8	0.10	0.24	0.42	50	100	1.6	0.21	80				
				50 HRC				0.20	0.28					40	90	70		
				55 HRC				0.16	0.21					40	80	60		
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.5	1.4	0.10	0.20	0.28	40	60	1.2	0.15	50				
	White Cast Iron	41	G-X300CrMo15	55 HRC	0.5	1.1	0.10	0.16	0.21	30	50	1.0	0.13	40				
NF	Al (>8%Si)	12	AISI12	130 HB	0.5	4.2	0.18	0.48	1.40	200	400	2.5	0.34	280				