

## ADKT 1505 PDTR LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [mm]		Feed [mm/tooth]		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	14.0	0.18	0.32	190	330	4.0	0.23	250		
		2		14.0		0.32		300		220					
		3		14.0		0.32		250		200					
	Low alloyed	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	14.0	0.15	0.25	150	240	4.0	0.20	0.20	200	
				230 HB				0.25		150				210	180
				280 HB				0.22		130				190	150
				350 HB				0.22		130				170	140
	High alloyed	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	10.0	0.12	0.22	90	150	3.0	0.18	0.18	130	
				280 HB				0.22		90				130	120
				320 HB				0.18		60				110	100
				350 HB				0.18		60				90	80
Stainless Steel	Austenitic	4	304, 316, X5CrNi18-9	180 HB	0.5	14.0	0.15	0.25	190	250	4.0	0.20	220		
				240 HB				0.22		160			210	190	
	Duplex	5	X2CrNiN23-4, S31500	290 HB	0.5	10.0	0.12	0.18	70	130	3.0	0.16	100		
				310 HB				0.18		120			90		
	Ferritic & Martensitic	6	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	14.0	0.15	0.25	150	210	4.0	0.20	0.20	190	
				42 HRC				0.20		90				150	130
Cast Iron	Grey	7	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	14.0	0.18	0.32	150	240	4.0	0.23	200		
				200 HB				0.32		220			180		
				250 HB				0.32		190			160		
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.5	14.0	0.15	0.28	100	200	4.0	0.20	0.20	180	
				200 HB				0.28		180				150	
				250 HB				0.28		150				130	
High Temp. Alloys	Fe, Ni & Co based	9	Incoloy 800, Inconel 700, Stellite 21	240 HB	0.5	10.0	0.12	0.18	25	45	3.0	0.16	32		
				250 HB				0.18		45			30		
				350 HB				0.18		45			30		
	Ti based	10	TiAl6V4, T40	-	0.5	10.0	0.12	0.20	40	65	3.0	0.18	55		
				-				0.18		30			55	40	
Hardened Mat.	Steel	11	X100CrMo13, 440C, G-X260NiCr42	45 HRC	0.5	5.0	0.10	0.18	40	80	2.0	0.14	60		
				50 HRC				0.16		70			55		
				55 HRC				0.14		60			50		
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.5	4.0	0.10	0.18	40	80	1.5	0.14	50		
	White Cast Iron	41	G-X300CrMo15	55 HRC	0.5	1.5	0.10	0.14	30	60	1.0	0.12	40		
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	14.0	0.18	0.32	200	400	4.0	0.25	280	