

## SNKX 09T3-HF 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	0.1	1.0	0.27	2.10	190	330	0.6	1.10	250			
				190 HB		1.0		1.95		300			220			
				250 HB		1.0		1.50		250			200			
	Low alloyed	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.1	1.0	0.25	1.95	150	240	0.5	1.00	200			
				230 HB		1.0		1.70		150			180			
				280 HB		1.0		0.23		1.60			130	190	0.90	150
				350 HB		1.0		0.23		1.50			130	170	0.90	140
	High alloyed	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.1	1.0	0.20	1.70	90	150	0.5	0.90	130			
				280 HB		1.0		1.60		90			130	0.5	0.90	120
				320 HB		0.8		1.50		60			110	0.4	0.80	100
				350 HB		0.8		1.40		60			90	0.4	0.80	80
Cast Iron	Grey	7	GG20, GG40, EN-GJL-250, No30B	150 HB	0.1	1.0	0.20	2.40	150	240	0.6	1.10	200			
				200 HB		1.0		2.40		220			180			
				250 HB		1.0		2.40		190			160			
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.1	1.0	0.20	1.80	100	200	0.5	1.00	180			
				200 HB		1.0		1.80		180			150			
				250 HB		1.0		1.80		150			130			
Hardened Mat.	Steel	11	X100CrMo13, 440C, G-X260NiCr42	45 HRC	0.1	0.6	0.16	1.10	40	80	0.4	0.70	60			
				50 HRC		0.5		1.00		70			0.3	0.65	55	
				55 HRC		0.4		0.90		60			0.3	0.60	50	
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.1	0.6	0.16	1.10	40	80	0.4	0.70	50			
	White Cast Iron	41	G-X300CrMo15	55 HRC	0.1	0.4	0.16	0.90	30	60	0.3	0.60	40			