

SPKN 1203 EDTR LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [mm]		Feed [mm/tooth]		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	0.5	7.0	0.18	0.43	190	330	3.0	0.30	250
		190 HB		220									
		250 HB		200									
	Low alloyed	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	7.0	0.15	0.34	150	240	3.0	0.26	200
				230 HB									180
				280 HB									150
				350 HB									140
	High alloyed	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	5.0	0.12	0.30	90	150	2.3	0.23	130
				280 HB									120
				320 HB									100
				350 HB									80
Cast Iron	Grey	7	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	7.0	0.18	0.43	150	240	3.0	0.30	200
				200 HB									180
				250 HB									160
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.5	7.0	0.15	0.38	100	200	3.0	0.26	180
				200 HB									150
				250 HB									130
Hardened Mat.	Steel	11	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	2.5	0.10	0.24	40	80	1.5	0.18	60
				50 HRc									55
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	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.5	2.0	0.10	0.24	40	80	1.1	0.18	50
	White Cast Iron	41	G-X300CrMo15	55 HRc	0.5	1.5	0.10	0.19	30	60	0.8	0.16	40