

SPKN 1204 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	
		2		190 HB		7.0		0.43		300			220	
		3		250 HB		7.0		0.43		250			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		7.0		0.34		150			210	180
				280 HB		7.0		0.30		130			190	150
				350 HB		7.0		0.30		130			170	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		5.0		0.30		90			130	120
				320 HB		5.0		0.24		60			110	100
				350 HB		5.0		0.24		60			90	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		7.0		0.43		220			180	
				250 HB		7.0		0.43		190			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		7.0		0.38		180			150	
				250 HB		7.0		0.38		150			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		1.8		0.22		70			55	
				55 HRc		1.5		0.19		60			50	
	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	