

SPUN 120308 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	0.37	190	330	3.0	0.26	250	
				190 HB									300	220
				250 HB									250	200
	Low alloyed	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	7.0	0.15	0.29	150	240	3.0	0.23	200	
				230 HB									150	180
				280 HB									130	150
				350 HB									130	140
	High alloyed	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	5.0	0.12	0.25	90	150	2.3	0.21	130	
				280 HB									90	120
				320 HB									60	100
				350 HB									60	80
Cast Iron	Grey	7	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	7.0	0.18	0.37	150	240	3.0	0.26	200	
				200 HB									220	180
				250 HB									190	160
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.5	7.0	0.15	0.32	100	200	3.0	0.23	180	
				200 HB									180	150
				250 HB									150	130
Hardened Mat.	Steel	11	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	2.5	0.10	0.21	40	80	1.5	0.16	60	
				50 HRc									70	55
				55 HRc									60	50
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.5	2.0	0.10	0.21	40	80	1.1	0.16	50	
	White Cast Iron	41	G-X300CrMo15	55 HRc	0.5	1.5	0.10	0.16	30	60	0.8	0.14	40	