

APKT 100332 PDTR 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	9.0	0.13	0.28	190	330	1.0	0.29	250	
		2		190 HB		9.0		0.28		300			220	
		3		250 HB		9.0		0.28		250			200	
	Low alloyed	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	9.0	0.11	0.22	150	240	1.0	0.25	200	
		4,6		230 HB		9.0		0.22		150			210	180
		5,7		280 HB		9.0		0.19		130			190	150
		8		350 HB		9.0		0.19		130			170	140
	High alloyed	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	6.4	0.08	0.19	90	150	1.0	0.22	130	
		10		280 HB		6.4		0.19		90			130	120
		11		320 HB		6.4		0.16		60			110	100
		11		350 HB		6.4		0.16		60			90	80
Stainless Steel	Austenitic	4	304, 316, X5CrNi18-9	180 HB	0.5	9.0	0.11	0.22	190	250	1.0	0.25	220	
		14		240 HB		9.0		0.08		0.19			160	210
	Duplex	5	X2CrNiN23-4, S31500	290 HB	0.5	6.4	0.08	0.16	70	130	1.0	0.20	100	
		14		310 HB		6.4		0.16		120			90	
	Ferritic & Martensitic	6	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	9.0	0.11	0.22	150	210	1.0	0.25	190	
		13		42 HRC		6.4		0.18		90			150	130
Cast Iron	Grey	7	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	9.0	0.13	0.28	150	240	1.0	0.29	200	
		15		200 HB		9.0		0.28		220			180	
		16		250 HB		9.0		0.28		190			160	
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.5	9.0	0.11	0.25	100	200	1.0	0.25	180	
		17,19		200 HB		9.0		0.25		180			150	
		18,20		250 HB		9.0		0.25		150			130	
High Temp. Alloys	Fe, Ni & Co based	9	Incoloy 800, Inconel 700, Stellite 21	240 HB	0.5	6.4	0.08	0.16	25	45	1.0	0.20	32	
		33		250 HB		6.4		0.16		45			30	
		34		350 HB		6.4		0.16		45			30	
	Ti based	10	TiAl6V4, T40	-	0.5	6.4	0.08	0.18	40	65	1.0	0.22	55	
		37		-		6.4		0.16		30			55	40
Hardened Mat.	Steel	11	X100CrMo13, 440C, G-X260NiCr42	45 HRC	0.4	3.2	0.07	0.16	40	80	0.7	0.17	60	
		38		50 HRC		1.9		0.14		60			55	
		38		55 HRC		1.0		0.12		60			50	
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.4	2.6	0.07	0.16	40	80	0.7	0.17	50	
	White Cast Iron	41	G-X300CrMo15	55 HRC	0.4	1.0	0.07	0.12	30	60	0.7	0.15	40	
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	9.0	0.13	0.28	200	400	1.0	0.31	280