

SNKX 1204-90° 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	1 C35, Ck45, 1020,	125 HB	0.5	3.0	0.08	0.25	190	330	2.0	0.14	250
			2 1045, 1060,	190 HB		3.0		0.25		300			220
			3 28Mn6	250 HB		3.0		0.25		250			200
	Low alloyed	2	6 42CrMo4, St50,	180 HB	0.5	3.0	0.08	0.22	150	240	2.0	0.12	200
			4,6 Ck60, 4140, 4340,	230 HB		3.0		0.22	150	210			180
			5,7 100Cr6	280 HB		3.0		0.18	130	190			150
			8	350 HB		3.0		0.18	130	170			140
	High alloyed	3	10 X40CrMoV5,	220 HB	0.5	3.0	0.08	0.18	90	150	2.0	0.10	130
			10 H13, M42, D3,	280 HB		3.0		0.18	90	130			120
			11 S6-5-2, 12Ni19	320 HB		3.0		0.16	60	110			100
			11	350 HB		3.0		0.16	60	90			80
Cast Iron	Grey	7	15 GG20, GG40,	150 HB	0.5	3.0	0.08	0.28	150	240	2.0	0.14	200
			15 EN-GJL-250,	200 HB		3.0		0.28		220			180
			16 No30B	250 HB		3.0		0.25		190			160
	Malleable & Nodular	8	17,19 GG640, GG670,	150 HB	0.5	3.0	0.08	0.25	100	200	2.0	0.12	180
			17,19 50005	200 HB		3.0		0.25		180			150
			18,20	250 HB		3.0		0.25		150			130
Hardened Mat.	Steel	11	38 X100CrMo13,	45 HRc	0.5	2.3	0.08	0.15	40	80	1.6	0.08	60
			38 440C,	50 HRc		2.3		0.14		70	1.4		55
			38 G-X260NiCr42	55 HRc		1.5		0.13		60	1.2		50
	Chilled Cast Iron		40 Ni-Hard 2	400 HB	0.5	2.3	0.08	0.15	40	80	1.6	0.08	50
	White Cast Iron		41 G-X300CrMo15	55 HRc	0.5	1.5	0.08	0.13	30	60	1.2	0.08	40