

Cutting Conditions

SEKN 1203 AFTN SEKN 1204 AFTN

Material Group	Group No	Material Examples*	Brinell hardness	d.o.c [mm]		feed [mm/tooth]		V _c [m/min]				
				min	max	min	max	min	max			
Low Carbon Steel	1	Ck 15 9SMnPb28	150	0.50	7.00	0.15	0.32	190	350			
			180						300			
			210						260			
Alloy Steel	2	42 CrMo 4 100 Cr 6 32 NiCrMo 14.5	180	0.50	7.00	0.15	0.30	150	240			
			230						210			
			280					130	190			
			320						170			
High Alloy Steel	3	X38 CrMoV 5 X210 CrW 12 X90 CrMoV 8	220	0.50	7.00	0.12	0.25	90	150			
			280						130			
			320					60	110			
			350						90			
Austenitic Stainless Steel	4	303 / 304 304 L	210 to 250	0.50	5.00	0.12	0.32	170	250			
	5	316 / 316 L	230 to 270						0.12	0.28	170	210
	6	316 Ti 630 (F16PH)	-----									
Ferritic Stainless Steel	7	430 / 439 / 444	Annealed	0.50	7.00	0.12	0.32	150	210			
Martensitic Stainless Steel	8	410 / 420	Annealed	0.50	7.00	0.12	0.32	150	230			
			Treated					90	170			
Grey Cast Iron	9	EN - GJL 200	140 to 230	0.50	7.00	0.15	0.40	170	300			
		EN - GJL 250							250			
		EN - GJL 300							210			
Nodular Cast Iron	10	EN - GJS 400	210	0.50	7.00	0.12	0.32	120	210			
		EN - GJS 600	260						170			
		EN - GJS 800	310						150			
Nickel Based Alloys	11	Inconel 625	-----	0.50	5.00	0.12	0.28	25	35			
		Inconel 718							40			
		Hastelloy C							65			
Titanium Based Alloys	12	TiAl 6 V4	-----	0.50	5.00	0.12	0.28	35	60			
		T40						28	40			

*For all material types and standards, see pages 155 to 158.