

Cutting Conditions

SPKN 1203 EDTR SPKN 1204 EDTR

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	0.38	190	350	
			180						260	
			210						220	
Alloy Steel	2	42 CrMo 4 100 Cr 6 32 NiCrMo 14.5	180	0.50	7.00	0.15	0.32	130	200	
			230						180	
			280						100	160
			320							140
High Alloy Steel	3	X38 CrMoV 5 X210 CrW 12 X90 CrMoV 8	220	0.50	7.00	0.12	0.28	90	130	
			280						110	
			320						60	95
			350							80
Austenitic Stainless Steel	4	303 / 304 304 L	210 to 250	Not recommended, please use SPKR.						
	5	316 / 316 L	230 to 270							
	6	316 Ti 630 (F16PH)	-----							
Ferritic Stainless Steel	7	430 / 439 / 444	Annealed	Not recommended, please use SPKR.						
Martensitic Stainless Steel	8	410 / 420	Annealed Treated	Not recommended, please use SPKR.						
Grey Cast Iron	9	EN - GJL 200	140 to 230	0.50	7.00	0.15	0.40	150	240	
		EN - GJL 250							220	
		EN - GJL 300							190	
Nodular Cast Iron	10	EN - GJS 400	210	0.50	7.00	0.12	0.32	100	200	
		EN - GJS 600	260						160	
		EN - GJS 800	310						130	
Nickel Based Alloys	11	Inconel 625	-----	Not recommended for exotic materials.						
		Inconel 718								
		Hastelloy C								
Titanium Based Alloys	12	TiAl 6 V4	-----	Not recommended for exotic materials.						
		T40								

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