

## TPKN 2204 PDTR

| Material Group              | Group No | Material Examples*                        | Brinell hardness    | d.o.c [mm]   |       | feed [mm/tooth] |      | V <sub>c</sub> [m/min] |      |
|-----------------------------|----------|---|---------------------|--|-------|-----------------|------|------------------------|------|
|                             |          |   |                     | min  | max   | min             | max  | min                    | max  |
| Low Carbon Steel            | 1        | XC12<br>S 250 Pb                          | 150                 | 0.50   | 18.00 | 0.18            | 0.25 | 190                    | 300  |
|                             |          |   | 180                 |  |       |                 |      |                        | 260  |
|                             |          |   | 210                 |  |       |                 |      |                        | 220  |
| Alloy Steel                 | 2        | 42 CrMo 4<br>100 Cr 6<br>32 NiCrMo 14.5   | 180                 | 0.50   | 18.00 | 0.15            | 0.22 | 130                    | 200  |
|                             |          |   | 230                 |  |       |                 |      |                        | 180  |
|                             |          |   | 280                 |  | 14.00 |                 |      | 100                    | 160  |
|                             |          |   | 320                 |  |       |                 |      |                        | 140  |
| High Alloy Steel            | 3        | X38 CrMoV 5<br>X210 CrW 12<br>X90 CrMoV 8 | 220                 | 0.50   | 12.00 | 0.12            | 0.18 | 90                     | 130  |
|                             |          |   | 280                 |  |       |                 |      |                        | 110  |
|                             |          |   | 320                 |  |       |                 |      | 90                     | 95   |
|                             |          |   | 350                 |  |       |                 |      |                        | 80   |
| Austenitic Stainless Steel  | 4        | 303 / 304<br>304 L                        | Annealed            | TPKN inserts are not recommended for stainless steel.  |       |                 |      |                        |      |
|                             | 5        | 316 / 316 L                               | Annealed            |  |       |                 |      |                        |      |
|                             | 6        | 316 Ti<br>630 (F16PH)                     | Annealed            |  |       |                 |      |                        |      |
| Ferritic Stainless Steel    | 7        | 430 / 439 / 444                           | Annealed            | TPKN inserts are not recommended for stainless steel.  |       |                 |      |                        |      |
| Martensitic Stainless Steel | 8        | 410 / 420                                 | Annealed<br>Treated | TPKN inserts are not recommended for stainless steel.  |       |                 |      |                        |      |
| Grey Cast Iron              | 9        | EN - GJL 200                              | 140<br>to 230       | 0.50   | 18.00 | 0.18            | 0.22 | 150                    | 240  |
|                             |          | EN - GJL 250                              |                     |  |       |                 |      |                        | 220  |
|                             |          | EN - GJL 300                              |                     |  |       |                 |      |                        | 190  |
| Nodular Cast Iron           | 10       | EN - GJS 400                              | 210                 | 0.50   | 14.00 | 0.15            | 0.28 | 100                    | 200  |
|                             |          | EN - GJS 600                              |                     |  |       |                 |      |                        | 0.22 |
|                             |          | EN - GJS 800                              |                     |  |       |                 | 0.20 |                        | 130  |
| Nickel Based Alloys         | 11       | Inconel 625                               | -----               | TPKN inserts are not recommended for exotic materials. |       |                 |      |                        |      |
|                             |          | Inconel 718                               |                     |  |       |                 |      |                        |      |
|                             |          | Hastelloy C                               |                     |  |       |                 |      |                        |      |
| Titanium Based Alloys       | 12       | TiAl 6 V4                                 | -----               | TPKN inserts are not recommended for exotic materials. |       |                 |      |                        |      |
|                             |          | T40                                       |                     |  |       |                 |      |                        |      |

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

