TPKR 1603 PDTR

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	150 180 210	0.50	12.00	0.15	0.22	190	300 260 220
Alloy Steel	2	42 CrMo 4 100 Cr 6 32 NiCrMo 14.5	180 230 280 320	0.50	12.00	0.15	0.18	130 100	200 180 160 140
High Alloy Steel	3	X38 CrMoV 5 X210 CrW 12 X90 CrMoV 8	220 280 320 350	TPKR inserts are not recommended for high resistance steels.					
Austenitic Stainless Steel	4	303 / 304 304 L	210 to 250	0.50	12.00	0.12	0.20	170	230
	5	316 / 316 L	230 to 270	0.50	5.00	0.12	0.18	170	210
	6	316 Ti 630 (F16PH)	--------	TPKR inserts are not recommended for stainless steels with high mechanical proprieties					
Ferritic Stainless Steel	7	430 / 439 / 444	Annealed	0.50	5.00	0.12	0.25	150	190
Martensitic Stainless Steel	8	410 / 420	Annealed Treated	0.50	5.00	0.12	0.25	130 90	210 150
Grey Cast Iron	9	EN - GJL 200 EN - GJL 250 EN - GJL 300	140 to 230	0.50	7.00	0.15	0.40	150	240 220 190
Nodular Cast Iron	10	EN - GJS 400 EN - GJS 600 EN - GJS 800	210 260 310	0.5	7.00	0.12	0.32	100	200 160 130
Nickel Based Alloys	11	Inconel 625 Inconel 718 Hastelloy C	--------	TPKR inserts are not recommended for exotic materials.					
Titanium Based Alloys	12	TiAl 6 V4 T40	--------	TPKR inserts are not recommended for exotic materials.					

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