

SDKX 0904-HF LT 3130

M0004484

Material Group	SAPPHIRE CUTTING TOOLS Group	Material Example	Hardness	D.O.C		Feed		Vc		Advised D.O.C [mm]	Advised Feed [mm/t]	Advised Vc [m/min]	
				min[mm]	max[mm]	min[mm/t]	max [mm/t]	min [m/min]	max [m/min]				
Steel	Non Alloyed	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.3	1.5	0.3	1.5	190	350	1	1.2	265	
			190 HB	0.3	1.5	0.3	1.5	190	320	1	1.2	240	
			250 HB	0.3	1.5	0.3	1.5	190	280	1	1.2	215	
	Low Alloyed	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	230 HB	0.3	1.2	0.3	1.36	150	230	0.8	1	200
				280 HB	0.3	1.2	0.3	1.36	130	210	0.8	0.9	165
				180 HB	0.3	1.2	0.3	1.36	150	270	0.8	1	215
				350 HB	0.3	1.2	0.3	1.36	130	190	0.8	0.9	155
	High Alloyed	3	X40CrM0V5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.3	1.2	0.3	1.2	90	170	0.7	0.8	140
				280 HB	0.3	1.1	0.3	1.2	90	150	0.7	0.8	130
				320 HB	0.3	1	0.3	1.2	60	120	0.7	0.7	110
				350 HB	0.3	1	0.3	1.2	60	100	0.7	0.7	90
	Stainless Steel	Austenitic	4	304, 316, X5CrNi18-9	180 HB	0.3	1.3	0.3	0.76	190	260	0.8	0.5
240 HB					0.3	1.3	0.3	0.76	160	220	0.8	0.5	200
Duplex		5	X2CrNiN23-4, S31500	290 HB	0.3	1.1	0.3	0.46	70	140	0.7	0.3	110
				310 HB	0.3	1.1	0.3	0.46	70	130	0.7	0.3	100
Ferritic & Martensitic		6	410, X6Cr17, 17-4 PH, 430	200 HB	0.3	1.2	0.3	0.52	150	220	0.8	0.4	200
				42 HRc	0.3	1	0.3	0.46	90	160	0.7	0.3	140