SEKT 12T3 AGSN
SEKT 1204 AFTN

Cutting Conditions

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	0.5	6.0	0.18	0.48	190	350
			180		6.0		0.48		300
			210		6.0		0.48		260
Alloy Steel	2	42 CrMo 4 100 Cr 6 32 NiCrMo 14.5	180	0.5	6.0	0.15	0.45	150	240
			230		6.0		0.45		210
			280	0.5	6.0	0.15	0.40	130	190
			320		6.0		0.40		170
High Alloy Steel	3	X38 CrMoV 5 X210 CrW 12 X90 CrMoV 8	220	0.5	5.0	0.12	0.42	90	150
			280		5.0		0.42		130
			320	0.5	5.0	0.12	0.38	60	110
			350		5.0		0.38		90
Austenitic Stainless Steel	4	303 / 304 304 L	210 to 250	0.5	6.0	0.18	0.35	170	250
	5	316 / 316 L	230 to 270	0.5	5.0	0.15	0.32	160	210
	6	316 Ti 630 (F16PH)	--------	0.5	4.0	0.12	0.28	70	150
Ferritic Stainless Steel	7	430 / 439 / 444	Annealed	0.5	6.0	0.18	0.35	150	210
Martensitic Stainless Steel	8	410 / 420	Annealed	0.5	6.0	0.15	0.35	150	230
			Treated	0.5	6.0	0.15	0.28	90	170
Grey Cast Iron	9	EN - GJL 200	140 to 230	0.5	6.0	0.18	0.48	170	300
		EN - GJL 250							250
		EN - GJL 300							210
Nodular Cast Iron	10	EN - GJS 400	210	0.5	6.0	0.15	0.42	120	210
		EN - GJS 600	260						170
		EN - GJS 800	310						150
Nickel Based Alloys	11	Inconel 625	--------	0.5	4.0	0.15	0.28	25	35
		Inconel 718						28	40
		Hastelloy C						40	60
Titanium Based Alloys	12	TiAl 6 V4	--------	0.5	4.0	0.18	0.32	35	60
		T40					0.28	28	40

*For all material types and standards, see pages 240 to 245.