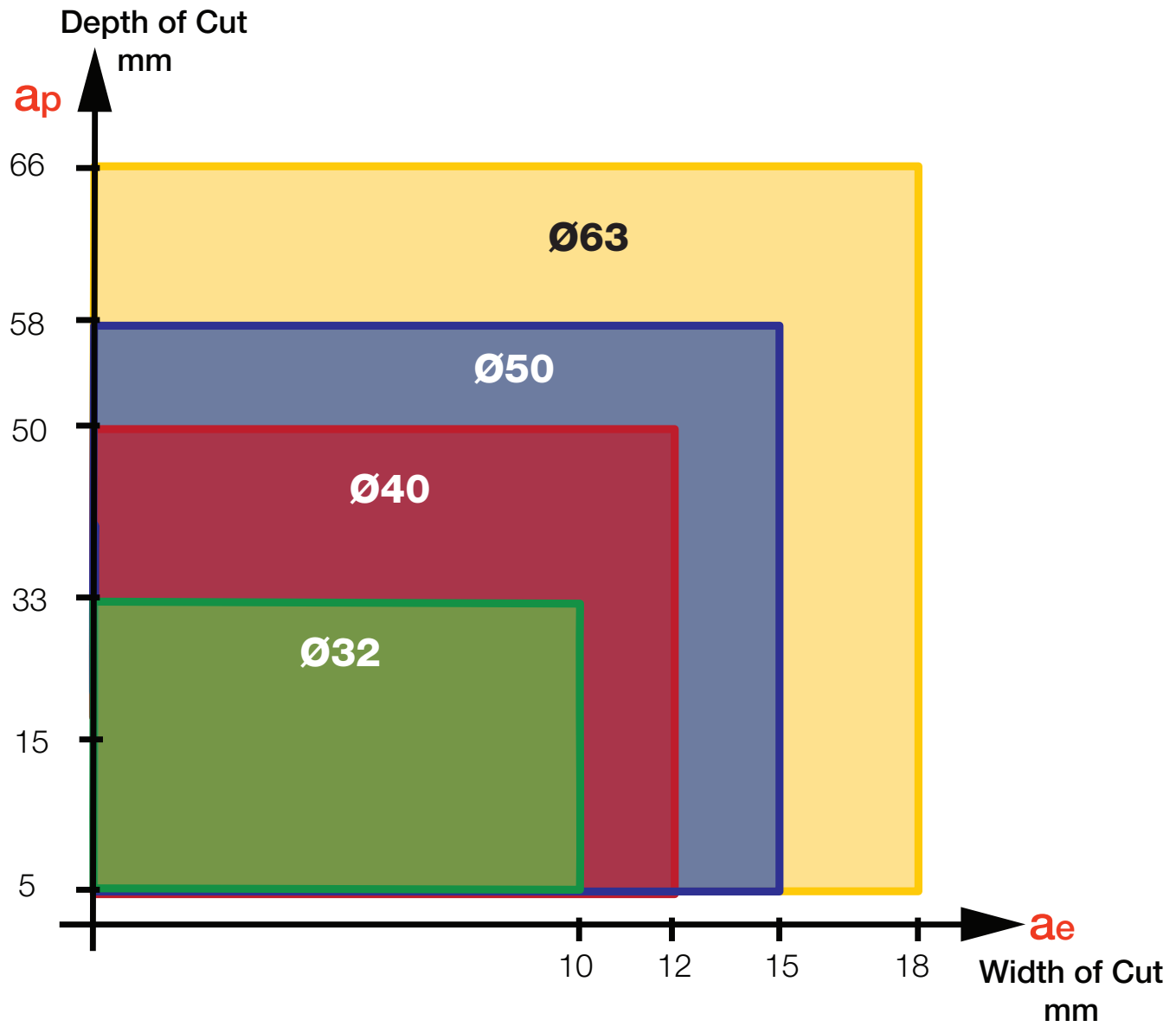
Table - Starting Cutting Recommendations for Extended Flute Cutter _ T490 ...11

ISO Class DIN/ISO 513	Workpiece Material: Description	Typical Example: AISI/SAE/ ASTM	Typical Example: DIN W.-Nr.	Typical Example: Hardness, HB	ISCAR Mat. Group*	Cutting Speed Vc, m/min	Feed Fz, mm/tooth	Width of Cut [mm]: 32 Z=2	40 Z=3	50 Z=3	50 Z=4	63 Z=4	63 Z=5	Grade	Coolant
P	Non-alloy steel	1020	1.0402	130-180	1	120-150	0.12-0.18	8-12	10-14	15-20	8-10	10-15	8-10	IC830/ IC808	Air
	Alloy steel	4340	1.6582	260-300	8	120-10	0.10-0.15	8-12	10-14	15-20	8-10	10-15	8-10		
	Alloy steel	3135	1.5710	HRC 35-40**	9	80-120	0.08-0.15	8-10	10-14	10-15	6-8	8-12	6-8		
	High alloy steel	H13	1.2344	200-220	10	100-150	0.12-0.18	8-12	10-14	15-20	8-10	10-15	8-10		
	Martensitic s.s.	420	1.4021	200	12	100-140	0.10-0.15	8-12	10-14	15-20	8-10	10-15	8-10		Air / wet
M	Austenitic s.s.	304L	1.4306	200	14	80-120	0.10-0.15	6-8	8-10	10-15	8-12	10-15	10-12	IC830/330	Wet (emulsion)
K	Grey cast iron	Class 40	0.6025 (GG25)	250	16	180-230	0.12-0.20	10-13	10-16	20-25	20-25	25-30	25-30	IC810	
	Nodular cast iron	Class 80-55-06	0.7060 (GGG60)	220	18	150-180	0.12-0.18	8-12	10-14	15-20	10-15	15-25	15-20		
S	High temp. alloys	Inconel 625	2.4856	200-240	33	35-45	0.08-0.12	6-8	8-10	10-15	8-12	10-15	10-12	IC830	Wet (emulsion)

* ISCAR material group in accordance with VDI 3323 standard

** Quenched and tempered

For austenitic and stainless steel and high temperature alloys use the peripherally ground T490 LNHT 1106…. Inserts



Workpiece material: SAE 4340

- T490 LNK D32...
- T490 SM/LNK D40...
- T490 SM/LNK D50...
- T490 SM D63...