

DENITTOOL-DATA

MicroTurn A/S

<b>Caution: General safety regulations and directions of machine manufacturers must be observed at any time!</b>				
Material description	W-Nr. German	AISI/SAE	Tensile strength	Hardness

			Rm (N/mm <sup>2</sup> )	HB	
1	Low Carbon Steel	1.0035 1.0038 1.0401 1.0050	1010 1045 1015 1050	- 500	- 160
2	Alloy Steel	1.0501 1.1141 1.5732 1.7225	1035 1115 3415 4140	500 - 700	140 - 200
3	Tool Steel	1.1221 1.3505 1.7225 1.5141	1060 52100 4140 -	900 - 1'100	170 - 275
4	Alloy Tool Steel	1.1191 1.7225 1.2080 1.7220	4140 4142 D3 4135	700 - 900	250 - 325
5	Alloy Cast Steel	1.6582 1.8159 1.2367 1.7361	4340 6150 A2 4145	1'100 - 1'500 800 - 1'000	325 - 450 250 - 300 330 - 390
6	Stainless Steel	1.4006 1.4057 1.4034 1.4005	403 431 420 416	- 800	- 250
7	Stainless Steel - Austenitic, Martensitic	1.4300 1.4301 1.4435 1.4542	302 304 (304H) 316 17-4 ph	500 - 1100	200 - 325
8	Grey Cast Iron	0.6010 0.6015 0.6020	A48-20B A48-25B A48-30B	- 250	- 200
9	Cast Iron Malleable	0.6025 0.8135 0.8140 0.7050	A48-35B A48-40B A48-45B 80-55-06	250 - 350	200 - 250
10	Copper Alloys	2.0331 2.0401 2.1030 2.0920	B121 B121 B103 CuAl 8	450 - 650	120 - 180
11	Aluminium Alloys	3.2582.05 3.3541.01 3.2315 3.0205	383.2 (ALSi-12) 514.0 (AlMg 3) 413.0 (ALMgSi 1) 1200 (AL 99)	250 - 350	200 - 300

NSA.. NSL.. NSQ.. NSX..	NSE.. Shank-Ø 4mm	NSE.. Shank-Ø 6mm	NSE.. Shank-Ø 8mm	NSF.. Shank-Ø 6mm	NSM.. NSW..

f (ipr) *)					(mm) **)
.0004 +	.0002 +	.0002 +	.0002 +	.0002 +	.0002 +
.0024	.0012	.0020	.0023	.0020	.0020
.0004 +	.0002 +	.0002 +	.0002 +	.0002 +	.0002 +
.0024	.0012	.0016	.0024	.0016	.0016
.0004 +	.0002 +	.0002 +	.0002 +	.0002 +	.0002 +
.0024	.0012	.0016	.0024	.0016	.0016
.0004 +	.0002 +	.0002 +	.0002 +	.0002 +	.0002 +
.0016	.0010	.0012	.0012	.0012	.0012
.0004 +	.0002 +	.0002 +	.0002 +	.0002 +	.0002 +
.0016	.0010	.0012	.0012	.0012	.0012
.0004 +	.0002 +	.0002 +	.0002 +	.0002 +	.0002 +
.0016	.0010	.0012	.0012	.0012	.0012
.0012 +	.0006 +	.0006 +	.0006 +	.0006 +	.0006 +
.0039	.0020	.0028	.0035	.0028	.0028
.0012 +	.0004 +	.0006 +	.0006 +	.0006 +	.0006 +
.0039	.0016	.0020	.0024	.0020	.0020
.0004 +	.0006 +	.0006 +	.0006 +	.0006 +	.0006 +
.0039	.0024	.0031	.0047	.0031	.0031
.0004 +	.0006 +	.0006 +	.0006 +	.0006 +	.0006 +
.0039	.0020	.0039	.0047	.0031	.0031

DENALLOY®						
uncoated		coated				
		TiN Standard	TiCN	AlTiN		

Vc (sfm)						
		165				
		142				
		120				
		85				
		66				
		116				
		95				
		99				
		85				
		525				
		990				

\*) low data for tool w. long shank - high data for tool w. short shank

\*\*\*) chip thickness

