

Turning 60°

DENITTOOL-DATA

Caution: General safety regulations and directions of machine manufacturers must be observed at any time!

Material description	W-Nr. German	AISI/SAE	Tensile strength	Hardness
			Rm (N/mm ²)	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

TPGT 16..-25	TPHT 11../16.. ER/L	TPHT 11../16.. FR/L	TPHW 11../16.. EN	TPHW 11../16.. FN
f (ipr *)				
	.0031 .0059 .0118			
	.0031 .0059 .0118		.0031 .0071 .0118	
	.0031 .0059 .0098		.0031 .0071 .0118	
	.0031 .0059 .0059		.0031 .0059 .0079	
	.0010 .0020 .0039	.0031 .0059 .0118		
	.0008 .0024 .0039	.0031 .0059 .0118		
			.0024 .0047 .0118	.0012 .0039 .0079
			.0024 .0047 .0098	.0012 .0039 .0079
		.0020 .0059 .0118		.0020 .0079 .0157
	.0020 .0079 .0157	.0020 .0059 .0079		

Carbide						Cermet		
uncoated		coated						
DX2	P25	DP25	DP35 DP55	DX20	DX30 DX50 DX52			
Vc (sfm)								
	495 425 300	1050 850 725	1220 990 825					
	390 300 200	990 825 690	1120 925 790					
	300 230 165	850 725 625	990 825 690					
	200 165 135	660 525 400	750 600 460					
		525 360 260	610 410 315					
		660 525 460	760 600 460					
		600 460 400	660 525 450					
	400 330 260	400 330 261	660 560 425	750 625 480	660 560 425	750 625 480		
	400 300 230	400 330 260	560 460 360	625 525 410	560 460 360	625 525 410		
	1800 1650 1320	1800 1650 1321	2640 2300 1980	2640 2300 1981	2640 2300 1982	2640 2300 1983		
	2640 1650 990				>3300 >3300			

*) in function of stability of tool & workpiece

