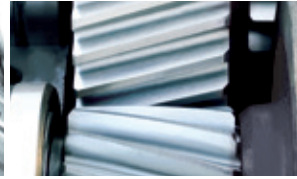




VEHICLES



AEROSPACE



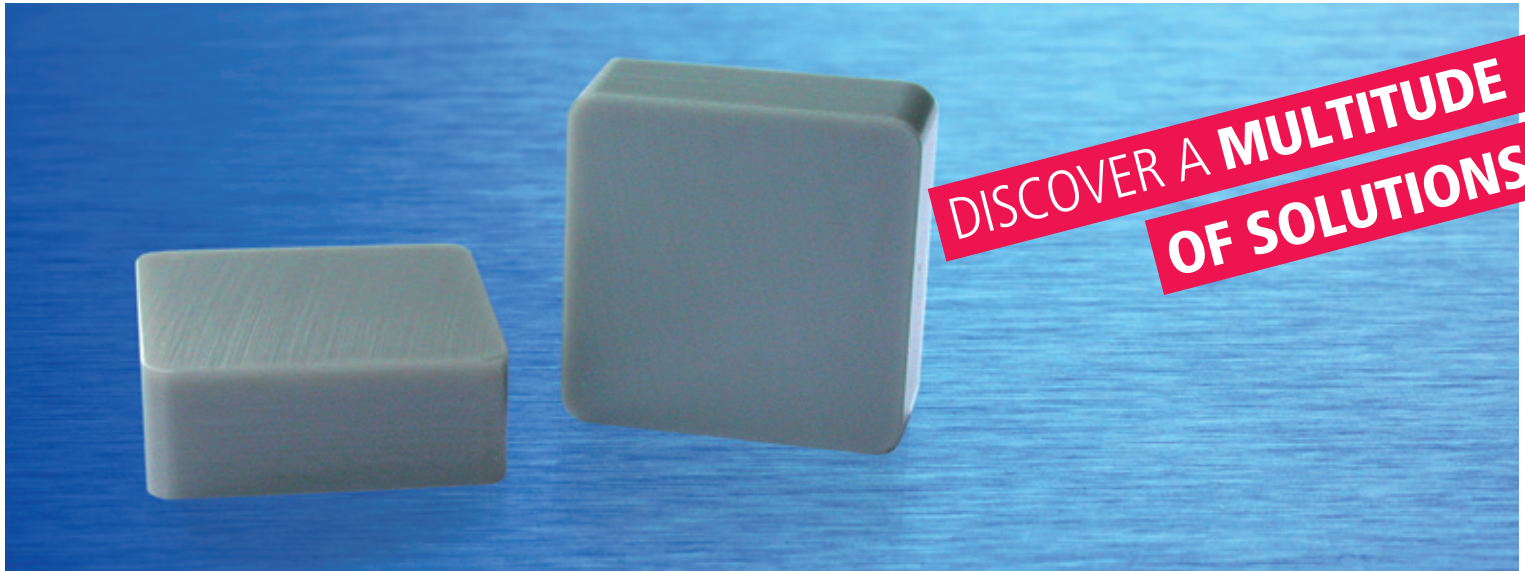
GEARS + BEARINGS



ENGINEERING



WIND ENERGY



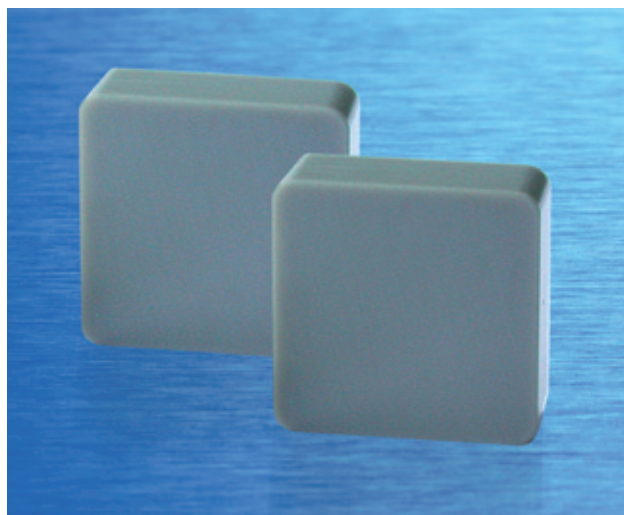
# LKM 840

The SiAlON for cast iron materials and heat resistant superalloys.

# LKM 840 - $\alpha/\beta$ -SiAlON for milling

Outstanding toughness combined with highest wear resistance make the LKM 840 SiAlON ceramic a high performance grade for rough milling of GJL (GG), GJS (GGG) and HRSA (high heat resistant superalloys) materials. Great wear performance enables high cutting speeds. This results in large removal rates and at the same time excellent process reliability. Using LKM 840 the reachable tool life of cast iron materials can be improved distinctly. When milling HRSA materials, a cutting speed of up to 1000 m/min is possible.

Increase of productivity, decrease of production time and cost. LKM 840 is the ideal grade to enhance the added value when milling.

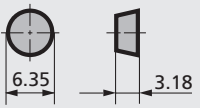

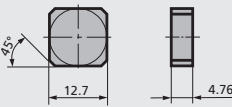
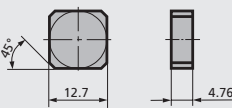
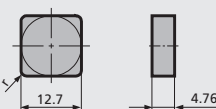
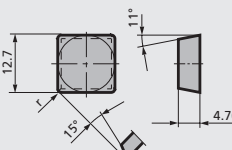


## Cutting data recommendations

GJL (GG)	Recommended value $v_c$	Total value $v_c$	Recommended value $f_z$	Total value $f_z$
<b>Härte (HB)</b>	<b>m/min.</b>	<b>m/min.</b>	<b>mm/z</b>	
190 - 210	1500	800 - 2000	0,20	0,14 - 0,25
220 - 240	1200	500 - 1500	0,20	0,14 - 0,25
250 - 280	800	300 - 1200	0,20	0,14 - 0,25

GJS (GGG)	Recommended value $v_c$	Total value $v_c$	Recommended value $f_z$	Total value $f_z$
<b>Zugfestigkeit RM (N/mm<sup>2</sup>)</b>	<b>m/min.</b>	<b>m/min.</b>	<b>mm/z</b>	
400 - 500	800	600 - 1000	0,16	0,14 - 0,21
500 - 700	700	500 - 800	0,16	0,14 - 0,21

HRSA	Recommended value $v_c$	Total value $v_c$	Recommended value $f_z$	Total value $f_z$
	<b>m/min.</b>	<b>m/min.</b>	<b>mm/z</b>	
<b>HRSA</b>	1000	500 - 1100	0,11	0,08 - 0,16

Insert	Type	Grade	K													H	S	P	SPK-ORDER NR.												
			GJL			GJS			ADI	SI GJS		GJV																			
			EN-GJL 150	EN-GJL 200	EN-GJL 250	EN-GJL 300	EN-GJL 350	EN-GJS 400-15	EN-GJS 500-7	EN-GJS 600-3	EN-GJS 700-2	EN-GJS 800-2	EN-GJS 800-8	EN-GJS 1000-5	EN-GJS 1200-2	EN-GJS 1400-0	EN-GJS 450-18	EN-GJS 500-14	EN-GJS 600-10	EN-GJV 300	EN-GJV 350	EN-GJV 400	EN-GJV 450	EN-GJV 500	STAHL HART	HARTGUSS	KOKILLENGUSS	SPEZ. LEGIERUNG	STAHL		
<b>RPGN 06 03 T00520</b> 	RPGN 06 03 00 T00520	LKM 840	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆					◇	◇	◇										◆		23.42.334.03.2
<b>RPGN 09 04 T00520</b> 	RPGN 09 04 00 T00520	LKM 840	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆					◇	◇	◇										◆		23.42.054.03.2
<b>SNCN 12 04 ZN T</b> 	SNCN 12 04 ZN T00520	LKM 840	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆					◇	◇	◇										◆		23.10.409.03.2
<b>SNCN 12 04 ZZ T</b> 	SNCN 12 04 ZZ T00520	LKM 840	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆					◇	◇	◇										◆		23.10.343.03.2
<b>SNGN 12 04 .. T</b> 	SNGN 12 04 08 T 01020	LKM 840	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆					◇	◇	◇										◆		23.10.009.20.2
	SNGN 12 04 12 T 01020	LKM 840	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆					◇	◇	◇										◆		23.10.058.20.2
<b>SPCN 09 04 08 T</b> 	SPCN 09 04 08 T01020	LKM 840	◆	◆	◆	◆	◆	◆	◆	◆	◆	◆					◇	◇	◇										◆		23.12.427.20.2

ISO application group

<b>K</b> <span style="color:red">■</span> Cast Iron	<b>H</b> <span style="color:grey">■</span> Hard materials	<b>S</b> <span style="color:orange">■</span> Special alloy	<b>P</b> <span style="color:blue">■</span> Steel	Main application <span style="color:blue">◆</span>	Additional application <span style="color:grey">◇</span>
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