

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	Ck15, Ck45 1020, 1045	150	0.5	3.5	0.23	0.48	190	350		
			180		3.5		0.48		300		
			210		3.5		0.48		260		
Alloy Steel	2	42 CrMo 4 St 50-2 Ck60 1060 4140	180	0.5	3.5	0.28	0.42	150	240		
			230		3.5		0.42		210		
			280	0.5	3.5	0.28	0.35	130	190		
			320		3.5		0.35		170		
High Alloy Steel	3	X40 CrMoV 5 1 H 13 40 NiCrMo 6 4340 S 2-10-1-8 HSS M42	220	0.5	3.5	0.15	0.32	90	150		
			280		3.5		0.32		130		
			320	0.5	3.5	0.15	0.28	60	110		
			350		3.5		0.28		90		
			400	0.5	3.0	0.14	0.25	40	80		
			480		2.0		0.22		70		
			550		1.0		0.20		60		
			Austenitic Stainless Steel	4	X5 CrNi 18 9 304	210 to 250	0.5	3.5	0.22	0.35	190
5	X2 CrNiMo 17 2 2 316	230 to 270				0.5	3.5	0.18	0.32	160	210
		6				X6 CrNiMoTi 17 12 2 316 Ti Duplex / Nitronic	-----	0.5	3.5	0.15	0.28
Ferritic Stainless Steel	7	X8 Cr 7 430	Annealed	0.5	3.5	0.18	0.35	150	210		
Martensitic Stainless Steel	8	X15 Cr 13 410	Annealed	0.5	3.5	0.18	0.35	150	230		
			Treated	0.5	3.5	0.18	0.28	90	170		
Grey Cast Iron	9	GG 20	140 to 230	0.5	3.5	0.20	0.50	170	300		
		GG 25							250		
		GG 30							210		
Nodular Cast Iron	10	GGG 40	210	0.5	3.5	0.18	0.48	120	210		
		GGG 50	260						170		
		GGG 70	310						150		
		G-X260NiCr42	450	0.5	3.0	0.14	0.25	30	60		
Nickel Based Alloys	11	Inconel 625	-----	0.5	3.5	0.15	0.30	25	35		
		Inconel 718						28	40		
		Hastelloy C						40	60		
Titanium Based Alloys	12	TiAl 6 V4	-----	0.5	3.5	0.15	0.35	35	60		
		T40					0.28	28	40		

