

Material Group	Group No	Material Examples*	Brinell hardness	d.o.c [mm]		feed [mm/tooth]		V <sub>c</sub> [m/min]	
				min	max	min	max	min	max
Low Carbon Steel	1	Ck15, Ck45 1020, 1045	150	0.5	4.0	0.23	0.52	190	350
			180		4.0		0.52		300
			210		4.0		0.52		260
Alloy Steel	2	42 CrMo 4 St 50-2 Ck60 1060 4140	180	0.5	4.0	0.20	0.48	150	240
			230		4.0		0.48		210
			280	0.5	4.0	0.20	0.45	130	190
			320		4.0		0.45		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	4.0	0.15	0.42	90	150
			280		4.0		0.42		130
			320	0.5	4.0	0.15	0.38	60	110
			350		4.0		0.38		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	4.0	0.18	0.35	190	250
	5	X2 CrNiMo 17 2 2 316	230 to 270	0.5	4.0	0.18	0.32	160	210
	6	X6 CrNiMoTi 17 12 2 316 Ti Duplex / Nitronic	-----	0.5	4.0	0.15	0.28	70	150
Ferritic Stainless Steel	7	X8 Cr 7 430	Annealed	0.5	4.0	0.21	0.38	150	210
Martensitic Stainless Steel	8	X15 Cr 13 410	Annealed	0.5	4.0	0.21	0.38	150	230
			Treated	0.5	4.0	0.21	0.32	90	170
Grey Cast Iron	9	GG 20	140 to 230	0.5	4.0	0.22	0.50	170	300
		GG 25							250
		GG 30							210
Nodular Cast Iron	10	GGG 40	210	0.5	4.0	0.18	0.45	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	4.0	0.16	0.32	25	35
		Inconel 718						28	40
		Hastelloy C						40	60
Titanium Based Alloys	12	TiAl 6 V4	-----	0.5	4.0	0.18	0.32	35	60
		T40					0.28	28	40

ODMT

