

Material Group	Group No	Material Examples*	Brinell hardness	d.o.c [mm]		feed [mm/rev]		A max [mm ²]	V _c [m/min]		Optimal cutting conditions		
				min	max	min	max		min	max	d.o.c	feed	
Low Carbon Steel	1	Ck15, Ck45 1020, 1045	150	CNMA inserts are not recommended for Low Carbon Steel									
			180										
			210										
Alloy Steel	2	42 CrMo 4 St 50-2 Ck60 1060 4140	180	CNMA inserts are not recommended for Alloy Steel									
			230										
			280										
			320										
High Alloy Steel	3	X40 CrMoV 5 1 H 13 40 NiCrMo 6 4340 S 2-10-1-8 HSS M42	220	CNMA inserts are not recommended for High Alloy Steel									
			280										
			320										
			350										
			400										
			480										
550													
Austenitic Stainless Steel	4	X5 CrNi 18 9 304	210 to 250	CNMA inserts are not recommended for Austenitic Stainless Steel									
	5	X2 CrNiMo 17 2 2 316	230 to 270										
	6	X6 CrNiMoTi 17 12 2 316 Ti Duplex / Nitronic	-----										
Ferritic Stainless Steel	7	X8 Cr 7 430	Annealed	CNMA inserts are not recommended for Ferritic Stainless Steel									
Martensitic Stainless Steel	8	X15 Cr 13 410	Annealed Treated	CNMA inserts are not recommended for Martensitic Stainless Steel									
Grey Cast Iron	9	GG 20	140 to 230	0.50	5.0	0.20	0.90	3.0	170	250	4.0	0.60	
		GG 25						2.7		230			
		GG 30						2.7		210			
Nodular Cast Iron	10	GGG 40	210 to 310	0.50	5.0	0.20	0.70	2.3	120	230	4.0	0.50	
		GGG 50						2.0		190			
		GGG 70						1.8		150			
		G-X260NiCr42						0.25		30			50
Nickel Based Alloys	11	Inconel 625	-----	CNMA inserts are not recommended for Exotic materials									
		Inconel 718											
		Hastelloy C											
Titanium Based Alloys	12	TiAl 6 V4	-----	CNMA inserts are not recommended for Exotic materials									
		T40											

Insert designation Super Finishing Finishing Semi Finishing Roughing Interrupted Cut

CNMA 120416 NN

