

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	0.20	5.0	0.12	0.30	1.2	180	330	2.5	0.16	
			180		4.0		0.28			0.8			280
			210		4.0		0.25			0.8			250
Alloy Steel	2	42 CrMo 4 St 50-2 Ck60 1060 4140	180	0.20	4.0	0.10	0.28	0.8	120	280	2.0	0.15	
			230		4.0		0.25			0.8			250
			280		3.0	0.08	0.22	0.6		210			
			320		3.0		0.20	0.5		180			
High Alloy Steel	3	X40 CrMoV 5 1 H 13 40 NiCrMo 6 4340 S 2-10-1-8 HSS M42	220	0.20	3.0	0.08	0.23	0.6	70	190	1.5	0.12	
			280		3.0		0.21	0.5		150			
			320		3.0		0.18	0.5		130			
			350		3.0		0.16	0.4		100			
			400	0.20	2.0	0.05	0.12	0.2	50	90	1.5	0.11	
			480		1.5		0.10	0.2	40	80	1.0	0.09	
			550		1.0		0.08	0.1	30	70	0.5	0.07	
Austenitic Stainless Steel	4	X5 CrNi 18 9 304	210 to 250	0.20	4.0	0.12	0.23	0.7	170	270	3.0	0.16	
	5	X2 CrNiMo 17 2 2 316	230 to 270		3.0	0.10	0.21	0.5	160	210	2.0	0.14	
	6	X6 CrNiMoTi 17 12 2 316 Ti Duplex / Nitronic	-----		3.0	0.08	0.18	0.5	70	150	1.5	0.20	
Ferritic Stainless Steel	7	X8 Cr 7 430	Annealed	0.20	3.0	0.10	0.22	0.6	170	250	2.0	0.15	
Martensitic Stainless Steel	8	X15 Cr 13 410	Annealed Treated	0.20	3.0	0.10	0.22	0.6	170 120	250 190	2.0	0.15	
Grey Cast Iron	9	GG 20	140 to 230	0.20	5.0	0.12	0.30	1.2	170	250	3.0	0.16	
		GG 25						1.2		230			
		GG 30						1.2		210			
Nodular Cast Iron	10	GGG 40	210	0.20	4.0	0.10	0.25	0.8	120	230	2.0	0.13	
		GGG 50	260					0.8		190			
		GGG 70	310					0.8		150			
		G-X260NiCr42	450	0.20	1.4	0.05	0.10	0.1	30	50	1.0	0.07	
Nickel Based Alloys	11	Inconel 625	-----	0.20	3.0	0.08	0.22	0.6	25	35	1.5	0.12	
		Inconel 718						0.6	28	40			
		Hastelloy C						0.6	40	65			
Titanium Based Alloys	12	TiAl 6 V4	-----	0.20	3.0	0.08	0.23	35	60	1.5	0.12		
		T40					0.21	28	40	1.5	0.12		

Insert designation Super Finishing Finishing Semi Finishing Roughing Interrupted Cut

TNUX 16040 R & L



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