

RCMT 10T3 M0 LT 1000

T0001916 Metric

Material Group	Lamina Group	Material Example	Hardness	D.O.C.		Feed		Amax [mm ²]	Vc		Advised D.O.C. [mm]	Advised Feed [mm/t]	Advised Vc [m/min]
				min [mm]	max [mm]	min [mm/t]	max [mm/t]		min [m/mm]	max [m/mm]			
Non Aligned	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.50	2.8	0.15	0.4	0.9	180	430	1.4	0.35	265
			190 HB	0.50	2.8	0.15	0.4	0.9	180	365	1.4	0.35	240
			250 HB	0.50	2.1	0.15	0.35	0.78	180	325	1.4	0.3	220
Low Aligned	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.50	2.8	0.15	0.35	0.78	120	365	1.4	0.3	220
			230 HB	0.50	2.8	0.15	0.35	0.67	120	325	1.4	0.3	200
			280 HB	0.50	2.8	0.15	0.35	0.56	120	275	1.4	0.3	165
			350 HB	0.50	2.1	0.15	0.35	0.5	120	235	1.4	0.3	145
High Aligned	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.50	2.8	0.13	0.35	0.67	70	245	1.4	0.3	155
			280 HB	0.50	2.8	0.13	0.3	0.56	70	195	1.4	0.28	130
			320 HB	0.50	2.1	0.13	0.3	0.45	70	130	1.4	0.28	100
			350 HB	0.50	2.1	0.13	0.3	0.36	70	110	1.4	0.24	90
Austenitic	4	304, 316, X5CrNi18-9	180 HB	0.50	2.8	0.14	0.35	0.45	170	270	1.4	0.3	220
			240 HB	0.50	2.8	0.14	0.32	0.45	160	220	1.4	0.29	190
Duplex	5	X2CrNiN23-4, S31500	290 HB	0.50	2.1	0.13	0.3	0.42	80	150	1.4	0.28	100
			310 HB	0.50	2.1	0.13	0.3	0.42	70	140	1.4	0.28	90
Ferritic & Martensitic	6	410, X6Cr17, 17-4 PH, 430	200 HB	0.50	2.8	0.15	0.35	0.45	170	250	1.4	0.25	210
			388 HB	0.50	2.8	0.15	0.3	0.42	120	190	1.4	0.22	140
Grey	7	GG20, GG40, EN-GJL-250, N030B	150 HB	0.50	2.8	0.11	0.45	0.98	170	250	1.4	0.35	200
			200 HB	0.50	2.8	0.11	0.45	0.91	160	230	1.4	0.35	180
			250 HB	0.50	2.8	0.11	0.45	0.84	150	210	1.4	0.35	160
Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.50	2.8	0.11	0.35	0.84	120	250	1.4	0.3	180
			200 HB	0.50	2.8	0.11	0.35	0.7	120	230	1.4	0.3	160
			250 HB	0.50	2.8	0.11	0.35	0.63	120	190	1.4	0.3	140
Fe, Ni & Co Based	9	Incoloy 800	240 HB	0.50	2.1	0.13	0.3	0.42	25	50	1.4	0.28	35
			250 HB	0.50	2.1	0.13	0.3	0.42	25	50	1.4	0.28	30
			350 HB	0.50	2.1	0.13	0.3	0.42	25	45	1.4	0.28	30
Steel Chilled Cast Iron White Cast Iron	11	X100CrMo13 .440C, GX260NiCr4 2	419 HB	0.50	1.7	0.05	0.22	0.28	50	100	1.3	0.18	80
			469 HB	0.50	1.4	0.05	0.18	0.24	40	90	1	0.16	70
			552 HB	0.30	1.1	0.05	0.14	0.17	40	80	0.8	0.12	60
			400 HB	0.50	1.7	0.05	0.22	0.24	40	60	1.3	0.18	50
			552 HB	0.30	1.1	0.05	0.14	0.14	30	50	0.8	0.12	40
Al (>8%Si)	12	AlSi12	130 HB	0.50	2.8	0.15	0.4	0.98	200	400	1.4	0.35	280



Steel



Stainless steel



Cast iron



High temp alloys



Hardened material



ALU