

Material Group	Lamina Group	Material Example	Hardness	D.O.C.		Feed		Vc		Advised D.O.C.	Advised Feed	Advised Vc
				min [mm]	max [mm]	min [mm/t]	max [mm/t]	min [m/mm]	max [m/mm]	[mm]	[mm/t]	[m/min]
Non Alloyed	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.50	7.0	0.18	0.46	190	330	3	0.34	250
			190 HB	0.50	7.0	0.18	0.46	190	300	3	0.34	220
			250 HB	0.50	7.0	0.18	0.46	190	250	3	0.34	200
Low Alloyed	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.50	7.0	0.15	0.36	150	240	3	0.3	200
			230 HB	0.50	7.0	0.15	0.36	150	210	3	0.3	180
			280 HB	0.50	7.0	0.15	0.32	130	190	3	0.27	150
High Alloyed	3	X40CrMOV5, H13, M42, D3, S6-5-2, 12Ni19	350 HB	0.50	7.0	0.15	0.32	130	170	3	0.27	140
			220 HB	0.50	5.0	0.12	0.32	90	150	2.3	0.27	130
			280 HB	0.50	5.0	0.12	0.32	90	130	2.3	0.27	120
Austentic	4	304, 316, X5CrNi18-9	320 HB	0.50	5.0	0.12	0.26	60	110	2.3	0.24	100
			350 HB	0.50	5.0	0.12	0.26	60	90	2.3	0.24	80
			180 HB	0.50	7.0	0.15	0.32	190	250	3	0.27	220
Duplex	5	X2CrNiN23-4, S31500	240 HB	0.50	7.0	0.12	0.29	160	210	3	0.27	190
			290 HB	0.50	5.0	0.12	0.26	70	130	2.3	0.24	100
Ferritic & Martensitic	6	410, X6Cr17, 17-4 PH, 430	310 HB	0.50	5.0	0.12	0.26	70	120	2.3	0.24	90
			200 HB	0.50	7.0	0.15	0.32	150	210	3	0.27	190
Grey	7	GG20, GG40, EN-GJL-250, N030B	388 HB	0.50	5.0	0.15	0.26	90	150	2.3	0.24	130
			150 HB	0.50	7.0	0.18	0.46	150	240	3	0.34	200
			200 HB	0.50	7.0	0.18	0.46	150	220	3	0.34	180
Malleable & Nodular	8	GGG40, GGG70, 50005	250 HB	0.50	7.0	0.18	0.46	150	190	3	0.34	160
			150 HB	0.50	7.0	0.15	0.41	100	200	3	0.3	180
			200 HB	0.50	7.0	0.15	0.41	100	180	3	0.3	150
Fe, Ni & Co Based	9	Incoloy 800	250 HB	0.50	7.0	0.15	0.41	100	150	3	0.3	130
			240 HB	0.50	5.0	0.12	0.26	25	45	2.3	0.24	32
			250 HB	0.50	5.0	0.12	0.26	25	45	2.3	0.24	30
Steel Chilled Cast Iron White Cast Iron	11	X100CrMo13, 440C, G-X260NiCr42	350 HB	0.50	5.0	0.12	0.26	25	45	2.3	0.24	30
			419 HB	0.50	2.5	0.1	0.26	40	80	1.5	0.21	60
			469 HB	0.50	1.75	0.1	0.23	40	70	1.1	0.19	55
Al (>8%Si)	12	AlSi12	552 HB	0.50	1.5	0.1	0.2	40	60	0.8	0.18	50
			400 HB	0.50	2.0	0.1	0.26	40	80	1.1	0.21	50
			552 HB	0.50	1.5	0.1	0.2	30	60	0.8	0.18	40



Steel



Stainless steel



Cast iron



High temp alloys



Hardened material



ALU