RDMT 0602 M0

Material Group	Group No	Material Examples*	Brinell hardness	d.o.c [mm]		feed [mm/tooth]		V_c [m/min]	
				min	max	min	max	min	max
Low Carbon Steel	1	Ck 15 9SMnPb28	150	0.50	2.00	0.15	0.35	180	400
			180		2.00		0.35		350
			210		1.50		0.35		200
Alloy Steel	2	42 CrMo 4 100 Cr 6 32 NiCrMo 14.5	180	0.50	2.00	0.15	0.30	120	300
			230		2.00		0.30		250
			280		2.00		0.30		210
			320		1.50		0.25		180
High Alloy Steel	3	X38 CrMoV 5 X210 CrW 12 X90 CrMoV 8	220	0.50	2.00	0.13	0.30	70	190
			280		2.00		0.30		150
			320		1.50		0.30		130
			350		1.50		0.25		100
Austenitic Stainless Steel	4	303 / 304 304 L	210 to 250	0.50	2.00	0.14	0.25	170	270
	5	316 / 316 L	230 to 270		2.00	0.13	0.18	170	210
	6	316 Ti 630 (F16PH)	--------		1.50	0.13	0.18	80	130
Ferritic Stainless Steel	7	430 / 439 / 444	Annealed	0.50	2.00	0.15	0.20	170	250
Martensitic Stainless Steel	8	410 / 420	Annealed	0.50	2.00	0.15	0.20	170	250
			Treated					120	210
Grey Cast Iron	9	EN - GJL 200	140 to 230	0.50	2.00	0.11	0.45	170	280
		EN - GJL 250							250
		EN - GJL 300							230
Nodular Cast Iron	10	EN - GJS 400	210	0.50	2.00	0.11	0.35	120	230
		EN - GJS 600	260						190
		EN - GJS 800	310						150
Nickel Based Alloys	11	Inconel 625	--------	0.50	1.50	0.13	0.18	25	35
		Inconel 718							40
		Hastelloy C							65
Titanium Based Alloys	12	TiAl 6 V4	--------	0.50	1.50	0.13	0.18	35	60
		T40					0.15	28	40

*For all material types and standards, see pages 155 to 158.