RDMT 0803 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	0.42	180	400
			180		2.00		0.42		350
			210		1.50		0.42		200
Alloy Steel	2	42 CrMo 4 100 Cr 6 32 NiCrMo 14.5	180	0.50	2.00	0.15	0.36	120	300
			230		2.00		0.36		250
			280		2.00	0.13	0.36		210
			320		1.50		0.30		180
High Alloy Steel	3	X38 CrMoV 5 X210 CrW 12 X90 CrMoV 8	220	0.50	2.00	0.13	0.36	70	190
			280		2.00		0.36		150
			320		1.50		0.36		130
			350		1.50		0.30		100
Austenitic Stainless Steel	4	303 / 304 304 L	210 to 250	0.50	2.00	0.14	0.30	170	270
	5	316 / 316 L	230 to 270		2.00	0.13	0.21	170	210
	6	316 Ti 630 (F16PH)	--------		1.50	0.13	0.21	80	130
Ferritic Stainless Steel	7	430 / 439 / 444	Annealed	0.50	2.00	0.15	0.24	170	250
Martensitic Stainless Steel	8	410 / 420	Annealed	0.50	2.00	0.15	0.24	170	250
			Treated					120	210
Grey Cast Iron	9	EN - GJL 200	140 to 230	0.50	2.00	0.11	0.54	170	280
		EN - GJL 250							250
		EN - GJL 300							230
Nodular Cast Iron	10	EN - GJS 400	210	0.50	2.00	0.11	0.42	120	230
		EN - GJS 600	260						170
		EN - GJS 800	310						150
Nickel Based Alloys	11	Inconel 625	--------	0.50	1.50	0.13	0.21	25	35
		Inconel 718							40
		Hastelloy C							65
Titanium Based Alloys	12	TiAl 6 V4	--------	0.50	1.50	0.13	0.21	35	60
		T40						28	40

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