

## RDMT 1204 M0

Material Group	Group No	Material Examples*	Brinell hardness	d.o.c [mm]		feed [mm/tooth]		V <sub>c</sub> [m/min]					
				min	max	min	max	min	max				
Low Carbon Steel	1	Ck 15 9SMnPb28	150	0.50	4.00	0.22	0.70	180	400				
			180		4.00		0.70		350				
			210		3.00		0.70		200				
Alloy Steel	2	42 CrMo 4 100 Cr 6 32 NiCrMo 14.5	180	0.50	4.00	0.22	0.60	120	300				
			230		3.00		0.60		250				
			280		3.00	0.18	0.60		210				
			320		2.50		0.50		180				
High Alloy Steel	3	X38 CrMoV 5 X210 CrW 12 X90 CrMoV 8	220	0.50	3.00	0.18	0.60	70	190				
			280		3.00		0.60		150				
			320		2.00		0.60		130				
			350		2.00		0.50		100				
Austenitic Stainless Steel	4	303 / 304 304 L	210 to 250	0.50	3.00	0.2	0.50	170	270				
	5	316 / 316 L	230 to 270		3.00					0.18	0.35	170	210
	6	316 Ti 630 (F16PH)	-----		2.00					0.18	0.35	80	130
Ferritic Stainless Steel	7	430 / 439 / 444	Annealed	0.50	3.00	0.22	0.40	170	250				
Martensitic Stainless Steel	8	410 / 420	Annealed	0.50	3.00	0.22	0.40	170	250				
			Treated					120	210				
Grey Cast Iron	9	EN - GJL 200	140 to 230	0.50	3.00	0.15	0.90	170	280				
		EN - GJL 250							250				
		EN - GJL 300							230				
Nodular Cast Iron	10	EN - GJS 400	210	0.50	3.00	0.15	0.70	120	230				
		EN - GJS 600	260						190				
		EN - GJS 800	310						150				
Nickel Based Alloys	11	Inconel 625	-----	0.50	2.00	0.18	0.35	25	35				
		Inconel 718							40				
		Hastelloy C							65				
Titanium Based Alloys	12	TiAl 6 V4	-----	0.50	3.00	0.18	0.35	35	60				
		T40						28	40				

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

