



Valid for WCMX06T308-NN

NEW PRODUCT

Material Group	Group N°	Brinell hardness HB	feed [mm/rev]		Vc [m/min]	
			min	max	max	min
Low Carbon steel	XC 12 S 250 Pb	150	0.06	0.12	180	270
		180				230
		210				200
Alloy steel	42 CrMo 4 100 Cr 6 32 NiCrMo 14.5	180	0.06	0.16	120	230
		230				190
		280	0.08	0.18		170
		320				150
High alloy steel	X38 CrMoV 5 X210 CrW 12 X90 CrMoV 8	220	0.08	0.18	70	170
		280		150		
		320	0.15	130		
		350		100		
Austenitic Stainless Steel	303 / 304 304 L	Annealed	0.06	0.12	170	230
	316 / 316 L	Annealed	0.08	0.14	120	210
	316 Ti 630 (F16PH)	Annealed	0.1	0.16	70	120
Ferritic Stainless Steel	430 / 439 / 444	Annealed	0.08	0.14	150	210
Martensitic Stainless Steel	410 / 420	Annealed	0.08	0.14	150	210
		Treated			120	170
Grey Cast Iron	EN - GJL 200	140 to 230	0.1	0.22	150	230
	EN - GJL 250					210
	EN - GJL 300					170
Nodular Cast Iron	EN - GJS 400	210	0.1	0.18	120	200
	EN - GJS 600	260				170
	EN - GJS 800	310				150
Nickel based	Inconel 625	-----	0.06	0.12	25	35
	Inconel 718	-----			28	40
	Hastelloy C	-----			40	65
Titanium based	TiAl 6 V4	-----	0.06	0.12	35	60
	T40	-----			0.1	28