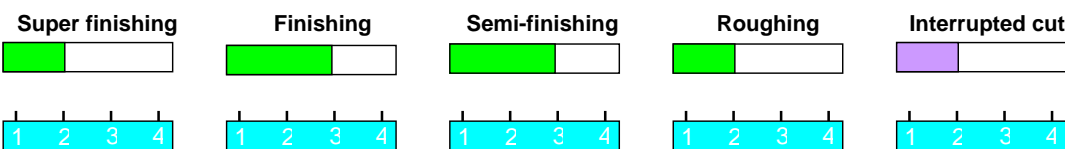


# WCMX 080412-NN

Material group	Group No	Material Examples	Hardness Brinell	feed [mm/rev]		Vc [m/min]	
				min	max	min	max
Low carbon Steel	1	XC 12 S 250 Pb	150	0.15	0.25	180	400
			180				350
			210				200
Alloy Steel	2	42 CrMo 4 100 Cr 6 32 NiCrMo 14.5	180	0.15	0.22	120	300
			230				250
			280	0.12	0.2		210
			320				180
High alloy Steel	3	X38 CrMoV 5 X210 CrW 12 X90 CrMoV 8	220	0.12	0.18	70	190
			280				150
			320				130
			350				100
Austenitic Stainless Steel	4	303 / 304 304 L	Annealed	0.12	0.25	170	270
	5	316 / 316 L	Annealed	0.12	0.23	120	210
	6	316 Ti 630 (F16PH)	Annealed	0.1	0.2	70	120
Ferritic Stainless Steel	7	430 / 439 444	Annealed	0.12	0.2	170	250
Martensitic Stainless Steel	8	410 / 420	Annealed	0.12	0.2	170	250
			Treated			120	210
Grey cast Iron	9	EN - GJL 200	140 à 230	0.15	0.28	170	280
		EN - GJL 250					250
		EN - GJL 300					230
Nodular Cast Iron	10	EN - GJS 400	210	0.12	0.23	120	230
		EN - GJS 600	260				190
		EN - GJS 800	310				150
Aluminum		Si < 4%	-----	Not recommended			
		4% < Si < 9%					
		Si > 9%					
Nickel based Alloys		Inconel 625	-----	0.12	0.18	25	35
		Inconel 718	-----			28	40
		Hastelloy C	-----			40	65
Titanium based Alloys		TiAl 6 V4	-----	0.12	0.18	35	60
		T40	-----		0.16	28	40



Conclusions: Super finishing good for the application  
 Finishing excellent for the application  
 Semi-finishing excellent for the application  
 Roughing good for the application  
 Interrupted cut good for the application