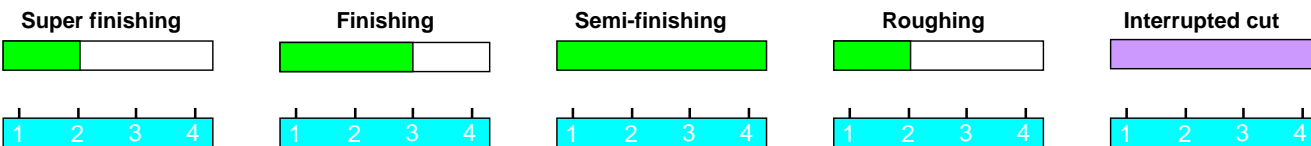


DNGG 110408-Alu

Material group	Group No	Material Examples	Hardness Brinell	d.o.c [mm]		feed [mm/t]		A max [mm ²]	Vc [m/min]		Recommended point	
				min	max	min	max		min	max	d.o.c	feed
Low carbon Steel	1	XC 12 S 250 Pb	150	----	----	----	----	----	----	----	----	----
			180									
			210									
Alloy Steel	2	42 CrMo 4 100 Cr 6 32 NiCrMo 14.5	180	----	----	----	----	----	----	----	----	----
			230									
			280									
			320									
High alloy Steel	3	X38 CrMoV 5 X210 CrW 12 X90 CrMoV 8	220	----	----	----	----	----	----	----	----	----
			280									
			320									
			350									
Austenitic Stainless Steel	4	303 / 304 304 L	Annealed	----	----	----	----	----	----	----	----	----
	5	316 / 316 L	Annealed									
	6	316 Ti 630 (F16PH)	Annealed									
Ferritic Stainless Steel	7	430 / 439 444	Annealed	----	----	----	----	----	----	----	----	----
Martensitic Stainless Steel	8	410 / 420	Annealed	----	----	----	----	----	----	----	----	----
			Treated									
Grey cast Iron	9	EN - GJL 200	140 à 230	----	----	----	----	----	----	----	----	----
		EN - GJL 250										
		EN - GJL 300										
Nodular Cast Iron	10	EN - GJS 400	210	----	----	----	----	----	----	----	----	----
		EN - GJS 600	260									
		EN - GJS 800	310									
Aluminum		Si < 4%	-----	0.25	5	0.12	0.6	2	400	1200	----	----
		4% < Si < 9%		0.25	5	0.1	0.5	1.8	250	800		
		Si > 9%		----	----	----	----	----	----	----	----	----
Nickel based Alloys		Inconle 625	-----	----	----	----	----	----	----	----	----	----
		Inconel 718	-----	----	----	----	----	----	----	----	----	----
		Hastelloy C	-----	----	----	----	----	----	----	----	----	----
Titanium based Alloys		TiAl 6 V4	-----	----	----	----	----	----	----	----	----	----
		T40	-----	----	----	----	----	----	----	----	----	----



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