ADLX 1505 PDTR

Material group	Group No	Material Examples	Hardness Brinell	d.o.c [mm]		feed [mm/t]		Vc [m/min]	
				min	max	min	max	min	max
Low carbon Steel	1	XC 12 S 250 Pb	150	0.5	14	0.18	0.3	180	400
			180						350
			210						200
Alloy Steel	2	42 CrMo 4 100 Cr 6 32 NiCrMo 14.5	180	0.5	14	0.15	0.25	120	300
			230						250
			280				0.22		210
			320						180
High alloy Steel	3	X38 CrMoV 5 X210 CrW 12 X90 CrMoV 8	220	0.5	14	0.12	0.22	70	190
			280						150
			320				0.18		130
			350						100
Austenitic Stainless Steel	4	303 / 304 304 L	Annealed	0.5	14	0.15	0.25	170	270
	5	316 / 316 L	Annealed		14	0.12	0.22	120	210
	6	316 Ti 630 (F16PH)	Annealed		14	0.12	0.18	70	120
Ferritic Stainless Steel	7	430 / 439 444	Annealed	0.5	14	0.15	0.25	170	250
Martensitic Stainless Steel	8	410 / 420	Annealed	0.5	14	0.15	0.25	170	250
			Treated					120	210
Grey cast Iron	9	EN - GJL 200	140 à 230	0.5	14	0.18	0.3	170	280
		EN - GJL 250							250
		EN - GJL 300							230
Nodular Cast Iron	10	EN - GJS 400	210	0.5	14	0.15	0.3	120	230
		EN - GJS 600	260				0.25		190
		EN - GJS 800	310				0.22		150
Aluminum		Si < 4%	---------	Not recommended					
		4% < Si < 9%							
		Si > 9%							
Nickel based Alloys		Inconel 625	--------	0.5	14	0.12	0.18	25	35
		Inconel 718	--------					28	40
		Hastelloy C	--------					40	65
Titanium based Alloys		TiAl 6 V4	--------	0.5	14	0.12	0.2	35	60
		T40	--------				0.18	28	40