

APLX 1003 PDTR

Material Group	Group No	Material Examples*	Brinell hardness	d.o.c [mm]		feed [mm/tooth]		V _c [m/min]				
				min	max	min	max	min	max			
Low Carbon Steel	1	Ck 15 9SMnPb28	150	0.50	9.00	0.10	0.25	190	300			
			180						260			
			210						220			
Alloy Steel	2	42 CrMo 4 100 Cr 6 32 NiCrMo 14.5	180	0.50	9.00	0.08	0.22	130	200			
			230						180			
			280				100	160				
			320					140				
High Alloy Steel	3	X38 CrMoV 5 X210 CrW 12 X90 CrMoV 8	220	0.50	7.00	0.08	0.18	90	130			
			280						110			
			320				60	95				
			350					80				
Austenitic Stainless Steel	4	303 / 304 304 L	Annealed	0.50	9.00	0.10	0.22	170	230			
	5	316 / 316 L	Annealed						0.10	0.20	170	210
	6	316 Ti 630 (F16PH)	Annealed						7.00	0.08	0.18	80
Ferritic Stainless Steel	7	430 / 439 / 444	Annealed	0.50	9.00	0.08	0.20	150	190			
Martensitic Stainless Steel	8	410 / 420	Annealed	0.50	9.00	0.08	0.20	130	210			
			Treated					90	150			
Grey Cast Iron	9	EN - GJL 200	140 to 230	0.50	9.00	0.10	0.25	150	240			
		EN - GJL 250							220			
		EN - GJL 300							190			
Nodular Cast Iron	10	EN - GJS 400	210	0.50	9.00	0.10	0.22	100	200			
		EN - GJS 600					0.20		160			
		EN - GJS 800					0.18		130			
Nickel Based Alloys	11	Inconel 625	-----	0.50	5.00	0.08	0.15	25	35			
		Inconel 718							38			
		Hastelloy C							65			
Titanium Based Alloys	12	TiAl 6 V4	-----	0.50	5.00	0.08	0.18	30	55			
		T40					0.15	22	35			

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

