

# ODMW 060508 TN

Material Group	Group No	Material Examples*	Brinell hardness	d.o.c [mm]		feed [mm/tooth]		V <sub>c</sub> [m/min]	
				min	max	min	max	min	max
Low Carbon Steel	1	Ck 15 9SMnPb28	150	0.50	4.00	0.15	0.38	190	350
			180						300
			210						260
Alloy Steel	2	42 CrMo 4 100 Cr 6 32 NiCrMo 14.5	180	0.50	4.00	0.15	0.32	130	240
			230						210
			280						190
			320						170
High Alloy Steel	3	X38 CrMoV 5 X210 CrW 12 X90 CrMoV 8	220	0.50	4.00	0.12	0.28	90	150
			280						130
			320						110
			350						90
Austenitic Stainless Steel	4	303 / 304 304 L	Annealed	ODMW inserts are not recommended for stainless steels					
	5	316 / 316 L	Annealed						
	6	316 Ti 630 (F16PH)	Annealed						
Ferritic Stainless Steel	7	430 / 439 / 444	Annealed	ODMW inserts are not recommended for stainless steels					
Martensitic Stainless Steel	8	410 / 420	Annealed Treated	ODMW inserts are not recommended for stainless steels					
Grey Cast Iron	9	EN - GJL 200	140 to 230	0.50	4.00	0.15	0.40	170	300
		EN - GJL 250							250
		EN - GJL 300							210
Nodular Cast Iron	10	EN - GJS 400	210	0.50	4.00	0.12	0.32	120	210
		EN - GJS 600	260						170
		EN - GJS 800	310						150
Nickel Based Alloys	11	Inconel 625	-----	ODMW inserts are not recommended for exotic's materials					
		Inconel 718							
		Hastelloy C							
Titanium Based Alloys	12	TiAl 6 V4	-----	ODMW inserts are not recommended for exotic's materials					
		T40							

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

