

OFMT 070405 TR

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	5.00	0.15	0.48	190	350			
			180						300			
			210						260			
Alloy Steel	2	42 CrMo 4 100 Cr 6 32 NiCrMo 14.5	180	0.50	5.00	0.15	0.45	150	240			
			230						210			
			280				130	190				
			320					170				
High Alloy Steel	3	X38 CrMoV 5 X210 CrW 12 X90 CrMoV 8	220	0.50	5.00	0.12	0.42	90	150			
			280						130			
			320				60	110				
			350					90				
Austenitic Stainless Steel	4	303 / 304 304 L	Annealed	0.50	5.00	0.12	0.35	170	250			
	5	316 / 316 L	Annealed						0.12	0.32	170	210
	6	316 Ti 630 (F16PH)	Annealed						0.12	0.28	80	130
Ferritic Stainless Steel	7	430 / 439 / 444	Annealed	0.50	5.00	0.12	0.35	150	210			
Martensitic Stainless Steel	8	410 / 420	Annealed	0.50	5.00	0.12	0.35	150	230			
			Treated					90	170			
Grey Cast Iron	9	EN - GJL 200	140 to 230	0.50	5.00	0.15	0.50	170	300			
		EN - GJL 250							250			
		EN - GJL 300							210			
Nodular Cast Iron	10	EN - GJS 400	210	0.50	5.00	0.12	0.45	120	210			
		EN - GJS 600					0.40		170			
		EN - GJS 800					0.35		150			
Nickel Based Alloys	11	Inconel 625	-----	-----	-----	-----	-----	-----	-----			
		Inconel 718							-----			
		Hastelloy C							-----			
Titanium Based Alloys	12	TiAl 6 V4	-----	0.50	5.00	0.12	0.35	35	60			
		T40					0.28	28	40			

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