

# SEKN 1504 AFTN

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	9.00	0.15	0.50	190	350	
			180						300	
			210						260	
Alloy Steel	2	42 CrMo 4 100 Cr 6 32 NiCrMo 14.5	180	0.50	9.00	0.15	0.45	150	240	
			230						210	
			280						190	
			320						170	
High Alloy Steel	3	X38 CrMoV 5 X210 CrW 12 X90 CrMoV 8	220	0.50	9.00	0.12	0.38	90	150	
			280						130	
			320						110	
			350						90	
Austenitic Stainless Steel	4	303 / 304 304 L	Annealed	0.50	7.00	0.12	0.35	170	250	
	5	316 / 316 L	Annealed						210	
	6	316 Ti 630 (F16PH)	Annealed						80	130
Ferritic Stainless Steel	7	430 / 439 / 444	Annealed	0.50	9.00	0.12	0.35	150	210	
Martensitic Stainless Steel	8	410 / 420	Annealed	0.50	9.00	0.12	0.35	150	230	
			Treated					90	170	
Grey Cast Iron	9	EN - GJL 200	140 to 230	0.50	9.00	0.15	0.60	170	300	
		EN - GJL 250							250	
		EN - GJL 300							210	
Nodular Cast Iron	10	EN - GJS 400	210	0.50	9.00	0.12	0.50	120	210	
		EN - GJS 600	260						170	
		EN - GJS 800	310						150	
Nickel Based Alloys	11	Inconel 625	-----	0.50	7.00	0.12	0.32	25	35	
		Inconel 718								28
		Hastelloy C								40
Titanium Based Alloys	12	TiAl 6 V4	-----	0.50	7.00	0.12	0.30	35	60	
		T40						28	40	

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

