

# SPKR 1203 EDTR SPKR 1204 EDTR

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	7.00	0.15	0.32	190	300				
			180						260				
			210						220				
Alloy Steel	2	42 CrMo 4 100 Cr 6 32 NiCrMo 14.5	180	0.50	7.00	0.15	0.30	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	0.12	0.25	90	130				
			280					110					
			320					60	95				
			350						80				
Austenitic Stainless Steel	4	303 / 304 304 L	210 to 250	0.50	5.00	0.12	0.25	170	230				
	5	316 / 316 L	230 to 270							0.12	0.20	170	210
	6	316 Ti 630 (F16PH)	-----										
Ferritic Stainless Steel	7	430 / 439 / 444	Annealed	0.50	5.00	0.12	0.25	150	190				
Martensitic Stainless Steel	8	410 / 420	Annealed	0.50	5.00	0.12	0.25	130	210				
			Treated					90	150				
Grey Cast Iron	9	EN - GJL 200	140 to 230	0.50	7.00	0.15	0.40	150	240				
		EN - GJL 250							220				
		EN - GJL 300							190				
Nodular Cast Iron	10	EN - GJS 400	210	0.50	7.00	0.12	0.32	100	200				
		EN - GJS 600	260						160				
		EN - GJS 800	310						130				
Nickel Based Alloys	11	Inconel 625	-----	Not recommended									
		Inconel 718											
		Hastelloy C											
Titanium Based Alloys	12	TiAl 6 V4	-----	Not recommended									
		T40											

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

