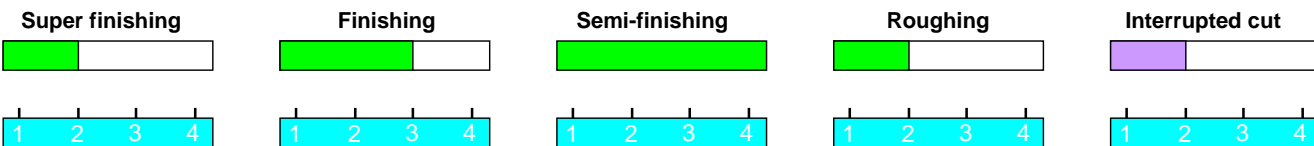


CBMT 0604048L-NN

Material group	Group No	Material Examples	Dureté Brinell	d.o.c [mm]		feed [mm/t]		A max [mm ²]	Vc [m/min]		Recommended point								
				min	max	min	max		min	max	d.o.c	feed							
Low carbon Steel	1	XC 12 S 250 Pb	150	0.5	4	0.21	0.45	1.2	180	400	0.5 to 2	0.18							
			180		3		0.4	0.9		350									
			210		3		0.35	0.9		200									
Alloy Steel	2	42 CrMo 4 100 Cr 6 32 NiCrMo 14.5	180	0.5	0.21	0.4	0.9	120	300	0.5 to 1.5	0.15								
			230			3	0.4		0.8			250							
			280		0.18	0.35	0.7		210										
			320			2.5	0.32		0.5			180							
High alloy Steel	3	X38 CrMoV 5 X210 CrW 12 X90 CrMoV 8	220	0.5	0.18	0.35	0.8	70	190	0.5 to 1.5	0.12								
			280			3	0.32		0.8			150							
			320			2.5	0.28		0.5			130							
			350			2	0.28		0.4			100							
Austenitic Stainless Steel	4	303 / 304 304 L	Annealed	0.5	0.2	0.35	0.8	170	270	0.5 to 2	0.15								
	5	316 / 316 L	Annealed									3	0.18	0.32	0.6	120	210	0.5 to 2	0.12
	6	316 Ti 630 (F16PH)	Annealed									3	0.18	0.28	0.5	70	120	0.5 to 2	0.12
Ferritic Stainless Steel	7	430 / 439 444	Annealed	0.5	3	0.22	0.35	0.7	170	250	1 to 2.5	0.15							
Martensitic Stainless Steel	8	410 / 420	Annealed	0.5	3	0.22	0.35	0.7	170	250	1 to 2.5	0.15							
			Treated						120	210									
Grey cast Iron	9	EN - GJL 200	140 à 230	0.5	4	0.15	0.4	1.2	170	280	0.5 to 2	0.18							
		EN - GJL 250						1.2		250									
		EN - GJL 300						1		230									
Nodular Cast Iron	10	EN - GJS 400	210	0.5	4	0.15	0.35	1	120	230	0.5 to 2	0.15							
		EN - GJS 600	260					0.9		190									
		EN - GJS 800	310					0.8		150									
Aluminum		Si < 4%	-----	----	----	----	----	----	----	----	----	----							
		4% < Si < 9%	-----	----	----	----	----	----	----	----	----	----							
		Si > 9%	-----	----	----	----	----	----	----	----	----	----							
Nickel based Alloys		Inconle 625	-----	0.5	3	0.2	0.32	0.6	28	25	0.5 to 1.5	0.12							
		Inconel 718	-----					0.6		40									
		Hastelloy C	-----					0.7		40			65						
Titanium based Alloys		TiAl 6 V4	-----	0.5	3	0.18	0.32	28	35	60	0.5 to 1.5	0.14							
		T40	-----				0.28		0.6	40		0.12							



Conclusions: Super finishing acceptable for the application
 Finishing good for the application
 Semi-finishing excellent for the application
 Roughing acceptable for the application
 Interrupted cut acceptable for the application