VNMG 160408 NN

	Material Group	Lamina Gr. N°	Material Examples	Hardness	DOC [mm]		Feed [mm/rev]		Amax [mm²]	Suggested Starting Parameters	
					min	max	min	max		DOC	Feed
P	Non Alloyed	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.70	3.50	0.25	0.65	2.16	2.60	0.48
				190 HB							0.44
				250 HB				0.59	1.80		0.41
	Low Alloyed	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB		3.50		0.59	1.44		0.40
				230 HB		2.80	0.25			2.60	
				280 HB				0.52			0.38
				350 HB		2.50	0.22		1.20	2.30	
	High Alloyed	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB		2.80		0.52	1.44	2.10	0.38
				280 HB	0.70		0.22				
				320 HB		2.10		0.46	0.96	1.90	0.35
				350 HB							
M	Austenitic	4	304, 316, X5CrNi18-9	180 HB	0.70	3.50	0.24	0.52	1.44	2.60	0.31
				240 HB					1.20		0.28
	Duplex	5	X2CrNiN23-4, S31500	290 HB	0.70	2.80	0.22	0.46	0.96	2.10	0.30
				310 HB							
	Ferritic & Martensitic	6	410, X6Cr17, 17-4PH, 430	200 HB	0.70	3.50	0.22	0.52	0.84	2.10	0.25
				42 HRc		2.80				1.90	
K	Grey	7	GG20, GG40, EN-GJL-250, N030B	150 HB	0.70	3.50	0.18	0.78	2.40	2.60	0.44
				200 HB					2.16		
				250 HB				0.72			
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.70	3.50	0.18	0.65	1.80	2.60	0.38
				200 HB					1.56		
				250 HB					1.44		
S	Fe, Ni & Co based	9	Incoloy 800	240 HB	0.70	2.10	0.24	0.46	0.84	1.70	0.35
			Inconel 700	250 HB							
			Stellite 21	350 HB							
	Ti based	10	T40	-	0.70	2.50	0.24	0.52	0.96	1.70	0.41
			TiAl6V4	-		2.10		0.46	0.84		0.38
H	Steel	11	X100 CrMo13, 440C, G-X260NiCr42	45 HRc	0.70	1.80	0.13	0.39	0.72	1.70	0.31
				50 HRc		1.40		0.33	0.48	1.30	0.25
				55 HRc		1.10		0.26	0.36	0.90	0.23
	Chilled Cast Iron		Ni-Hard 2	400 HB		1.40		0.33	0.48	1.30	
	White Cast Iron		G-X300CrMo15	55 HRc		1.10		0.26	0.36	0.90	0.19
NF	Aluminium	12	AlSi12	130 HB	0.70	4.20	0.24	0.78	2.16	2.60	0.50

The depth of cut and feed rate tables are for the geometry and corner radius specified above the table. Refer to cutting speed tables on pages 186 and 187 for recommended materials per grade.