RDMT 0702 M0

	Material Group	Lamina Gr. N°	Material Examples	Hardness	DOC [mm] min	DOC [mm] max	Feed [mm/z] min	Feed [mm/z] max	Suggested Starting Parameters DOC	Suggested Starting Parameters Feed
P	Non Alloyed	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.50	1.80	0.18	0.54	0.80	0.32
				190 HB						
				250 HB						
	Low Alloyed	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.50	1.80	0.15	0.43	0.80	0.28
				230 HB						
				280 HB				0.37		0.25
				350 HB						
	High Alloyed	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.50	1.30	0.12	0.37	0.60	0.25
				280 HB						
				320 HB				0.31		0.22
				350 HB						
M	Austenitic	4	304, 316, X5CrNi18-9	180 HB	0.50	1.80	0.15	0.43	0.80	0.28
				240 HB			0.12	0.37		
	Duplex	5	X2CrNiN23-4, S31500	290 HB	0.50	1.40	0.12	0.31	0.60	0.22
				310 HB						
	Ferritic & Martensitic	6	410, X6Cr17, 17-4PH, 430	200 HB	0.50	1.80	0.15	0.43	0.80	0.28
				42 HRc		1.40		0.34	0.60	0.22
K	Grey	7	GG20, GG40, EN-GJL-250, N030B	150 HB	0.50	1.80	0.18	0.54	0.80	0.32
				200 HB						
				250 HB						
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.50	1.80	0.15	0.48	0.80	0.28
				200 HB						
				250 HB						
S	Fe, Ni & Co based	9	Incoloy 800	240 HB	0.50	1.40	0.12	0.31	0.60	0.22
			Inconel 700	250 HB						
			Stellite 21	350 HB						
	Ti based	10	TiAl6V4	-	0.50	1.40	0.12	0.34	0.60	0.25
			T40	-				0.31		0.22
H	Steel	11	X100 CrMo13, 440C, G-X260NiCr42	45 HRc	0.30	0.60	0.10	0.31	0.40	0.20
				50 HRc		0.50		0.27	0.30	0.18
				55 HRc				0.24		0.17
	Chilled Cast Iron		Ni-Hard 2	400 HB				0.31		0.20
	White Cast Iron		G-X300CrMo15	55 HRc				0.24		0.17
NF	Aluminium	12	AlSi12	130 HB	0.50	1.80	0.18	0.54	0.80	0.35

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 page 226 for recommended materials per grade.