BALL NOSE, 2 FLUTE | LT 4000 - Ø 1 - 6, 8, 10, 12

	Material Group	Lamina Gr. N°	Material Examples	Hardness	Profiling		Slotting	fz [mm/tooth]								
					ap	ae	ap	Ø 1	Ø 2	Ø 3	Ø 4	Ø 5	Ø 6	Ø 8	Ø 10	Ø 12
P	Non Alloyed	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	1.5xØ	0.5xØ	1.0xØ	0.035	0.045	0.065	0.080	0.105	0.100	0.115	0.125	0.140
				190 HB												
				250 HB												
	Low Alloyed	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	1.5xØ	0.5xØ	1.0xØ	0.033	0.042	0.061	0.075	0.099	0.094	0.108	0.118	0.132
				230 HB												
				280 HB			0.7xØ	0.028	0.036	0.052	0.064	0.084	0.080	0.092	0.100	0.112
				350 HB												
	High Alloyed	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	1.5xØ	0.5xØ	1.0xØ	0.028	0.036	0.051	0.063	0.083	0.079	0.091	0.099	0.111
				280 HB												
				320 HB			0.6xØ	0.021	0.027	0.039	0.048	0.063	0.060	0.069	0.075	0.084
				350 HB												
M	Austenitic	4	304, 316, X5CrNi18-9	180 HB	1.5xØ	0.5xØ	1.0xØ	0.023	0.029	0.042	0.052	0.068	0.065	0.075	0.081	0.091
				240 HB												
	Duplex	5	X2CrNiN23-4, S31500	290 HB	1.5xØ	0.5xØ	1.0xØ	0.018	0.023	0.033	0.040	0.053	0.050	0.058	0.063	0.070
				310 HB												
	Ferritic & Martensitic	6	410, X6Cr17, 17-4PH, 430	200 HB	1.5xØ	0.5xØ	1.0xØ	0.024	0.031	0.044	0.054	0.071	0.068	0.078	0.085	0.095
				42 HRc												
K	Grey	7	GG20, GG40, EN-GJL-250, N030B	150 HB	1.5xØ	0.5xØ	1.0xØ	0.039	0.050	0.072	0.088	0.116	0.110	0.127	0.138	0.154
				200 HB												
				250 HB												
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	1.5xØ	0.5xØ	1.0xØ	0.033	0.043	0.062	0.076	0.100	0.095	0.109	0.119	0.133
				200 HB												
				250 HB												
S	Fe, Ni & Co based	9	Incoloy 800	240 HB	1.5xØ	0.3xØ	1.0xØ	0.022	0.029	0.042	0.051	0.067	0.064	0.074	0.080	0.090
			Inconel 700	250 HB												
			Stellite 21	350 HB												
	Ti based	10	T40	-	1.5xØ	0.5xØ	1.0xØ	0.019	0.025	0.036	0.044	0.058	0.055	0.063	0.069	0.077
			TiAl6V4	-												
H	Steel	11	X100CrMo13, 440C, G-X260NiCr42	45 HRc	1.5xØ	0.3xØ	0.2xØ	0.014	0.018	0.026	0.032	0.042	0.040	0.046	0.050	0.056
				50 HRc												
				55 HRc		0.2xØ	0.1xØ	0.011	0.014	0.020	0.024	0.032	0.030	0.035	0.038	0.042
	Chilled Cast Iron	12	Ni-Hard 2	400 HB	1.5xØ	0.2xØ	0.1xØ	0.011	0.014	0.020	0.024	0.032	0.030	0.035	0.038	0.042
	White Cast Iron	13	G-X300CrMo15	55 HRc	1.5xØ	0.2xØ	0.1xØ	0.011	0.014	0.020	0.024	0.032	0.030	0.035	0.038	0.042
NF	Aluminium	14	AlSi12	130 HB	1.5xØ	0.5xØ	1.0xØ	0.035	0.045	0.065	0.080	0.105	0.100	0.115	0.125	0.140

ROUGHER, 3 – 4 FLUTE | LT 4000 - Ø 4 - 6, 8, 10, 12

	Material Group	Lamina Gr. N°	Material Examples	Hardness	Profiling		Slotting	fz [mm/tooth]				
					ap	ae	ap	Ø 4 (Z3)	Ø 5	Ø 6	Ø 8	Ø 10	Ø 12
P	Non Alloyed	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	1.5xØ	0.5xØ	1.0xØ	0.024	0.030	0.040	0.055	0.065	0.077
				190 HB									
				250 HB									
	Low Alloyed	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	1.5xØ	0.5xØ	1.0xØ	0.025	0.030	0.039	0.053	0.063	0.074
				230 HB									
				280 HB			0.7xØ	0.020	0.024	0.032	0.043	0.052	0.062
				350 HB									
	High Alloyed	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	1.5xØ	0.5xØ	1.0xØ	0.021	0.026	0.033	0.046	0.055	0.064
				280 HB									
				320 HB			0.6xØ	0.016	0.020	0.025	0.035	0.041	0.049
				350 HB									
M	Austenitic	4	304, 316, X5CrNi18-9	180 HB	1.5xØ	0.5xØ	1.0xØ	0.017	0.022	0.028	0.038	0.045	0.053
				240 HB									
	Duplex	5	X2CrNiN23-4, S31500	290 HB	1.5xØ	0.5xØ	1.0xØ	0.013	0.017	0.021	0.029	0.035	0.040
				310 HB									
	Ferritic & Martensitic	6	410, X6Cr17, 17-4PH, 430	200 HB	1.5xØ	0.5xØ	1.0xØ	0.013	0.017	0.021	0.029	0.035	0.040
				42 HRc									
K	Grey	7	GG20, GG40, EN-GJL-250, N030B	150 HB	1.5xØ	0.5xØ	1.0xØ	0.029	0.036	0.047	0.064	0.076	0.089
				200 HB									
				250 HB									
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	1.5xØ	0.5xØ	1.0xØ	0.025	0.031	0.040	0.055	0.066	0.077
				200 HB									
				250 HB									
S	Fe, Ni & Co based	9	Incoloy 800	240 HB	1.5xØ	0.3xØ	1.0xØ	0.014	0.018	0.023	0.031	0.037	0.044
			Inconel 700	250 HB									
			Stellite 21	350 HB									
	Ti based	10	T40	-	1.5xØ	0.5xØ	1.0xØ	0.015	0.018	0.023	0.032	0.038	0.045
			TiAl6V4	-									
H	Steel	11	X100CrMo13, 440C, G-X260NiCr42	45 HRc	1.5xØ	0.3xØ	0.2xØ	0.011	0.013	0.017	0.023	0.028	0.032
				50 HRc									
				55 HRc		0.2xØ	0.1xØ	0.008	0.010	0.013	0.017	0.021	0.024
	Chilled Cast Iron	12	Ni-Hard 2	400 HB	1.5xØ	0.2xØ	0.1xØ	0.008	0.010	0.013	0.017	0.021	0.024
	White Cast Iron	13	G-X300CrMo15	55 HRc	1.5xØ	0.2xØ	0.1xØ	0.008	0.010	0.013	0.017	0.021	0.024
NF	Aluminium	14	AlSi12	130 HB	1.5xØ	0.5xØ	1.0xØ	0.027	0.033	0.042	0.058	0.069	0.081