

Material Group	Group No	Material Examples*	Brinell hardness	d.o.c [mm]		feed [mm/tooth]		V _c [m/min]							
				min	max	min	max	min	max						
Low Carbon Steel	1	Ck 15 9SMnPb28	150	0.5	4.0	0.28	0.52	190	350						
			180		4.0		0.52		300						
			210		4.0		0.52		260						
Alloy Steel	2	42 CrMo 4 100 Cr 6 32 NiCrMo 14.5	180	0.5	4.0	0.25	0.48	150	240						
			230		4.0		0.48		210						
			280	0.5	4.0	0.25	0.42	130	190						
			320		4.0		0.42		170						
High Alloy Steel	3	X38 CrMoV 5 X210 CrW 12 X90 CrMoV 8	220	0.5	4.0	0.23	0.38	90	150						
			280		4.0		0.38		130						
			320	0.5	4.0	0.23	0.32	60	110						
			350		4.0		0.32		90						
Austenitic Stainless Steel	4	303 / 304 304 L	210 to 250	ODMW inserts are not recommended for stainless steels											
	5	316 / 316 L	230 to 270												
	6	316 Ti 630 (F16PH)	-----												
Ferritic Stainless Steel	7	430 / 439 / 444	Annealed												
Martensitic Stainless Steel	8	410 / 420	Annealed												
			Treated												
Grey Cast Iron	9	EN - GJL 200	140 to 230	0.5	4.0	0.25	0.60	170	300						
		EN - GJL 250							250						
		EN - GJL 300							210						
Nodular Cast Iron	10	EN - GJS 400	210	0.5	4.0	0.23	0.50	120	210						
		EN - GJS 600	260						170						
		EN - GJS 800	310						150						
Nickel Based Alloys	11	Inconel 625	-----	ODMW inserts are not recommended for exotic materials											
		Inconel 718													
		Hastelloy C													
Titanium Based Alloys	12	TiAl 6 V4	-----												
		T40													

*For all material types and standards, see pages 240 to 245.