

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	5.0	0.18	0.32	190	350					
			180		5.0		0.32		300					
			210		5.0		0.32		260					
Alloy Steel	2	42 CrMo 4 100 Cr 6 32 NiCrMo 14.5	180	0.5	5.0	0.15	0.30	150	240					
			230		5.0		0.30		210					
			280	0.5	5.0	0.15	0.30	130	190					
			320		5.0		0.30		170					
High Alloy Steel	3	X38 CrMoV 5 X210 CrW 12 X90 CrMoV 8	220	0.5	5.0	0.12	0.25	90	150					
			280		5.0		0.25		130					
			320	0.5	3.5	0.12	0.25	60	110					
			350		3.5		0.25		90					
Austenitic Stainless Steel	4	303 / 304 304 L	210 to 250	0.5	5.0	0.18	0.32	170	250					
			230 to 270						0.5	5.0	0.15	0.28	160	210

Ferritic Stainless Steel	7	430 / 439 / 444	Annealed	0.5	5.0	0.12	0.32	150	210					
Martensitic Stainless Steel	8	410 / 420	Annealed	0.5	5.0	0.12	0.32	150	230					
			Treated	0.5	5.0	0.12	0.25	90	170					
Grey Cast Iron	9	EN - GJL 200	140 to 230	0.5	5.0	0.15	0.40	170	300					
		EN - GJL 250							250					
		EN - GJL 300							210					
Nodular Cast Iron	10	EN - GJS 400	210	0.5	5.0	0.12	0.32	120	210					
		EN - GJS 600	260						170					
		EN - GJS 800	310						150					
Nickel Based Alloys	11	Inconel 625	-----	0.5	3.5	0.12	0.28	25	35					
		Inconel 718							28	40				
		Hastelloy C							40	60				
Titanium Based Alloys	12	TiAl 6 V4	-----	0.5	3.5	0.12	0.28	35	60					
		T40					0.28	28	40					

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