

| Material Group | Group No | Material Examples* | Brinell hardness | feed [mm/rev] | | V _c [m/min] | |
|-----------------------------|----------|---|------------------|---------------|------|------------------------|-----|
| | | | | min | max | min | max |
| Low Carbon Steel | 1 | Ck15, Ck45 1020, 1045 | 150 | 0.05 | 0.10 | 180 | 270 |
| | | | 180 | | | | 230 |
| | | | 210 | | | | 200 |
| Alloy Steel | 2 | 42 CrMo 4 St 50-2 Ck60 1060 4140 | 180 | 0.05 | 0.12 | 120 | 240 |
| | | | 230 | | | | 190 |
| | | | 280 | 0.05 | 0.13 | 120 | 170 |
| | | | 320 | | | | 150 |
| High Alloy Steel | 3 | X40 CrMoV 5 1 H 13 40 NiCrMo 6 4340 S 2-10-1-8 HSS M42 | 220 | 0.07 | 0.13 | 70 | 170 |
| | | | 280 | | | | 150 |
| | | | 320 | 0.07 | 0.11 | 70 | 130 |
| | | | 350 | | | | 100 |
| | | | 400 | 0.07 | 0.14 | 70 | 120 |
| | | | 480 | | | | 100 |
| 550 | 80 | | | | | | |
| Austenitic Stainless Steel | 4 | X5 CrNi 18 9 304 | 210 to 250 | 0.05 | 0.11 | 170 | 230 |
| | 5 | X2 CrNiMo 17 2 2 316 | 230 to 270 | 0.07 | 0.12 | 120 | 210 |
| | 6 | X6 CrNiMoTi 17 12 2 316 Ti Duplex / Nitronic | ----- | 0.08 | 0.12 | 70 | 120 |
| Ferritic Stainless Steel | 7 | X8 Cr 7 430 | Annealed | 0.07 | 0.11 | 150 | 210 |
| Martensitic Stainless Steel | 8 | X15 Cr 13 410 | Annealed | 0.07 | 0.11 | 150 | 210 |
| | | | Treated | 0.07 | 0.11 | 120 | 170 |
| Grey Cast Iron | 9 | GG 20 | 140 to 230 | 0.10 | 0.14 | 150 | 230 |
| | | GG 25 | | | | | 210 |
| | | GG 30 | | | | | 170 |
| Nodular Cast Iron | 10 | GGG 40 | 210 | 0.10 | 0.14 | 120 | 200 |
| | | GGG 50 | 260 | | | | 170 |
| | | GGG 70 | 310 | | | | 150 |
| | | G-X260NiCr42 | 450 | 0.10 | 0.16 | 120 | 150 |
| Nickel Based Alloys | 11 | Inconel 625 | ----- | 0.05 | 0.10 | 25 | 35 |
| | | Inconel 718 | | | | | |
| | | Hastelloy C | | | | | |
| Titanium Based Alloys | 12 | TiAl 6 V4 | ----- | 0.05 | 0.10 | 35 | 60 |
| | | T40 | | | | | 28 |