

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	Ck15, Ck45 1020, 1045	150	0.5	4	0.28	0.52	190	350
			180		4		0.52		300
			210		4		0.52		260
Alloy Steel	2	42 CrMo 4 St 50-2 Ck60 1060 4140	180	0.5	4	0.25	0.48	150	240
			230		4		0.48		210
			280	0.5	4	0.25	0.42	130	190
			320		4		0.42		170
High Alloy Steel	3	X40 CrMoV 5 1 H 13 40 NiCrMo 6 4340 S 2-10-1-8 HSS M42	220	0.5	4	0.23	0.38	90	150
			280		4		0.38		130
			320	0.5	4	0.23	0.32	60	110
			350		4		0.32		90
			400	0.5	3	0.14	0.25	40	80
			480		2		0.22		70
			550		1		0.2		60
Austenitic Stainless Steel	4	X5 CrNi 18 9 304	210 to 250	ODMW inserts are not recommended for Stainless Steel					
	5	X2 CrNiMo 17 2 2 316	230 to 270						
	6	X6 CrNiMoTi 17 12 2 316 Ti Duplex / Nitronic	-----						
Ferritic Stainless Steel	7	X8 Cr 7 430	Annealed						
Martensitic Stainless Steel	8	X15 Cr 13 410	Annealed Treated						
Grey Cast Iron	9	GG 20	140 to 230	0.5	4	0.25	0.6	170	300
		GG 25							250
		GG 30							210
Nodular Cast Iron	10	GGG 40	210	0.5	4	0.23	0.5	120	210
		GGG 50	260						170
		GGG 70	310						150
		G-X260NiCr42	450						0.5
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							