

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	9	0.18	0.38	190	350
			180		9		0.38		300
			210		9		0.38		260
Alloy Steel	2	42 CrMo 4 St 50-2 Ck60 1060 4140	180	0.5	9	0.15	0.35	150	240
			230		9		0.35		210
			280	0.5	9	0.15	0.32	130	190
			320		9		0.32		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	9	0.12	0.32	90	150
			280		9		0.32		130
			320	0.5	9	0.12	0.28	60	110
			350		9		0.28		90
			400	0.5	6	0.1	0.22	40	80
			480		3		0.2		70
			550		1.5		0.28		60
Austenitic Stainless Steel	4	X5 CrNi 18 9 304	210 to 250	SPKN 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	9	0.15	0.38	170	300
		GG 25							250
		GG 30							210
Nodular Cast Iron	10	GGG 40	210	0.5	9	0.12	0.3	120	210
		GGG 50	260						170
		GGG 70	310						150
		G-X260NiCr42	450	0.5	3	0.1	0.2	30	60
Nickel Based Alloys	11	Inconel 625	-----	SPKN inserts are not recommended for Exotic materials					
		Inconel 718							
		Hastelloy C							
Titanium Based Alloys	12	TiAl 6 V4	-----	SPKN inserts are not recommended for Exotic materials					
		T40							