

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	7	0.18	0.32	180	300						
			180		7		0.32		260						
			210		7		0.32		220						
Alloy Steel	2	42 CrMo 4 St 50-2 Ck60 1060 4140	180	0.5	7	0.15	0.28	130	200						
			230		7		0.28		180						
			280	0.5	7	0.15	0.25	100	160						
			320		7		0.25		140						
High Alloy Steel	3	X40 CrMoV 5 1 H 13 40 NiCrMo 6 4340 S 2-10-1-8 HSS M42	220	0.5	7	0.12	0.27	90	130						
			280		7		0.27		110						
			320	0.5	7	0.12	0.23	60	95						
			350		7		0.23		80						
			400	0.5	5	0.1	0.18	40	80						
			480		3		0.16		70						
			550		1.5		0.14		60						
Austenitic Stainless Steel	4	X5 CrNi 18 9 304	210 to 250	SPUN 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	7	0.15	0.35	150	240
		GG 25													220
		GG 30													190
Nodular Cast Iron	10	GGG 40	210	0.5	7	0.12	0.28	100	200						
		GGG 50	260						160						
		GGG 70	310						130						
		G-X260NiCr42	450						0.5	3	0.1	0.14	30	60	
Nickel Based Alloys	11	Inconel 625	-----	SPUN inserts are not recommended for Exotic materials											
		Inconel 718													
		Hastelloy C													
Titanium Based Alloys	12	TiAl 6 V4	-----												
		T40													