

Material Group	Lamina Group	Material Example	Hardness	Feed		Vc		Advised Feed	Advised Vc
				min [mm/t]	max [mm/t]	min [m/min]	max [m/min]	[mm/t]	[m/mln]
Non Alloyed	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.05	0.1	180	270	0.08	225
			190 HB	0.05	0.1	180	230	0.08	205
			250 HB	0.05	0.1	180	200	0.08	190
Low Alloyed	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.05	0.1	120	230	0.08	175
			230 HB	0.05	0.1	120	190	0.08	155
			280 HB	0.05	0.1	100	170	0.07	135
			350 HB	0.05	0.1	100	150	0.07	125
High Alloyed	3	X40CrMOV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.07	0.1	70	170	0.09	120
			280 HB	0.07	0.1	70	150	0.09	110
			320 HB	0.07	0.09	60	130	0.08	95
			350 HB	0.07	0.09	60	100	0.08	80
Austentic	4	304, 316, X5CrNi18-9	180 HB	0.05	0.1	170	230	0.07	200
			240 HB	0.07	0.1	120	210	0.08	165
Duplex	5	X2CrNiN23-4, S31500	290 HB	0.07	0.09	70	120	0.08	95
			310 HB	0.07	0.09	70	120	0.08	95
Ferritic & Martensitic	6	410, X6Cr17, 17-4 PH, 430	200 HB	0.07	0.09	100	150	0.08	125
			388 HB	0.05	0.08	60	100	0.07	80
Grey	7	GG20, GG40, EN-GJL-250, N030B	150 HB	0.09	0.11	150	230	0.1	190
			200 HB	0.09	0.11	150	210	0.1	180
			250 HB	0.09	0.11	150	170	0.1	160
Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.09	0.11	120	200	0.1	160
			200 HB	0.09	0.11	120	170	0.1	145
			250 HB	0.09	0.11	120	150	0.1	135
Fe, Ni & Co Based	9	Incoloy 800	240 HB	0.05	0.08	25	35	0.07	30
			250 HB	0.05	0.08	25	35	0.07	30
			350 HB	0.05	0.08	23	35	0.07	29
Steel Chilled Cast Iron White Cast Iron	11	X100CrMo13, 440C, G-X260NiCr42	419 HB	0.05	0.08	50	90	0.07	70
			469 HB	0.05	0.08	40	70	0.07	55
			552 HB	0.05	0.08	30	60	0.07	45
			400 HB	0.05	0.08	40	60	0.07	50
			552 HB	0.05	0.08	30	50	0.07	40
Al (>8%Si)	12	AISI12	130 HB	0.05	0.1	200	400	0.08	300



Steel



Stainless steel



Cast iron



High temp alloys



Hardened material



ALU