

Material Group	Lamina Group	Material Example	Hardness	D.O.C.		Feed		Amax [mm ²]	Vc		Advised D.O.C. [mm]	Advised Feed [mm/t]	Advised Vc [m/mln]
				min [mm]	max [mm]	min [mm/t]	max [mm/t]		min [m/mm]	max [m/mm]			
Non Alloyed	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.30	3.6	0.13	0.35	0.84	110	220	2	0.2	160
			190 HB	0.30	3.0	0.13	0.33	0.73	110	180	2	0.2	150
			250 HB	0.30	3.0	0.13	0.3	0.67	110	170	2	0.2	140
Low Alloyed	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.30	3.0	0.12	0.3	0.7	70	180	2	0.17	130
			230 HB	0.30	3.0	0.12	0.3	0.67	70	170	2	0.17	120
			280 HB	0.30	2.4	0.12	0.27	0.56	70	140	2	0.17	110
			350 HB	0.30	2.4	0.12	0.27	0.5	70	120	2	0.17	100
High Alloyed	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.30	3.0	0.11	0.27	0.56	40	130	2	0.13	80
			280 HB	0.30	3.0	0.11	0.24	0.56	40	100	2	0.13	70
			320 HB	0.30	2.4	0.11	0.21	0.45	40	90	2	0.13	60
			350 HB	0.30	2.4	0.11	0.21	0.36	40	70	2	0.13	60
Austentic	4	304, 316, X5CrNi18-9	180 HB	0.30	3.0	0.12	0.27	0.45	100	180	2	0.13	140
			240 HB	0.30	3.0	0.12	0.27	0.36	100	150	2	0.13	120
Duplex	5	X2CrNiN23-4, S31500	290 HB	0.30	2.4	0.11	0.21	0.28	50	100	2	0.13	80
			310 HB	0.30	2.4	0.11	0.21	0.28	40	90	2	0.13	70
Ferritic & Martensitic	6	410, X6Cr17, 17-4 PH, 430	200 HB	0.30	3.0	0.12	0.27	0.45	100	170	2	0.15	110
			388 HB	0.30	2.4	0.12	0.24	0.36	70	130	2	0.13	70
Grey	7	GG20, GG40, EN-GJL-250, N030B	150 HB	0.30	3.6	0.1	0.3	0.9	100	170	2	0.2	130
			200 HB	0.30	3.6	0.1	0.3	0.84	100	150	2	0.2	130
			250 HB	0.30	3.6	0.1	0.3	0.84	90	140	2	0.2	120
Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.30	3.0	0.1	0.27	0.67	70	170	2	0.17	120
			200 HB	0.30	3.0	0.1	0.27	0.56	70	150	2	0.17	110
			250 HB	0.30	3.0	0.1	0.27	0.56	70	130	2	0.17	100
Fe, Ni & Co Based	9	Incoloy 800	240 HB	0.30	2.4	0.11	0.23	0.36	20	40	2	0.13	20
			250 HB	0.30	2.4	0.11	0.23	0.36	20	40	2	0.13	20
			350 HB	0.30	2.4	0.11	0.23	0.36	20	30	2	0.13	20
Steel Chilled Cast Iron White Cast Iron	11	X100CrMo13, 440C, G-X260NiCr42	419 HB	0.30	2.2	0.06	0.18	0.28	30	70	1.5	0.12	50
			469 HB	0.30	1.8	0.06	0.15	0.24	30	60	1.2	0.1	40
			552 HB	0.30	1.7	0.06	0.14	0.18	30	50	1	0.08	40
			400 HB	0.30	1.9	0.06	0.18	0.24	30	40	1.2	0.12	30
			552 HB	0.30	1.7	0.06	0.14	0.18	20	40	1	0.08	30
Al (>8%Si)	12	AlSi12	130 HB	0.30	4.8	0.12	0.45	0.98	120	260	2	0.22	190



Steel



Stainless steel



Cast iron



High temp alloys



Hardened material



ALU