

M0004296 APKT 0602-HF LT 3000													D.O.C		Feed		Vc		Advised D.O.C	Advised Feed	Advised Vc
Material Group	Gr. N°	VDI	Material Example	Hardness	min[mm]	max[mm]	min[mm/t]	max[mm/t]	min [m/min]	max [m/min]	[mm]	[mm/t]	[m/min]								
Steel	Non Alloyed	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.20	0.50	0.20	1.40	190	330	0.50	1.00	250								
		2	C35, Ck45, 1020, 1045, 1060, 28Mn6	190 HB	0.20	0.50	0.20	1.40	190	300	0.50	1.00	220								
		3	C35, Ck45, 1020, 1045, 1060, 28Mn6	250 HB	0.20	0.50	0.20	1.40	190	250	0.50	1.00	200								
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.20	0.50	0.20	1.30	150	240	0.40	0.80	200							
			4,6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	230 HB	0.20	0.50	0.20	1.30	150	210	0.40	0.80	180							
			5,7	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	280 HB	0.20	0.50	0.20	1.30	130	190	0.40	0.70	150							
			8	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	350 HB	0.20	0.50	0.20	1.30	130	170	0.40	0.70	140							
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.20	0.40	0.20	1.10	90	150	0.40	0.70	130							
					280 HB	0.20	0.40	0.20	1.10	90	130	0.40	0.70	120							
			11	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	320 HB	0.20	0.40	0.20	1.10	60	110	0.40	0.60	100							
					350 HB	0.20	0.40	0.20	1.10	60	90	0.40	0.60	80							
Stainless Steel	Austenitic	4	304, 316, X5CrNi18-9	180 HB	0.20	0.40	0.20	0.70	190	250	0.40	0.50	220								
				240 HB	0.20	0.40	0.20	0.70	160	210	0.40	0.50	190								
	Duplex	5	X2CrNiN23-4, S31500	290 HB	0.20	0.40	0.20	0.50	70	130	0.40	0.35	100								
				310 HB	0.20	0.40	0.20	0.50	70	120	0.40	0.35	90								
	Ferritic & Martensitic	6	410, X6Cr17, 17-4 PH, 430	200 HB	0.20	0.40	0.20	0.50	150	210	0.40	0.40	190								
				42 HRC	0.20	0.40	0.20	0.50	90	150	0.40	0.30	130								
Cast Iron	Grey	7	GG20, GG40, EN-GJL-250, N030B	150 HB	0.20	0.50	0.20	1.40	150	240	0.50	1.00	200								
				200 HB	0.20	0.50	0.20	1.40	150	220	0.50	1.00	180								
				250 HB	0.20	0.50	0.20	1.40	150	190	0.50	1.00	160								
	Malleable & Nodular	8	17,19 GGG40, GGG70, 50005	150 HB	0.20	0.50	0.20	1.20	100	200	0.50	0.90	180								
				200 HB	0.20	0.50	0.20	1.20	100	180	0.50	0.90	150								
				250 HB	0.20	0.50	0.20	1.20	100	150	0.40	0.90	130								
NiTi Alloy	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	0.20	0.40	0.20	0.50	30	50	0.30	0.30	32							
			33	Inconel 700	250 HB	0.20	0.40	0.20	0.50	30	50	0.30	0.30	30							
			34	Stellite 21	350 HB	0.20	0.40	0.20	0.50	30	50	0.30	0.30	30							
	Ti Based	10	36	TiAl6V4	-	0.20	0.40	0.20	0.40	40	70	0.30	0.30	55							
			37	T40	-	0.20	0.40	0.20	0.40	30	60	0.30	0.30	40							
Hardened Materials	Steel Chilled Cast Iron White Cast Iron	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRC	0.20	0.40	0.20	0.70	40	80	0.40	0.40	60							
					50 HRC	0.20	0.30	0.20	0.60	40	70	0.20	0.30	55							
					55 HRC	0.20	0.30	0.20	0.50	40	60	0.20	0.30	50							
		40	Ni-Hard 2	400 HB	0.20	0.30	0.20	0.50	40	80	0.20	0.30	50								
		41	G-X300CrMo15	55 HRC	0.20	0.30	0.20	0.50	30	60	0.20	0.30	40								
Alu mi	AI (~90%Si)	12	25	AlSi12	130 HB	0.20	0.50	0.20	0.70	200	400	0.50	0.60	280							