

Material Group	SAPPHIRE CUTTING TOOLS Group	Material Example	Hardness	D.O.C		Feed		Amax [mm ²]	Vc		Advised D.O.C [mm]	Advised Feed [mm/t]	Advised Vc [m/min]	
				min[mm]	max[mm]	min[mm/t]	max [mm/t]		min [m/min]	max [m/min]				
Steel	Non Alloyed	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.5	5	0.26	0.7	2.41	180	330	3	0.51	240	
			190 HB	0.5	5	0.26	0.7	2.41	180	280	3	0.47	220	
			250 HB	0.5	5	0.26	0.63	2.01	180	250	3	0.45	200	
	Low Alloyed	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	230 HB	0.5	4	0.26	0.63	1.61	120	250	3	0.43	180
				280 HB	0.5	4	0.22	0.56	1.61	120	210	3	0.41	150
				180 HB	0.5	5	0.26	0.63	1.61	120	280	3	0.43	200
				350 HB	0.5	3.5	0.22	0.56	1.34	120	180	2.7	0.41	130
	High Alloyed	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	4	0.22	0.56	1.61	70	190	2.5	0.41	140
				280 HB	0.5	4	0.22	0.56	1.61	70	150	2.5	0.41	120
				320 HB	0.5	3	0.22	0.49	1.07	70	130	2.2	0.38	100
				350 HB	0.5	3	0.22	0.49	1.07	70	110	2.2	0.38	90
	Stainless Steel	Austenitic	304, 316, X5CrNi18-9	180 HB	0.5	5	0.25	0.56	1.61	170	270	3	0.34	190
240 HB				0.5	5	0.25	0.56	1.34	160	220	3	0.3	170	
Duplex		X2CrNiN23-4, S31500	290 HB	0.5	4	0.22	0.49	1.07	80	150	2.5	0.32	100	
			310 HB	0.5	4	0.22	0.49	1.07	70	140	2.5	0.32	90	
Ferritic & Martensitic		6	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	5	0.22	0.56	0.94	170	250	2.5	0.27	190
				42 HRc	0.5	4	0.22	0.56	0.94	120	190	2.2	0.27	130
Cast Iron	Grey	GG20, GG40, EN-GJL-250, N030B	150 HB	0.5	5	0.18	0.84	2.68	170	250	3	0.47	200	
			200 HB	0.5	5	0.18	0.84	2.41	160	230	3	0.47	180	
			250 HB	0.5	5	0.18	0.77	2.41	150	210	3	0.47	160	
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.5	5	0.18	0.7	2.01	120	250	3	0.41	180
				200 HB	0.5	5	0.18	0.7	1.74	120	230	3	0.41	160
				250 HB	0.5	5	0.18	0.7	1.61	120	190	3	0.41	140
NITI Alloy	Fe, Ni & Co Based	9	Incoloy 800	240 HB	0.5	3	0.25	0.49	0.94	30	50	2	0.38	30
			Inconel 700	250 HB	0.5	3	0.25	0.49	0.94	30	50	2	0.38	30
			Stellite 21	350 HB	0.5	3	0.25	0.49	0.94	30	40	2	0.38	30
	Ti Based	10	T40	-	0.5	3	0.25	0.49	0.94	40	60	2	0.41	45
			TiAl6V4	-	0.5	3.5	0.25	0.56	1.07	50	70	2	0.45	55
Hardened Materials	Steel Chilled Cast Iron White Cast Iron	11	G- X300CrMo15	55 HRc	0.5	1.5	0.14	0.28	0.4	30	50	1	0.2	40
			Ni-Hard 2	400 HB	0.5	2	0.14	0.35	0.54	40	60	1.5	0.24	50
			X100CrMo13, 440C, G- X260NiCr42	45 HRc	0.5	2.5	0.14	0.42	0.8	50	100	2	0.34	80
				50 HRc	0.5	2	0.14	0.35	0.54	40	90	1.5	0.27	70
				55 HRc	0.5	1.5	0.14	0.28	0.4	40	80	1	0.24	60
Aluminium	Al (>8%Si)	12	AlSi12	130 HB	0.5	6	0.25	0.84	2.41	200	400	3	0.54	280