

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	0.21	0.48	1.94	180	330	3	0.41	240	
			190 HB	0.5	5	0.21	0.48	1.94	180	280	3	0.38	220	
			250 HB	0.5	5	0.21	0.43	1.62	180	250	3	0.36	200	
	Low Alloyed	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	230 HB	0.5	4	0.21	0.43	1.3	120	250	3	0.35	180
				280 HB	0.5	4	0.18	0.38	1.3	120	210	3	0.32	150
				180 HB	0.5	5	0.21	0.43	1.3	120	280	3	0.35	200
				350 HB	0.5	3.5	0.18	0.38	1.08	120	180	2.7	0.32	130
	High Alloyed	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	4	0.18	0.38	1.3	70	190	2.5	0.32	140
				280 HB	0.5	4	0.18	0.38	1.3	70	150	2.5	0.32	120
				320 HB	0.5	3	0.18	0.33	0.86	70	130	2.2	0.3	100
				350 HB	0.5	3	0.18	0.33	0.86	70	110	2.2	0.3	90
	Stainless Steel	Austenitic	304, 316, X5CrNi18-9	180 HB	0.5	5	0.2	0.38	1.3	170	270	3	0.27	190
240 HB				0.5	5	0.2	0.38	1.08	160	220	3	0.24	170	
Duplex		X2CrNiN23-4, S31500	290 HB	0.5	4	0.18	0.33	0.86	80	150	2.5	0.26	100	
			310 HB	0.5	4	0.18	0.33	0.86	70	140	2.5	0.26	90	
Ferritic & Martensitic		6	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	5	0.18	0.38	0.76	170	250	2.5	0.22	190
				42 HRc	0.5	4	0.18	0.38	0.76	120	190	2.2	0.22	130
Cast Iron	Grey	GG20, GG40, EN-GJL-250, N030B	150 HB	0.5	5	0.15	0.57	2.16	170	250	3	0.38	200	
			200 HB	0.5	5	0.15	0.57	1.94	160	230	3	0.38	180	
			250 HB	0.5	5	0.15	0.52	1.94	150	210	3	0.38	160	
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.5	5	0.15	0.48	1.62	120	250	3	0.32	180
				200 HB	0.5	5	0.15	0.48	1.4	120	230	3	0.32	160
				250 HB	0.5	5	0.15	0.48	1.3	120	190	3	0.32	140
NITI Alloy	Fe, Ni & Co Based	9	Incoloy 800	240 HB	0.5	3	0.2	0.33	0.76	30	50	2	0.3	30
			Inconel 700	250 HB	0.5	3	0.2	0.33	0.76	30	50	2	0.3	30
			Stellite 21	350 HB	0.5	3	0.2	0.33	0.76	30	40	2	0.3	30
	Ti Based	10	T40	-	0.5	3	0.2	0.33	0.76	40	60	2	0.32	45
TiAl6V4			-	0.5	3.5	0.2	0.38	0.86	50	70	2	0.36	55	
Hardened Materials	Steel Chilled Cast Iron White Cast Iron	11	G- X300CrMo15	55 HRc	0.5	1.5	0.11	0.19	0.32	30	50	1	0.16	40
			Ni-Hard 2	400 HB	0.5	2	0.11	0.24	0.43	40	60	1.5	0.19	50
			X100CrMo13, 440C, G- X260NiCr42	45 HRc	0.5	2.5	0.11	0.29	0.65	50	100	2	0.27	80
				50 HRc	0.5	2	0.11	0.24	0.43	40	90	1.5	0.22	70
				55 HRc	0.5	1.5	0.11	0.19	0.32	40	80	1	0.19	60
Aluminium	Al (>8%Si)	12	AlSi12	130 HB	0.5	6	0.2	0.57	1.94	200	400	3	0.43	280