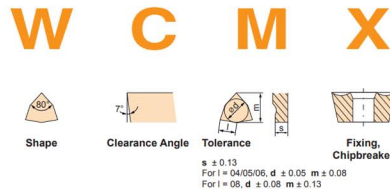


INSERTO WCMX 080412 NN LT 30

• Procedencia SUIZA • Suministrado por McT-Enterprises

Material Group	Gr. N°	VOI Group	Material Examples	Hardness	Feed [mm/rev]		V _c [m/min]		Suggested Starting Parameters		
					min	max	min	max	Feed	V _c	
Steel	Non Alloyed	1	C35, Ck45, 1020, 1045, 1060, 20Mn6	125 HB	0.06	0.16	180	270	0.11	225	
		2		190 HB	0.06	0.16	180	230	0.11	205	
		3		250 HB	0.06	0.16	180	200	0.11	190	
	Low Alloyed	2	42CrMo4, S150, Ck60, 4140, 4340, 100Cr6	180 HB	0.06	0.16	120	230	0.11	175	
		4,6		230 HB	0.06	0.16	120	190	0.11	155	
		5,7		280 HB	0.06	0.15	100	170	0.11	135	
		8		350 HB	0.06	0.15	100	150	0.11	125	
	High Alloyed	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12N19	220 HB	0.09	0.16	70	170	0.13	120	
		10		280 HB	0.09	0.16	70	150	0.13	110	
		11		320 HB	0.09	0.14	60	130	0.11	95	
		11		350 HB	0.09	0.14	60	100	0.11	80	
Stainless Steel	Austenitic	4	304, 316, X5CrNi18-9	180 HB	0.06	0.15	170	230	0.11	200	
		14		240 HB	0.09	0.15	120	210	0.12	165	
	Duplex	5	X2CrNiMo23-4, S31500	290 HB	0.09	0.14	70	120	0.11	95	
Ferritic & Martensitic	6	410, X6Cr17, 17-4 PH, 430	200 HB	0.09	0.14	100	150	0.11	125		
	13		42 Hrc	0.06	0.13	60	100	0.09	80		
Cast Iron	Grey	7	GG20, GG40, EN-GJL-250, No30B	150 HB	0.10	0.18	150	230	0.14	190	
		15		200 HB	0.10	0.18	150	210	0.14	180	
		16		250 HB	0.10	0.18	150	170	0.14	160	
Malleable & Nodular	8	GGG40, GG70, 50005	150 HB	0.10	0.18	120	200	0.14	160		
	17,19		200 HB	0.10	0.18	120	170	0.14	145		
	18,20		250 HB	0.10	0.18	120	150	0.14	135		
High Temp. Alloys	Fe, Ni & Co Based	9	Incoloy 800, Inconel 700, Stellite 21	240 HB	0.06	0.13	25	35	0.09	30	
		33		250 HB	0.06	0.13	25	35	0.09	30	
		34		350 HB	0.06	0.13	23	35	0.09	29	
	Ti Based	10	TiAl6V4, T40	-	0.06	0.13	35	60	0.09	45	
		37		-	0.06	0.13	28	40	0.09	34	
Hardened Mat.	Steel	11	X100CrMo13, 440C, G-X260NiCr42	45 Hrc	0.06	0.13	50	90	0.09	70	
		38		50 Hrc	0.06	0.13	40	70	0.09	65	
		38		55 Hrc	0.06	0.13	30	60	0.09	45	
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.06	0.13	40	60	0.09	50	
		41		G-X300CrMo15	55 Hrc	0.06	0.13	30	50	0.09	40
MF	Al (>8%Si)	12	25	AlSi12	130 HB	0.10	0.16	200	400	0.13	300



LAMINA TECHNOLOGIES

