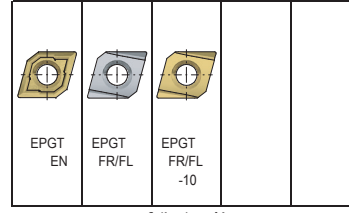


Caution: General safety regulations and directions of machine manufacturers must be observed at any time!

Material description	W-Nr. German	AISI/SAE	Tensile strength	Hardness
			Rm (N/mm ²)	HB
1 Low Carbon Steel	1.0035	1010	- 500	- 160
	1.0038	1045		
	1.0401	1015		
	1.0050	1050		
2 Alloy Steel	1.0501	1035	500 - 700	140 - 200
	1.1141	1115		
	1.5732	3415		
	1.7225	4140		
3 Tool Steel	1.1221	1060	900 - 1'100	170 - 275
	1.3505	52100		
	1.7225	4140		
	1.5141	-		
4 Alloy Tool Steel	1.1191	4140	700 - 900	250 - 325
	1.7225	4142		
	1.2080	D3		
	1.7220	4135		
5 Alloy Cast Steel	1.6582	4340	1'100 - 1'500 800 - 1'000	325 - 450 250 - 300 330 - 390
	1.8159	6150		
	1.2367	A2		
	1.7361	4145		
6 Stainless Steel	1.4006	403	- 800	- 250
	1.4057	431		
	1.4034	420		
	1.4005	416		
7 Stainless Steel - Austenitic, Martensitic	1.4300	302	500 - 1100	200 - 325
	1.4301	304 (304H)		
	1.4435	316		
	1.4542	17-4 ph		
8 Grey Cast Iron	0.6010	A48-20B	- 250	- 200
	0.6015	A48-25B		
	0.6020	A48-30B		
9 Cast Iron Malleable	0.6025	A48-35B	250 - 350	200 - 250
	0.8135	A48-40B		
	0.8140	A48-45B		
	0.7050	80-55-06		
10 Copper Alloys	2.0331	B121	450 - 650	120 - 180
	2.0401	B121		
	2.1030	B103		
	2.0920	CuAl 8		
11 Aluminium Alloys	3.2582.05	383.2 (ALSi-12)	250 - 350	200 - 300
	3.3541.01	514.0 (AlMg 3)		
	3.2315	413.0 (ALMgSi 1)		
	3.0205	1200 (AL 99)		



Carbide				Cermet		
uncoated	coated			un coated	coated	
DX2	DX20	DX30 DX50 DX52		DT55	DT255	DT355

f (ipr) *)				Vc (sfm)							
.0020	.0012	.0012		500		1120	1250		1510	1910	1910
.0059	.0028	.0028		425		960	1050		1220	1550	1550
.0098	.0055	.0055		300		790	860		825	1050	1051
.0020	.0012	.0012		400		1050	1190		1450	1810	1810
.0059	.0028	.0028		300		890	990		1150	1450	1450
.0098	.0028	.0028		200		725	925		725	925	926
.0020	.0012	.0012		300		860	1050		1350	1680	1680
.0059	.0028	.0028		230		700	960		1120	1380	1380
.0079	.0028	.0028		165		560	660		760	960	961
.0020	.0012	.0012		200		660	860		725	890	890
.0059	.0028	.0028		165		600	725		600	790	790
.0079	.0028	.0028		135		400	525		460	560	561
.0020	.0012	.0012				460	660		600	725	725
.0059	.0020	.0020				400	525		500	625	625
.0079	.0020	.0020				300	400		400	500	501
.0020		.0012				525	560				
.0059		.0028				460	525				
.0008		.0008									
.0059		.0028				400	425				
						330	360				
.0020						460	860	925	600	1120	1190
.0059						400	725	825	525	925	1060
.0079						300	660	760	425	790	990
.0020						400	725	825	528	925	1050
.0059						300	660	725	400	860	925
.0079						230	600	660	300	800	860
.0008		.0008				1490	1810	1980			
.0059		.0059				1320	1650	1810			
.0079		.0098				1160	1485	1650			
		.0008					>6270	>6600			
		.0059									
		.0098									

*) in function of stability of tool & workpiece

