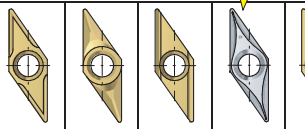
Caution: General safety regulations and directions of machine manufacturers must be observed at any time!



	Material description	W-Nr. German	AISI/SAE	Tensile strength	Hardness	VCGT 07.. -12	VCGT 07.. -25	VCGT 07.. -08 FR/L	VCGT 07.. FN-18M	VCGW 07..	Carbide uncoated DX2	Carbide uncoated	Carbide coated DX20 DX32	Carbide coated DX30 DX50 DX52	Carbide coated	Cermet	Cermet
				Rm (N/mm²)	HB	f (ipr) *)					Vc (sfm)						
1	Low Carbon Steel	1.0035 1.0038 1.0401 1.0050	1010 1045 1015 1050	- 500	- 160	0.0008 ÷ 0.0059		0.0004 ÷ 0.0031	0.0008 ÷ 0.0059	0.0004 ÷ 0.0039	495		825	957			
2	Alloy Steel	1.0501 1.1141 1.5732 1.7225	1035 1115 3415 4140	500 - 700	140 - 200	0.0008 ÷ 0.0051		0.0004 ÷ 0.0031	0.0008 ÷ 0.0059	0.0004 ÷ 0.0039	396		726	825			
3	Tool Steel	1.1221 1.3505 1.7225 1.5141	1060 52100 4140 -	900 - 1'100	170 - 275	0.0008 ÷ 0.0039		0.0004 ÷ 0.0019	0.0008 ÷ 0.0039	0.0004 ÷ 0.0027	297		660	759			
4	Alloy Tool Steel	1.1191 1.7225 1.2080 1.7220	4140 4142 D3 4135	700 - 900	250 - 325	0.0008 ÷ 0.0039		0.0004 ÷ 0.0019	0.0008 ÷ 0.0039	0.0004 ÷ 0.0028			528	594			
5	Alloy Cast Steel	1.6582 1.8159 1.2367 1.7361	4340 6150 A2 4145	1'100 - 1'500 800 - 1'000	325 - 450 250 - 390	0.0008 ÷ 0.0028		0.0004 ÷ 0.0019		0.0004 ÷ 0.0028			429	495			
6	Stainless Steel	1.4006 1.4057 1.4034 1.4005	403 431 420 416	- 800	- 250	0.0008 ÷ 0.0059	0.0004 ÷ 0.0024	0.0004 ÷ 0.0031	0.0008 ÷ 0.0059				660	759			
7	Stainless Steel - Austenitic, Martensitic	1.4300 1.4301 1.4435 1.4542	302 304 (304H) 316 17-4 ph	500 - 1100	200 - 325	0.0008 ÷ 0.0039	0.0004 ÷ 0.0024	0.0004 ÷ 0.002	0.0008 ÷ 0.0051				528	594			
8	Grey Cast Iron	0.6010 0.6015 0.6020	A48-20B A48-25B A48-30B	- 250	- 200	0.0008 ÷ 0.0059				0.0008 ÷ 0.0078	297		594	693			
9	Cast Iron Malleable	0.6025 0.8135 0.8140 0.7050	A48-35B A48-40B A48-45B 80-55-06	250 - 350	200 - 250	0.0008 ÷ 0.0059				0.0008 ÷ 0.0059	264		462	528			
10	Copper Alloys	2.0331 2.0401 2.1030 2.0920	B121 B121 B103 CuAl 8	450 - 650	120 - 180	0.0004 ÷ 0.0079	0.0004 ÷ 0.0039	0.0004 ÷ 0.0039	0.0008 ÷ 0.0118	0.0008 ÷ 0.0079	660		>990	>990			
11	Aluminium Alloys	3.2582.05 3.3541.01 3.2315 3.0205	383.2 (ALSi-12) 514.0 (AlMg 3) 413.0 (ALMgSi 1) 1200 (AL 99)	250 - 350	200 - 300	0.0016 ÷ 0.0059	0.0004 ÷ 0.0118	0.0004 ÷ 0.0039	0.0008 ÷ 0.0098		>3300		>3300	>3300			

*) in function of stability of tool & workpiece

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