

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
1 Low Carbon Steel	1.0035 1.0038 1.0401 1.0050	1010 1045 1015 1050	- 500	- 160
2 Alloy Steel	1.0501 1.1141 1.5732 1.7225	1035 1115 3415 4140	500 - 700	140 - 200
3 Tool Steel	1.1221 1.3505 1.7225 1.5141	1060 52100 4140 -	900 - 1'100	170 - 275
4 Alloy Tool Steel	1.1191 1.7225 1.2080 1.7220	4140 4142 D3 4135	700 - 900	250 - 325
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 - 300 330 - 390
6 Stainless Steel	1.4006 1.4057 1.4034 1.4005	403 431 420 416	- 800	- 250
7 Stainless Steel - Austenitic, Martensitic	1.4300 1.4301 1.4435 1.4542	302 304 (304H) 316 17-4 ph	500 - 1100	200 - 325
8 Grey Cast Iron	0.6010 0.6015 0.6020	A48-20B A48-25B A48-30B	- 250	- 200
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
10 Copper Alloys	2.0331 2.0401 2.1030 2.0920	B121 B121 B103 CuAl 8	450 - 650	120 - 180
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

Carbide						Cermet					
uncoated		coated			un coated	coated					
DX2		DX20	DX30 DX50 DX70		DT55	DT255	DT355				
CPET FL	CPET FN-20	CPGT EN	CPGT FL	CPGT FN	CPGT FN-20						
f (ipr - *)						Vc (sfm)					
.0012 .0028	.0012 .0028	.0020 .0059	.0012 .0028	.0012 .0039		1120 955	1250 1055	1520 1220	1915 1550	1915 1550	
.0012 .0028	.0012 .0028	.0020 .0059	.0012 .0028	.0012 .0039		1055 890	1190 990	1450 1155	1815 1450	1815 1450	
.0012 .0028	.0012 .0028	.0020 .0059	.0012 .0028	.0012 .0039		860 695	1055 955	1355 1120	1685 1385	1685 1385	
.0012 .0028	.0012 .0028	.0020 .0059	.0012 .0028	.0012 .0031				725 660	890 790	890 790	
0.001	0.001	.0020 .0059	0.001	.0012 .0031				595 495	725 625	725 625	
	.0012 .0028			.0012 .0039	.0008 .0059	530 460	560 530				
	.0008 .0028			.0008 .0039	.0008 .0059	395 330	430 365				
.0012 .0031		.0020 .0059	.0012 .0031	.0020 .0059		460 395	860 725	925 825	595 530	1120 925	1190 1055
.0012 .0031		.0020 .0059	.0012 .0031	.0020 .0059			725 660	825 725	530 395	925 860	1055 925
	.0008 .0059			.0008 .0059	.0008 .0039	1485 1320	1815 1650	1980 1815			
	.0008 .0059			.0008 .0059 .0118			>6270 >6600				

*) in function of stability of tool & workpiece

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