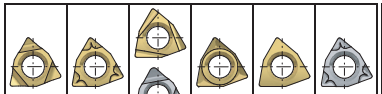
Caution: General safety regulations and directions of machine manufacturers must be observed at any time!



	Material description	W-Nr. German	AISI/SAE	Tensile strength	Hardness	f (ipr) *)						Carbide						Cermet		
												uncoated		coated				un coated	coated	
												DX2	P25	DP25	DP35 DP55	DX20	DX30 DX50 DX52	DT55	DT255	DT355
				Rm (N/mm²)	HB							Vc (sfm)								
1	Low Carbon Steel	1.0035 1.0038 1.0401 1.0050	1010 1045 1015 1050	- 500	- 160	.0012 .0039	.0020 .0059	.0012 .0039 .0059		.0020 .0059	.0020 .0059	495 425 300				1120 960 790	1250 1050 850	1500 1220 825	1910 1550 1050	1910 1550 1051
2	Alloy Steel	1.0501 1.1141 1.5732 1.7225	1035 1115 3415 4140	500 - 700	140 - 200	.0012 .0039	.0020 .0059	.0012 .0039 .0059		.0020 .0059	.0020 .0059	400 300 200				1120 950 790	1190 990 925	1450 1150 725	1810 1450 925	1810 1450 926
3	Tool Steel	1.1221 1.3505 1.7225 1.5141	1060 52100 4140 -	900 - 1'100	170 - 275	.0012 .0039	.0020 .0059	.0012 .0039 .0059		.0020 .0059	.0020 .0059							1350 1120 760	1680 1380 950	1680 1380 951
4	Alloy Tool Steel	1.7225 1.7218 1.2080 1.7220	4140 4130 D3 4135	700 - 900	250 - 325	.0012 .0039	.0020 .0059	.0012 .0039 .0059		.0020 .0059	.0020 .0059							725 660 460	890 790 560	890 790 561
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	.0008	.0020 .0039	.0008		.0020 .0039	.0020 .0040							590 495 400	725 625 500	725 625 501
6	Stainless Steel	1.4006 1.4057 1.4034 1.4005	403 431 420 416	- 800	- 250	.0012 .0039		.0012 .0039	.0004 .0024	.0008 .0039	.0008 .0039					525 462	560 525		660 625	660 626
7	Stainless Steel - Austenitic, Martensitic	1.4300 1.4301 1.4435 1.4542	302 304 (304H) 316 17-4 ph	500 - 1100	200 - 325	.0008 .0039		.0008 .0039	.0004 .0024	.0008 .0041	.0008 .0042					400 330	430 360		500 425	500 426
8	Grey Cast Iron	0.6010 0.6015 0.6020	A48-20B A48-25B A48-30B	- 250	- 200		.0020 .0059			.0020 .0059	.0020 .0059	460 400 330				860 725 660	925 825 760	825 725 660	1120 925 860	1190 1050 990
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		.0020 .0059			.0020 .0059	.0020 .0059	400 300 230				725 660 600	825 725 660	700 625 560	925 860 790	1050 925 860
10	Copper Alloys	2.0331 2.0401 2.1030 2.0920	B121 B121 B103 CuAl 8	450 - 650	120 - 180	.0012 .0039		.0012 .0039 .0059	.0004 .0024	.0008 .0059	.0008 .0059	1480 1320 1155				1810 1650 1485	1980 1810 1650	1910 1710 1485	2375 2145 1910	2575 2375 2145
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	.0008 .0059 .0079		.0008 .0059 .0079	.0004 .0039 .0079			>3300				>6270	>6600			

*) in function of stability of tool & workpiece

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