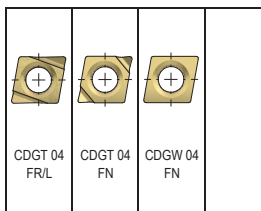


**Caution: General safety regulations and directions of machine manufacturers must be observed at any time!**

Material description	W-Nr. German	AISI/SAE	Tensile strength	Hardness
			Rm (N/mm <sup>2</sup> )	HB
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



f (ipr) \*)

.0004 +	.0004 +	.0004 +	
.0039	.0039	.0059	
.0004 +	.0004 +	.0004 +	
.0039	.0039	.0059	
		.0004 +	
		.0039	
		.0004 +	
		.0028	
.0004 +	.0004 +	.0004 +	
.0039	.0039	.0059	
.0004 +	.0004 +	.0004 +	
.0024	.0024	.0039	
		0.0004 +	
		0.0079	
		.0004 +	
		.0039	
.0004 +	.0004 +	.0012 +	
.0059	.0059	.0059	
.0004 +	.0004 +		
.0059	.0059		

Carbide						Cermet		
uncoated		coated				un coated	coated	
DX2	P25	DP35 DP55	DX20	DX30 DX50 DX52	DC15	DT55	DT255	DT355

Vc (sfm)

525			760	925				
460			690	860				
430			590	825				
			600	825				
			525	725				
			525	725				
			360	560				
300			495	660				
230			400	600				
660			>1000	>1000				
>1980			>3300	>3300				

\*) in function of stability of tool & workpiece

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