CNMA 120408
DNMA 150608
SNMA 120408
TNMA 160408

Material Group		Lamina Gr. N°	Material Examples	Hardness	DOC [mm] min	DOC [mm] max	Feed [mm/rev] min	Feed [mm/rev] max	Amax [mm²]	Suggested Starting Parameters DOC	Suggested Starting Parameters Feed
K	Grey	7	GG20, GG40, EN-GJL-250, N030B	150 HB	0.5	6.0	0.15	0.40	1.35	3.5	0.30
				200 HB				0.38	1.20		
				250 HB				0.35	1.20		
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.5	6.0	0.15	0.40	1.00	2.5	0.30
				200 HB				0.38	0.90		
				250 HB				0.35	0.80		
H	Chilled Cast Iron	12	Ni-Hard 2	400 HB	0.5	2.2	0.11	0.20	0.30	1.4	0.15
	White Cast Iron	13	G-X300CrMo15	55 HRc	0.5	1.6	0.11	0.20	0.20	1.1	0.15

CNMA 120412
DNMA 150612
SNMA 120412
TNMA 160412

Material Group		Lamina Gr. N°	Material Examples	Hardness	DOC [mm] min	DOC [mm] max	Feed [mm/rev] min	Feed [mm/rev] max	Amax [mm²]	Suggested Starting Parameters DOC	Suggested Starting Parameters Feed
K	Grey	7	GG20, GG40, EN-GJL-250, N030B	150 HB	0.8	6.0	0.15	0.60	1.50	3.5	0.43
				200 HB				0.48	1.40		0.40
				250 HB				0.45	1.35		0.38
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.8	6.0	0.15	0.48	1.30	3.0	0.43
				200 HB				0.40	1.10		0.36
				250 HB				0.38	1.00		0.33
H	Chilled Cast Iron	12	Ni-Hard 2	400 HB	0.8	2.4	0.11	0.25	0.30	1.5	0.20
	White Cast Iron	13	G-X300CrMo15	55 HRc	0.8	1.8	0.11	0.20	0.25	1.4	0.16

WNMA 080408

Material Group		Lamina Gr. N°	Material Examples	Hardness	DOC [mm] min	DOC [mm] max	Feed [mm/rev] min	Feed [mm/rev] max	Amax [mm²]	Suggested Starting Parameters DOC	Suggested Starting Parameters Feed
K	Grey	7	GG20, GG40, EN-GJL-250, N030B	150 HB	0.5	2.0	0.15	0.40	1.4	1.75	0.30
				200 HB				0.38	1.2		
				250 HB				0.35			
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.5	2.0	0.15	0.40	1.0	1.50	0.30
				200 HB				0.38	0.9		
				250 HB				0.35	0.8		
H	Chilled Cast Iron	12	Ni-Hard 2	400 HB	0.5	2.0	0.11	0.20	0.3	1.4	0.15
	White Cast Iron	13	G-X300CrMo15	55 HRc	0.5	1.6	0.11	0.20	0.2	1.1	0.15

WNMA 080412

Material Group		Lamina Gr. N°	Material Examples	Hardness	DOC [mm] min	DOC [mm] max	Feed [mm/rev] min	Feed [mm/rev] max	Amax [mm²]	Suggested Starting Parameters DOC	Suggested Starting Parameters Feed
K	Grey	7	GG20, GG40, EN-GJL-250, N030B	150 HB	0.8	2.0	0.20	0.60	1.9	1.75	0.40
				200 HB				0.58	1.7		
				250 HB				0.56			
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.8	2.0	0.20	0.52	1.4	1.50	0.30
				200 HB				0.50	1.2		
				250 HB				0.48	1.1		
H	Chilled Cast Iron	12	Ni-Hard 2	400 HB	0.8	2.0	0.14	0.25	0.4	1.6	0.19
	White Cast Iron	13	G-X300CrMo15	55 HRc	0.8	1.8	0.14	0.20	0.3	1.3	0.17

The depth of cut and feed rate tables are for the geometry and corner radius specified above the table.
Refer to cutting speed tables on pages 186 and 187 for recommended materials per grade.