

Tool material

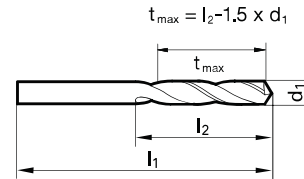
**HSS**

Surface



- |                          |   |   |
|--------------------------|---|---|
| <b>P</b> Steel           | ● | web thinning ≥ Ø 14.050 • relieved cone • for use in automatic/capstan lathes |
| <b>M</b> Stainless steel |   |   |
| <b>K</b> Cast iron       | ● | thin materials  |
| <b>N</b> Aluminum        | ○ |   |
| <b>S</b> Titanium alloys |   |   |
| <b>H</b> Hardened steel  |   |   |
- =Optimal  
○=Limited

Stub Length



Speeds and feeds information on pg. 480

Shank diameter = cut diameter

Diameter (d <sub>1</sub> )			l <sub>1</sub> mm	t <sub>max</sub> mm	l <sub>2</sub> mm	EDP #
inch	wire/ltr	mm				
0.0197		0.50	20.00	2.25	3.00	9002260005000
0.0217		0.55	21.00	2.68	3.50	9002260005500
0.0236		0.60	21.00	2.60	3.50	9002260006000
0.0256		0.65	22.00	3.03	4.00	9002260006500
0.0276		0.70	23.00	3.45	4.50	9002260007000
0.0295		0.75	23.00	3.38	4.50	9002260007500
0.0315		0.80	24.00	3.80	5.00	9002260008000
0.0335		0.85	24.00	3.73	5.00	9002260008500
0.0354		0.90	25.00	4.15	5.50	9002260009000
0.0374		0.95	25.00	4.08	5.50	9002260009500
0.0394		1.00	26.00	4.50	6.00	9002260010000
0.0402	#60	1.02	26.00	4.47	6.00	9002260010200
0.0413		1.05	26.00	4.43	6.00	9002260010500
0.0421	#58	1.07	28.00	5.40	7.00	9002260010700
0.0429	#57	1.09	28.00	5.37	7.00	9002260010900
0.0433		1.10	28.00	5.35	7.00	9002260011000
0.0453		1.15	28.00	5.28	7.00	9002260011500
0.0465	#56	1.18	28.00	5.23	7.00	9002260011800
0.0469	3/64	1.19	30.00	6.22	8.00	9002260011900
0.0472		1.20	30.00	6.20	8.00	9002260012000
0.0492		1.25	30.00	6.13	8.00	9002260012500
0.0512		1.30	30.00	6.05	8.00	9002260013000
0.0520	#55	1.32	30.00	6.02	8.00	9002260013200
0.0524		1.33	32.00	7.01	9.00	9002260013300
0.0531		1.35	32.00	6.98	9.00	9002260013500
0.0551	#54	1.40	32.00	6.90	9.00	9002260014000
0.0571		1.45	32.00	6.83	9.00	9002260014500
0.0591		1.50	32.00	6.75	9.00	9002260015000
0.0594	#53	1.51	34.00	7.74	10.00	9002260015100
0.0610		1.55	34.00	7.68	10.00	9002260015500
0.0626	1/16	1.59	34.00	7.62	10.00	9002260015900
0.0630		1.60	34.00	7.60	10.00	9002260016000
0.0634	#52	1.61	34.00	7.59	10.00	9002260016100
0.0650		1.65	34.00	7.53	10.00	9002260016500
0.0669	#51	1.70	34.00	7.45	10.00	9002260017000
0.0689		1.75	36.00	8.38	11.00	9002260017500
0.0701	#50	1.78	36.00	8.33	11.00	9002260017800
0.0709		1.80	36.00	8.30	11.00	9002260018000
0.0713		1.81	36.00	8.29	11.00	9002260018100
0.0728	#49	1.85	36.00	8.23	11.00	9002260018500

Diameter (d <sub>1</sub> )			l <sub>1</sub> mm	t <sub>max</sub> mm	l <sub>2</sub> mm	EDP #
inch	wire/ltr	mm				
0.0748		1.90	36.00	8.15	11.00	9002260019000
0.0760	#48	1.93	38.00	9.11	12.00	9002260019300
0.0768		1.95	38.00	9.08	12.00	9002260019500
0.0783	#47	1.99	38.00	9.02	12.00	9002260019900
0.0787		2.00	38.00	9.00	12.00	9002260020000
0.0807		2.05	38.00	8.93	12.00	9002260020500
0.0811	#46	2.06	38.00	8.91	12.00	9002260020600
0.0819	#45	2.08	38.00	8.88	12.00	9002260020800
0.0827		2.10	38.00	8.85	12.00	9002260021000
0.0846		2.15	40.00	9.78	13.00	9002260021500
0.0858	#44	2.18	40.00	9.73	13.00	9002260021800
0.0866		2.20	40.00	9.70	13.00	9002260022000
0.0886		2.25	40.00	9.63	13.00	9002260022500
0.0890	#43	2.26	40.00	9.61	13.00	9002260022600
0.0906		2.30	40.00	9.55	13.00	9002260023000
0.0925		2.35	40.00	9.48	13.00	9002260023500
0.0933	#42	2.37	43.00	10.45	14.00	9002260023700
0.0937	3/32	2.38	43.00	10.43	14.00	9002260023800
0.0945		2.40	43.00	10.40	14.00	9002260024000
0.0961	#41	2.44	43.00	10.34	14.00	9002260024400
0.0965		2.45	43.00	10.33	14.00	9002260024500
0.0980	#40	2.49	43.00	10.27	14.00	9002260024900
0.0984		2.50	43.00	10.25	14.00	9002260025000
0.0996	#39	2.53	43.00	10.21	14.00	9002260025300
0.1004		2.55	43.00	10.18	14.00	9002260025500
0.1016	#38	2.58	43.00	10.13	14.00	9002260025800
0.1024		2.60	43.00	10.10	14.00	9002260026000
0.1039	#37	2.64	43.00	10.04	14.00	9002260026400
0.1043		2.65	43.00	10.03	14.00	9002260026500
0.1063		2.70	46.00	11.95	16.00	9002260027000
0.1067	#36	2.71	46.00	11.94	16.00	9002260027100
0.1083		2.75	46.00	11.88	16.00	9002260027500
0.1094	7/64	2.78	46.00	11.83	16.00	9002260027800
0.1098	#35	2.79	46.00	11.82	16.00	9002260027900
0.1102		2.80	46.00	11.80	16.00	9002260028000
0.1110	#34	2.82	46.00	11.77	16.00	9002260028200
0.1122		2.85	46.00	11.73	16.00	9002260028500
0.1130	#33	2.87	46.00	11.70	16.00	9002260028700
0.1142		2.90	46.00	11.65	16.00	9002260029000
0.1161	#32	2.95	46.00	11.58	16.00	9002260029500

Diameter (d <sub>1</sub> )			l <sub>1</sub> mm	t <sub>max</sub> mm	l <sub>2</sub> mm	EDP #
inch	wire/ltr	mm				
0.1181		3.00	46.00	11.50	16.00	9002260030000
0.1201	#31	3.05	49.00	13.43	18.00	9002260030500
0.1220		3.10	49.00	13.35	18.00	9002260031000
0.1240		3.15	49.00	13.28	18.00	9002260031500
0.1248	1/8	3.17	49.00	13.25	18.00	9002260031700
0.1260		3.20	49.00	13.20	18.00	9002260032000
0.1272		3.23	49.00	13.16	18.00	9002260032300
0.1280		3.25	49.00	13.13	18.00	9002260032500
0.1283	#30	3.26	49.00	13.11	18.00	9002260032600
0.1299		3.30	49.00	13.05	18.00	9002260033000
0.1319		3.35	49.00	12.98	18.00	9002260033500
0.1339		3.40	52.00	14.90	20.00	9002260034000
0.1358	#29	3.45	52.00	14.83	20.00	9002260034500
0.1378		3.50	52.00	14.75	20.00	9002260035000
0.1398		3.55	52.00	14.68	20.00	9002260035500
0.1417		3.60	52.00	14.60	20.00	9002260036000
0.1457		3.70	52.00	14.45	20.00	9002260037000
0.1469	#26	3.73	52.00	14.41	20.00	9002260037300
0.1476		3.75	52.00	14.38	20.00	9002260037500
0.1484		3.77	55.00	16.35	22.00	9002260037700
0.1496	#25	3.80	55.00	16.30	22.00	9002260038000
0.1512		3.84	55.00	16.24	22.00	9002260038400
0.1516		3.85	55.00	16.23	22.00	9002260038500
0.1520	#24	3.86	55.00	16.21	22.00	9002260038600
0.1535		3.90	55.00	16.15	22.00	9002260039000
0.1539	#23	3.91	55.00	16.14	22.00	9002260039100
0.1555		3.95	55.00	16.08	22.00	9002260039500
0.1563	5/32	3.97	55.00	16.05	22.00	9002260039700
0.1571	#22	3.99	55.00	16.02	22.00	9002260039900
0.1575		4.00	55.00	16.00	22.00	9002260040000
0.1591	#21	4.04	55.00	15.94	22.00	9002260040400
0.1594		4.05	55.00	15.93	22.00	9002260040500
0.1614		4.10	55.00	15.85	22.00	9002260041000
0.1634		4.15	55.00	15.78	22.00	9002260041500
0.1654		4.20	55.00	15.70	22.00	9002260042000
0.1661	#19	4.22	55.00	15.67	22.00	9002260042200
0.1673		4.25	55.00	15.63	22.00	9002260042500
0.1693	#18	4.30	58.00	17.55	24.00	9002260043000
0.1713		4.35	58.00	17.48	24.00	9002260043500
0.1720	11/64	4.37	58.00	17.45	24.00	9002260043700
0.1728	#17	4.39	58.00	17.42	24.00	9002260043900
0.1732		4.40	58.00	17.40	24.00	9002260044000
0.1752		4.45	58.00	17.33	24.00	9002260044500
0.1772	#16	4.50	58.00	17.25	24.00	9002260045000
0.1799	#15	4.57	58.00	17.15	24.00	9002260045700
0.1811		4.60	58.00	17.10	24.00	9002260046000
0.1810		4.62	58.00	17.07	24.00	9002260046200
0.1850	#13	4.70	58.00	16.95	24.00	9002260047000
0.1870		4.75	58.00	16.88	24.00	9002260047500
0.1874	3/16	4.76	62.00	18.86	26.00	9002260047600
0.1890	#12	4.80	62.00	18.80	26.00	9002260048000
0.1909	#11	4.85	62.00	18.73	26.00	9002260048500
0.1929		4.90	62.00	18.65	26.00	9002260049000
0.1937	#10	4.92	62.00	18.62	26.00	9002260049200
0.1961	#9	4.98	62.00	18.53	26.00	9002260049800
0.1969		5.00	62.00	18.50	26.00	9002260050000
0.1988		5.05	62.00	18.43	26.00	9002260050500
0.2008		5.10	62.00	18.35	26.00	9002260051000
0.2012	#7	5.11	62.00	18.34	26.00	9002260051100
0.2028		5.15	62.00	18.28	26.00	9002260051500
0.2031	13/64	5.16	62.00	18.26	26.00	9002260051600
0.2039	#6	5.18	62.00	18.23	26.00	9002260051800
0.2047		5.20	62.00	18.20	26.00	9002260052000
0.2055	#5	5.22	62.00	18.17	26.00	9002260052200
0.2067		5.25	62.00	18.13	26.00	9002260052500

Diameter (d <sub>1</sub> )			l <sub>1</sub> mm	t <sub>max</sub> mm	l <sub>2</sub> mm	EDP #
inch	wire/ltr	mm				
0.2087		5.30	62.00	18.05	26.00	9002260053000
0.2091	#4	5.31	66.00	20.04	28.00	9002260053100
0.2106		5.35	66.00	19.98	28.00	9002260053500
0.2126		5.40	66.00	19.90	28.00	9002260054000
0.2130	#3	5.41	66.00	19.89	28.00	9002260054100
0.2165		5.50	66.00	19.75	28.00	9002260055000
0.2189	7/32	5.56	66.00	19.66	28.00	9002260055600
0.2205		5.60	66.00	19.60	28.00	9002260056000
0.2209	#2	5.61	66.00	19.59	28.00	9002260056100
0.2224		5.65	66.00	19.53	28.00	9002260056500
0.2244		5.70	66.00	19.45	28.00	9002260057000
0.2264		5.75	66.00	19.38	28.00	9002260057500
0.2280	#1	5.79	66.00	19.32	28.00	9002260057900
0.2283		5.80	66.00	19.30	28.00	9002260058000
0.2323		5.90	66.00	19.15	28.00	9002260059000
0.2343	15/64	5.95	66.00	19.08	28.00	9002260059500
0.2362		6.00	66.00	19.00	28.00	9002260060000
0.2378	B	6.04	70.00	21.94	31.00	9002260060400
0.2402		6.10	70.00	21.85	31.00	9002260061000
0.2421	C	6.15	70.00	21.78	31.00	9002260061500
0.2441		6.20	70.00	21.70	31.00	9002260062000
0.2461	D	6.25	70.00	21.63	31.00	9002260062500
0.2480		6.30	70.00	21.55	31.00	9002260063000
0.2500	1/4	6.35	70.00	21.48	31.00	9002260063500
0.2520		6.40	70.00	21.40	31.00	9002260064000
0.2559		6.50	70.00	21.25	31.00	9002260065000
0.2571		6.53	70.00	21.21	31.00	9002260065300
0.2598		6.60	70.00	21.10	31.00	9002260066000
0.2610	G	6.63	70.00	21.06	31.00	9002260066300
0.2638		6.70	70.00	20.95	31.00	9002260067000
0.2657	17/64	6.75	74.00	23.88	34.00	9002260067500
0.2677		6.80	74.00	23.80	34.00	9002260068000
0.2717	I	6.90	74.00	23.65	34.00	9002260069000
0.2736		6.95	74.00	23.58	34.00	9002260069500
0.2756		7.00	74.00	23.50	34.00	9002260070000
0.2795		7.10	74.00	23.35	34.00	9002260071000
0.2811	9/32	7.14	74.00	23.29	34.00	9002260071400
0.2835		7.20	74.00	23.20	34.00	9002260072000
0.2854		7.25	74.00	23.13	34.00	9002260072500
0.2874		7.30	74.00	23.05	34.00	9002260073000
0.2902	L	7.37	74.00	22.95	34.00	9002260073700
0.2913		7.40	74.00	22.90	34.00	9002260074000
0.2949	M	7.49	74.00	22.77	34.00	9002260074900
0.2953		7.50	74.00	22.75	34.00	9002260075000
0.2969	19/64	7.54	79.00	25.69	37.00	9002260075400
0.2992		7.60	79.00	25.60	37.00	9002260076000
0.3031		7.70	79.00	25.45	37.00	9002260077000
0.3051		7.75	79.00	25.38	37.00	9002260077500
0.3071		7.80	79.00	25.30	37.00	9002260078000
0.3110		7.90	79.00	25.15	37.00	9002260079000
0.3126	5/16	7.94	79.00	25.09	37.00	9002260079400
0.3150		8.00	79.00	25.00	37.00	9002260080000
0.3161	O	8.03	79.00	24.96	37.00	9002260080300
0.3189		8.10	79.00	24.85	37.00	9002260081000
0.3228	P	8.20	79.00	24.70	37.00	9002260082000
0.3268		8.30	79.00	24.55	37.00	9002260083000
0.3307		8.40	79.00	24.40	37.00	9002260084000
0.3319	Q	8.43	79.00	24.36	37.00	9002260084300
0.3346		8.50	79.00	24.25	37.00	9002260085000
0.3386		8.60	84.00	27.10	40.00	9002260086000
0.3425		8.70	84.00	26.95	40.00	9002260087000
0.3437	11/32	8.73	84.00	26.91	40.00	9002260087300
0.3445		8.75	84.00	26.88	40.00	9002260087500
0.3465		8.80	84.00	26.80	40.00	9002260088000
0.3480	S	8.84	84.00	26.74	40.00	9002260088400

Stub Length

Diameter (d <sub>1</sub> )			l <sub>1</sub> mm	t <sub>max</sub> mm	l <sub>2</sub> mm	EDP #
inch	wire/ltr	mm				
0.3504		8.90	84.00	26.65	40.00	9002260089000
0.3543		9.00	84.00	26.50	40.00	9002260090000
0.3579	T	9.09	84.00	26.37	40.00	9002260090900
0.3583		9.10	84.00	26.35	40.00	9002260091000
0.3594	23/64	9.13	84.00	26.31	40.00	9002260091300
0.3622		9.20	84.00	26.20	40.00	9002260092000
0.3677	U	9.34	84.00	25.99	40.00	9002260093400
0.3701		9.40	84.00	25.90	40.00	9002260094000
0.3740		9.50	84.00	25.75	40.00	9002260095000
0.3748	3/8	9.52	89.00	28.72	43.00	9002260095200
0.3780		9.60	89.00	28.60	43.00	9002260096000
0.3819		9.70	89.00	28.45	43.00	9002260097000
0.3839		9.75	89.00	28.38	43.00	9002260097500
0.3858	W	9.80	89.00	28.30	43.00	9002260098000
0.3898		9.90	89.00	28.15	43.00	9002260099000
0.3937		10.00	89.00	28.00	43.00	9002260100000
0.3969	X	10.08	89.00	27.88	43.00	9002260100800
0.3976		10.10	89.00	27.85	43.00	9002260101000
0.4016		10.20	89.00	27.70	43.00	9002260102000
0.4035		10.25	89.00	27.63	43.00	9002260102500
0.4055		10.30	89.00	27.55	43.00	9002260103000
0.4063	13/32	10.32	89.00	27.52	43.00	9002260103200
0.4094		10.40	89.00	27.40	43.00	9002260104000
0.4130	Z	10.49	89.00	27.27	43.00	9002260104900
0.4134		10.50	89.00	27.25	43.00	9002260105000
0.4173		10.60	89.00	27.10	43.00	9002260106000
0.4252		10.80	95.00	30.80	47.00	9002260108000
0.4291		10.90	95.00	30.65	47.00	9002260109000
0.4331		11.00	95.00	30.50	47.00	9002260110000
0.4370		11.10	95.00	30.35	47.00	9002260111000
0.4374	7/16	11.11	95.00	30.34	47.00	9002260111100
0.4409		11.20	95.00	30.20	47.00	9002260112000

Diameter (d <sub>1</sub> )			l <sub>1</sub> mm	t <sub>max</sub> mm	l <sub>2</sub> mm	EDP #
inch	wire/ltr	mm				
0.4429		11.25	95.00	30.13	47.00	9002260112500
0.4449		11.30	95.00	30.05	47.00	9002260113000
0.4488		11.40	95.00	29.90	47.00	9002260114000
0.4528		11.50	95.00	29.75	47.00	9002260115000
0.4531	29/64	11.51	95.00	29.74	47.00	9002260115100
0.4606		11.70	95.00	29.45	47.00	9002260117000
0.4626		11.75	95.00	29.38	47.00	9002260117500
0.4646		11.80	95.00	29.30	47.00	9002260118000
0.4724		12.00	102.00	33.00	51.00	9002260120000
0.4764		12.10	102.00	32.85	51.00	9002260121000
0.4803		12.20	102.00	32.70	51.00	9002260122000
0.4843	31/64	12.30	102.00	32.55	51.00	9002260123000
0.4882		12.40	102.00	32.40	51.00	9002260124000
0.4921		12.50	102.00	32.25	51.00	9002260125000
0.4961		12.60	102.00	32.10	51.00	9002260126000
0.5000	1/2	12.70	102.00	31.95	51.00	9002260127000
0.5118		13.00	102.00	31.50	51.00	9002260130000
0.5354		13.60	107.00	33.60	54.00	9002260136000
0.5906		15.00	111.00	33.50	56.00	9002260150000
0.5984		15.20	115.00	35.20	58.00	9002260152000
0.6181		15.70	115.00	34.45	58.00	9002260157000
0.6201		15.75	115.00	34.38	58.00	9002260157500
0.6248	5/8	15.87	115.00	34.20	58.00	9002260158700
0.6496		16.50	119.00	35.25	60.00	9002260165000
0.6693		17.00	119.00	34.50	60.00	9002260170000
0.7500	3/4	19.05	131.00	37.43	66.00	9002260190500
0.7811	25/32	19.84	131.00	36.24	66.00	9002260198400
1.0000	1.0000	25.40	156.00	39.90	78.00	9002260254000
1.0039		25.50	156.00	39.75	78.00	9002260255000
1.2008		30.50	174.00	41.25	87.00	9002260305000
1.7500	1 3/4	44.45	214.00	41.33	108.00	9002260444500

Series # 225

Material group	Hardness		SFM	Feed Rate - IPR									
	HRc	Bhn		1/16 in. 1.590 mm	1/8 in. 3.170 mm	1/4 in. 6.350 mm	3/8 in. 9.520 mm	1/2 in. 12.700 mm	5/8 in. 15.870 mm	3/4 in. 19.050 mm	1 in. 25.400 mm	1 1/4 in. 31.750 mm	1 1/2 in. 38.100 mm
Common structural steels	-	≤ 150											
Free-cutting steels	≤ 32	≤ 301											
Unalloyed heat-treatable steels	≤ 25	≤ 255											
Alloyed heat-treatable steels	≤ 32	≤ 301											
Unalloyed case hardened steels	≤ 43	≤ 402											
Alloyed case hardened steels	≤ 25	≤ 255											
Nitriding steels	≤ 32	≤ 301											
Tool steels	≤ 43	≤ 402											
High speed steels	≤ 25	≤ 255											
Spring steels	≤ 43	≤ 402											
Hardened steels	≤ 38	≤ 354											
Stainless steels, sulphured	≤ 48	≤ 460											
austenitic	≤ 66	-											
martensitic	≤ 28	≤ 273											
Cast iron	≤ 36	≤ 337											
Spheroidal graphite iron and malleable cast iron	≤ 46	≤ 435											
Chilled cast iron	≤ 23	≤ 242											
New cast materials GGV	≤ 38	≤ 354											
New cast materials ADI	≤ 23	≤ 242											
Special alloys	≤ 38	≤ 354											
Ti and Ti-alloys	≤ 20	≤ 220											
Aluminium and Al-alloys	≤ 32	≤ 301											
Al wrought alloys	≤ 43	≤ 402											
Al cast alloys ≤ 10 % Si	≤ 54	≤ 549											
≤ 24 % Si	≤ 25	≤ 255	295	0.0020	0.0065	0.0100	0.0125	0.0160	0.0160	0.0180	0.0200		
Magnesium alloys	-	≤ 120	295	0.0020	0.0065	0.0100	0.0125	0.0160	0.0160	0.0180	0.0200		
Copper, low-alloyed	-	≤ 180	225	0.0020	0.0065	0.0100	0.0125	0.0160	0.0160	0.0180	0.0200		
Brass, short-chipping	-	≤ 180											
long-chipping	-	≤ 180	115	0.0015	0.0040	0.0065	0.0080	0.0100	0.0100	0.0110	0.0125		
Bronze, short-chipping	-	≤ 180	145	0.0015	0.0040	0.0065	0.0080	0.0100	0.0100	0.0110	0.0125		
Bronze, long-chipping	≤ 25	≤ 255											
Duroplastics	≤ 25	≤ 255											
Thermoplastics	≤ 32	≤ 301											
Reinforced plastics - Kevlar			90	0.0015	0.0040	0.0065	0.0080	0.0100	0.0100	0.0110	0.0125		
Reinforced plastics - GFK / CFK													

Series # 226

Material group	Hardness		SFM	Feed Rate - IPR									
	HRc	Bhn		1/16 in. 1.590 mm	1/8 in. 3.170 mm	1/4 in. 6.350 mm	3/8 in. 9.520 mm	1/2 in. 12.700 mm	5/8 in. 15.870 mm	3/4 in. 19.050 mm	1 in. 25.400 mm	1 1/4 in. 31.750 mm	1 1/2 in. 38.100 mm
Common structural steels	-	≤ 150	115	0.0017	0.0050	0.0080	0.0100	0.0125					
Free-cutting steels	≤ 32	≤ 301	90	0.0015	0.0040	0.0065	0.0080	0.0100					
Unalloyed heat-treatable steels	≤ 25	≤ 255	115	0.0017	0.0050	0.0080	0.0100	0.0125					
Alloyed heat-treatable steels	≤ 32	≤ 301	90	0.0015	0.0040	0.0065	0.0080	0.0100					
Unalloyed case hardened steels	≤ 43	≤ 402											
Alloyed case hardened steels	≤ 25	≤ 255	115	0.0017	0.0050	0.0080	0.0100	0.0125					
Nitriding steels	≤ 32	≤ 301											
Tool steels	≤ 43	≤ 402											
High speed steels	≤ 25	≤ 255	55	0.0012	0.0030	0.0050	0.0065	0.0080					
Spring steels	≤ 43	≤ 402											
Hardened steels	≤ 38	≤ 354											
Stainless steels, sulphured	≤ 48	≤ 460											
austenitic	≤ 66	-											
martensitic	≤ 28	≤ 273											
Cast iron	≤ 36	≤ 337											
Spheroidal graphite iron and malleable cast iron	≤ 46	≤ 435											
Chilled cast iron	≤ 23	≤ 242	115	0.0017	0.0050	0.008	0.0100	0.0125					
New cast materials GGV	≤ 38	≤ 354	90	0.0017	0.0050	0.008	0.0100	0.0125					
New cast materials ADI	≤ 23	≤ 242	100	0.0017	0.0050	0.008	0.0100	0.0125					
Special alloys	≤ 38	≤ 354	75	0.0017	0.0050	0.008	0.0100	0.0125					
Ti and Ti-alloys	≤ 20	≤ 220											
Aluminium and Al-alloys	≤ 32	≤ 301											
Al wrought alloys	≤ 43	≤ 402											
Al cast alloys ≤ 10 % Si	≤ 54	≤ 549											
≤ 24 % Si	≤ 25	≤ 255	225	0.0020	0.0065	0.0100	0.0125	0.0160					
Magnesium alloys	-	≤ 120	180	0.0017	0.0050	0.0080	0.0100	0.0125					
Copper, low-alloyed	-	≤ 180	295	0.0017	0.0050	0.0080	0.0100	0.0125					
Brass, short-chipping	-	≤ 180	115	0.0015	0.0040	0.0065	0.0080	0.0100					
long-chipping	-	≤ 180	145	0.0015	0.0040	0.0065	0.0080	0.0100					
Bronze, short-chipping	-	≤ 180	115	0.0012	0.0030	0.0050	0.0065	0.0080					
Bronze, long-chipping	≤ 25	≤ 255	100	0.0012	0.0030	0.0050	0.0065	0.0080					
Duroplastics	≤ 25	≤ 255	90	0.0012	0.0030	0.0050	0.0065	0.0080					
Thermoplastics	≤ 32	≤ 301											
Reinforced plastics - Kevlar			55	0.0012	0.0030	0.0050	0.0065	0.0080					
Reinforced plastics - GFK / CFK			90	0.0015	0.0040	0.0065	0.0080	0.0100					