Material group	Hardness HRC	Hardness BHN	SFM	Feed Rate - IPR 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	- ≤ 32	≤ 150 ≤ 301											
Free-cutting steels	≤ 25 ≤ 32	≤ 255 ≤ 301	235		0.0040	0.0065	0.0080	0.0100					
Unalloyed heat-treatable steels	≤ 20 ≤ 25 ≤ 32	≤ 220 ≤ 255 ≤ 301	210 120		0.0040 0.0030	0.0065 0.0050	0.0080 0.0065	0.0100 0.0080					
Alloyed heat-treatable steels	≤ 32 ≤ 43	≤ 301 ≤ 402	145 120		0.0030 0.0025	0.0050 0.0040	0.0065 0.0050	0.0080 0.0065					
Unalloyed case hardened steels	≤ 25	≤ 255											
Alloyed case hardened steels	≤ 32 ≤ 43	≤ 301 ≤ 402	130 100		0.0030 0.0025	0.0050 0.0040	0.0065 0.0050	0.0080 0.0065					
Nitriding steels	≤ 32 ≤ 43	≤ 301 ≤ 402	120 85		0.0030 0.0025	0.0050 0.0040	0.0065 0.0050	0.0080 0.0065					
Tool steels	≤ 25 ≤ 43	≤ 255 ≤ 402	145 85		0.0030 0.0025	0.0050 0.0040	0.0065 0.0050	0.0080 0.0065					
High speed steels	≤ 43	≤ 402	85		0.0025	0.0040	0.0050	0.0065					
Spring steels	≤ 38	≤ 354											
Hardened steels	≤ 48 ≤ 66	≤ 460 -											
Stainless steels, sulphured austenitic martensitic	≤ 28 ≤ 36 ≤ 46	≤ 273 ≤ 337 ≤ 435	120 100		0.0030 0.0025	0.0050 0.0040	0.0065 0.0050	0.0080 0.0065					
Cast iron	≤ 23 ≤ 38	≤ 242 ≤ 354	295 235		0.0050 0.0050	0.0080 0.0080	0.0100 0.0100	0.0125 0.0125					
Spheroidal graphite iron and malleable cast iron	≤ 23 ≤ 38	≤ 242 ≤ 354	260 185		0.0050 0.0050	0.0080 0.0080	0.0100 0.0100	0.0125 0.0125					
Chilled cast iron	≤ 38	≤ 354	60		0.0025	0.0040	0.0050	0.0065					
New cast materials GGV	≤ 20 ≤ 32	≤ 220 ≤ 301											
New cast materials ADI	≤ 32 ≤ 43	≤ 301 ≤ 402											
Special alloys	≤ 54	≤ 549											
Ti and Ti-alloys	≤ 25 ≤ 43	≤ 255 ≤ 402											
Aluminium and Al-alloys	-	≤ 120											
Al wrought alloys	-	≤ 200											
Al cast alloys ≤ 10 % Si ≤ 24 % Si	- -	≤ 180 ≤ 180	560 460		0.0065 0.0040	0.0100 0.0065	0.0125 0.0080	0.0160 0.0100					
Magnesium alloys	-	≤ 120											
Copper, low-alloyed	-	≤ 150	295		0.0040	0.0065	0.0080	0.0100					
Brass, short-chipping long-chipping	- -	≤ 180 ≤ 180	340		0.0065	0.0080	0.0100	0.0100					
Bronze, short-chipping	- ≤ 25	≤ 180 ≤ 255											
Bronze, long-chipping	≤ 25 ≤ 32	≤ 255 ≤ 301	235 185		0.0030 0.0030	0.0050 0.0050	0.0065 0.0065	0.0080 0.0080					
Duroplastics Thermoplastics Reinforced plastics - Kevlar Reinforced plastics - GFK / CFK			145		0.0030	0.0050	0.0065	0.0080					

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