



# MACHINING CONDITIONS

## APMT 1604 PDTR LT 30

FM001134

Material Group	Lamina Group	Material Example	Hardness	D.O.C		Feed		Vc		Advised D.O.C	Advised Feed	Advised Vc	
				min[mm]	max[mm]	min[mm/t]	max[mm/t]	min[m/min]	max [m/min]	[mm]	[mm/t]	[m/min]	
Steel	Non Alloyed	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.5	15	0.16	0.3	190	330	4	0.21	250	
			190 HB	0.5	15	0.16	0.3	190	300	4	0.21	220	
			250 HB	0.5	15	0.16	0.3	190	250	4	0.21	200	
	Low Alloyed	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	230 HB	0.5	15	0.14	0.23	150	210	4	0.18	180
				280 HB	0.5	15	0.14	0.2	130	190	4	0.16	150
				180 HB	0.5	15	0.14	0.23	150	240	4	0.18	200
				350 HB	0.5	15	0.14	0.2	130	170	4	0.16	140
	High Alloyed	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	10.7	0.11	0.2	90	150	3	0.16	130
				280 HB	0.5	10.7	0.11	0.2	90	130	3	0.16	120
				320 HB	0.5	10.7	0.11	0.17	60	110	3	0.14	100
				350 HB	0.5	10.7	0.11	0.17	60	90	3	0.14	80
	Stainless Steel	Austenitic	4	304, 316, X5CrNi18-9	180 HB	0.5	15	0.14	0.23	190	250	4	0.18
240 HB					0.5	15	0.11	0.2	160	210	4	0.18	190
Duplex		5	X2CrNiN23-4, S31500	290 HB	0.5	10.7	0.11	0.17	70	130	3	0.14	100
				310 HB	0.5	10.7	0.11	0.17	70	120	3	0.14	90
Ferritic & Martensitic		6	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	15	0.14	0.23	150	210	4	0.18	190
				42 HRc	0.5	10.7	0.14	0.19	90	150	3	0.14	130
Cast Iron	Grey	7	GG20, GG40, EN-GJL-250, N030B	150 HB	0.5	15	0.16	0.3	150	240	4	0.21	200
				200 HB	0.5	15	0.16	0.3	150	220	4	0.21	180
				250 HB	0.5	15	0.16	0.3	150	190	4	0.21	160
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.5	15	0.14	0.26	100	200	4	0.18	180
				200 HB	0.5	15	0.14	0.26	100	180	4	0.18	150
				250 HB	0.5	15	0.14	0.26	100	150	4	0.18	130
NITTI Alloy	Fe, Ni & Co Based	9	Incoloy 800	240 HB	0.5	10.7	0.11	0.17	30	50	3	0.14	32
			Inconel 700	250 HB	0.5	10.7	0.11	0.17	30	50	3	0.14	30
			Stellite 21	350 HB	0.5	10.7	0.11	0.17	30	50	3	0.14	30
	Ti Based	10	T40	-	0.5	10.7	0.11	0.17	30	60	3	0.14	40
			TiAl6V4	-	0.5	10.7	0.11	0.19	40	70	3	0.16	55
	Hardened Materials	Steel Chilled Cast Iron White Cast Iron	11	G-X300CrMo15	55 HRc	0.5	1.6	0.09	0.13	30	60	1	0.11
Ni-Hard 2				400 HB	0.5	4.3	0.09	0.17	40	80	1.5	0.13	50
45 HRc				0.5	5.4	0.09	0.17	40	80	2	0.13	60	
X100CrMo13, 440C, G-X260NiCr42				50 HRc	0.5	3.2	0.09	0.15	40	70	1.5	0.12	55
55 HRc				0.5	1.6	0.09	0.13	40	60	1	0.11	50	
Aluminium	Al (>8%Si)	12	AISI12	130 HB	0.5	15	0.16	0.3	200	400	4	0.22	280