MACHINING CONDITIONS

RDMW 1204 M0 LT 30

M0001551

	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	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.3	4	0.27	0.7	190	350	1.5	0.6	300
				190 HB	0.3	4	0.27	0.65	190	300	1.5	0.6	250
				250 HB	0.3	3	0.27	0.5	190	260	1.5	0.5	220
	Low Alloyed	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	230 HB	0.3	3	0.25	0.57	150	210	1.5	0.55	190
				280 HB	0.3	2	0.23	0.52	130	190	1.5	0.5	150
				180 HB	0.3	4	0.25	0.65	150	240	1.5	0.6	210
				350 HB	0.3	1.5	0.23	0.5	130	170	1	0.5	130
	High Alloyed	3	X40CrM0V5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.3	2	0.2	0.57	90	150	1	0.55	130
				280 HB	0.3	2	0.2	0.52	90	130	1	0.5	120
				320 HB	0.3	1.5	0.2	0.5	60	110	1	0.5	100
				350 HB	0.3	1.5	0.2	0.47	60	90	1	0.45	90
Cast Iron	Grey	7	GG20, GG40, EN-GJL-250, N030B	150 HB	0.3	3	0.2	0.8	170	300	2	0.8	200
				200 HB	0.3	3	0.2	0.8	170	250	2	0.7	170
				250 HB	0.3	3	0.2	0.8	150	210	2	0.6	150
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.3	2.5	0.2	0.6	120	210	1.5	0.5	210
				200 HB	0.3	2.5	0.2	0.6	120	170	1.5	0.55	170
				250 HB	0.3	2.5	0.2	0.6	120	150	1.5	0.6	150
Hardened Materials	Steel Chilled Cast Iron White Cast Iron	11	G-X300CrMo15	55 HRc	0.3	0.5	0.18	0.34	30	60	0.5	0.34	30
			Ni-Hard 2	400 HB	0.3	1	0.18	0.38	40	60	0.5	0.38	50
			X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.3	1	0.18	0.38	40	80	0.5	0.38	60
				50 HRc	0.3	0.8	0.18	0.34	40	70	0.5	0.34	50
				55 HRc	0.3	0.5	0.18	0.3	40	60	0.5	0.3	40