



MACHINING CONDITIONS

SNKX 1607-45 LT 30

M0002205

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	6.5	0.16	0.58	190	330	4	0.46	250	
			190 HB	0.5	6.5	0.16	0.58	190	300	4	0.46	220	
			250 HB	0.5	6.5	0.16	0.58	190	250	4	0.46	200	
	Low Alloyed	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	230 HB	0.5	6.5	0.14	0.5	150	210	4	0.4	180
				280 HB	0.5	6.5	0.14	0.44	130	190	4	0.36	150
				180 HB	0.5	6.5	0.14	0.5	150	240	4	0.4	200
				350 HB	0.5	6.5	0.14	0.44	130	170	4	0.36	140
	High Alloyed	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	6.5	0.11	0.44	90	150	3	0.36	130
				280 HB	0.5	6.5	0.11	0.44	90	130	3	0.36	120
				320 HB	0.5	6.5	0.11	0.36	60	110	3	0.32	100
				350 HB	0.5	6.5	0.11	0.36	60	90	3	0.32	80
	Stainless Steel	Austentic	4	304, 316, X5CrNi18-9	180 HB	0.5	6.5	0.14	0.44	190	250	4	0.34
240 HB					0.5	6.5	0.11	0.4	160	210	4	0.34	190
Duplex		5	X2CrNiN23-4, S31500	290 HB	0.5	5	0.11	0.36	70	130	3	0.3	100
				310 HB	0.5	5	0.11	0.36	70	120	3	0.3	90
Ferritic & Martensitic		6	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	6.5	0.14	0.44	150	210	4	0.34	190
				42 HRc	0.5	5	0.14	0.4	90	150	3	0.3	130
Cast Iron	Grey	7	GG20, GG40, EN-GJL-250, N030B	150 HB	0.5	6.5	0.17	0.58	150	240	4	0.46	200
				200 HB	0.5	6.5	0.17	0.58	150	220	4	0.46	180
				250 HB	0.5	6.5	0.17	0.58	150	190	4	0.46	160
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.5	6.5	0.14	0.52	100	200	4	0.4	180
				200 HB	0.5	6.5	0.14	0.52	100	180	4	0.4	150
				250 HB	0.5	6.5	0.14	0.52	100	150	4	0.4	130
NITTI Alloy	Fe, Ni & Co Based	9	Incoloy 800	240 HB	0.5	5	0.11	0.36	30	50	3	0.3	32
			Inconel 700	250 HB	0.5	5	0.11	0.36	30	50	3	0.3	30
			Stellite 21	350 HB	0.5	5	0.11	0.36	30	50	3	0.3	30
	Ti Based	10	T40	-	0.5	5	0.11	0.36	30	60	3	0.3	40
			TiAl6V4	-	0.5	5	0.11	0.4	40	70	3	0.34	55
Hardened Materials	Steel Chilled Cast Iron White Cast Iron	11	G-X300CrMo15	55 HRc	0.4	1.5	0.09	0.28	30	60	1	0.24	40
			Ni-Hard 2	400 HB	0.4	3	0.09	0.36	40	80	1.5	0.28	50
			X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.4	3	0.09	0.36	40	80	2	0.28	60
				50 HRc	0.4	3	0.09	0.32	40	70	1.5	0.26	55
				55 HRc	0.4	1.5	0.09	0.28	40	60	1	0.24	50
Aluminium	Al (>8%Si)	12	AISI12	130 HB	0.5	6.5	0.17	0.6	200	400	4	0.5	280