



# MACHINING CONDITIONS

TCMT 16T308 NN LT 1000

T0001928

Material Group	Lamina Group	Material Example	Hardness	D.O.C		Feed		Amax	Vc		Advised D.O.C	Advised Feed	Advised Vc	
				min[mm]	max[mm]	min[mm/t]	max [mm/t]	[mm^2]	min [m/min]	max [m/min]	[mm]	[mm/t]	[m/min]	
Steel	Non Alloyed	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.5	5	0.21	0.43	1.62	180	330	3	0.34	240	
			190 HB	0.5	5	0.21	0.43	1.62	180	280	3	0.32	220	
			250 HB	0.5	5	0.21	0.38	1.35	180	250	3	0.3	200	
	Low Alloyed	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	230 HB	0.5	4	0.21	0.38	1.08	120	250	3	0.29	180
				280 HB	0.5	4	0.18	0.34	1.08	120	210	3	0.27	150
				180 HB	0.5	5	0.21	0.38	1.08	120	280	3	0.29	200
				350 HB	0.5	3.5	0.18	0.34	0.9	120	180	2.7	0.27	130
	High Alloyed	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	4	0.18	0.34	1.08	70	190	2.5	0.27	140
				280 HB	0.5	4	0.18	0.34	1.08	70	150	2.5	0.27	120
				320 HB	0.5	3	0.18	0.3	0.72	70	130	2.2	0.25	100
				350 HB	0.5	3	0.18	0.3	0.72	70	110	2.2	0.25	90
	Stainless Steel	Austentic	4	304, 316, X5CrNi18-9	180 HB	0.5	5	0.2	0.34	1.08	170	270	3	0.23
240 HB					0.5	5	0.2	0.34	0.9	160	220	3	0.2	170
Duplex		5	X2CrNiN23-4, S31500	290 HB	0.5	4	0.18	0.3	0.72	80	150	2.5	0.22	100
				310 HB	0.5	4	0.18	0.3	0.72	70	140	2.5	0.22	90
Ferritic & Martensitic		6	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	5	0.18	0.34	0.63	170	250	2.5	0.18	190
				42 HRc	0.5	4	0.18	0.34	0.63	120	190	2.2	0.18	130
Cast Iron	Grey	7	GG20, GG40, EN-GJL-250, N030B	150 HB	0.5	5	0.15	0.51	1.8	170	250	3	0.32	200
				200 HB	0.5	5	0.15	0.51	1.62	160	230	3	0.32	180
				250 HB	0.5	5	0.15	0.47	1.62	150	210	3	0.32	160
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.5	5	0.15	0.43	1.35	120	250	3	0.27	180
				200 HB	0.5	5	0.15	0.43	1.17	120	230	3	0.27	160
				250 HB	0.5	5	0.15	0.43	1.08	120	190	3	0.27	140
NITTI Alloy	Fe, Ni & Co Based	9	Incoloy 800	240 HB	0.5	3	0.2	0.3	0.63	30	50	2	0.25	30
			Inconel 700	250 HB	0.5	3	0.2	0.3	0.63	30	50	2	0.25	30
			Stellite 21	350 HB	0.5	3	0.2	0.3	0.63	30	40	2	0.25	30
	Ti Based	10	T40	-	0.5	3	0.2	0.3	0.63	40	60	2	0.27	45
			TiAl6V4	-	0.5	3.5	0.2	0.34	0.72	50	70	2	0.3	55
Hardened Materials	Steel Chilled Cast Iron White Cast Iron	11	G-X300CrMo15	55 HRc	0.5	1.5	0.11	0.17	0.27	30	50	1	0.14	40
			Ni-Hard 2	400 HB	0.5	2	0.11	0.21	0.36	40	60	1.5	0.16	50
			X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	2.5	0.11	0.26	0.54	50	100	2	0.23	80
				50 HRc	0.5	2	0.11	0.21	0.36	40	90	1.5	0.18	70
				55 HRc	0.5	1.5	0.11	0.17	0.27	40	80	1	0.16	60
Aluminium	Al (>8%Si)	12	AISI12	130 HB	0.5	6	0.2	0.51	1.62	200	400	3	0.36	280

