

# RCMT 0602 M0

## Machining Conditions

Material Group	Group No.	Material Examples*	Brinell hardness HB	d.o.c [mm]		feed [mm/rev]		A max [mm <sup>2</sup> ]	V <sub>c</sub> [m/min]		Optimal cutting conditions	
				min	max	min	max		min	max	d.o.c	feed
Low Carbon Steel	1	Ck15 9SMnPb28	150	0.50	2.00	0.15	0.35	0.51	180	400	0.5 to 2	0.35
			180		2.00		0.35	0.44		350		
			210		1.50		0.35	0.44		200		
Alloy Steel	2	42 CrMo 4 100 Cr 6 32 NiCrMo 14.5	180	0.50	2.00	0.15	0.30	0.44	120	300	0.5 to 2	0.30
			230		2.00		0.30	0.38		250		
			280		2.00		0.30	0.32		210		
			320		1.50		0.25	0.25		180		
High Alloy Steel	3	X38 CrMoV 5 X210 CrW 12 X90 CrMoV 8	220	0.50	2.00	0.13	0.30	0.38	70	190	0.5 to 2	0.28
			280		2.00		0.30	0.32		150		
			320		1.50		0.30	0.25		130		
			350		1.50		0.25	0.19		100		
Austenitic Stainless Steel	4	303 / 304 304 L	210 to 250	0.50	2.00	0.14	0.25	0.25	170	270	0.5 to 2	0.35
			230 to 270		2.00	0.13	0.18	0.19	170	210	0.5 to 2	0.32
			316 Ti 630 (F16PH)		-----	1.50	0.13	0.18	0.19	80	130	0.5 to 2
Ferritic Stainless Steel	7	430 / 439 / 444	Annealed	0.50	2.00	0.15	0.20	0.25	170	250	0.5 to 2	0.32
Martensitic Stainless Steel	8	410 / 420	Annealed Treated	0.50	2.00	0.15	0.20	0.25	170 120	250 210	0.5 to 2	0.32
Grey Cast Iron	9	EN - GJL 200 EN - GJL 250 EN - GJL 300	140 to 230	0.50	2.00	0.11	0.45	0.64	170	280	0.5 to 2	0.35
			0.57					250				
			0.57					230				
Nodular Cast Iron	10	EN - GJS 400 EN - GJS 600 EN - GJS 800	210	0.50	2.00	0.11	0.35	0.48	120	230	0.5 to 2	0.30
			260					0.41		190		
			310					0.38		150		
Nickel Based Alloys	11	Inconel 625 Inconel 718 Hastelloy C	-----	0.50	1.50	0.13	0.18	0.20	25	35	0.5 to 2	0.28
			0.20					40				
			0.24					65				
Titanium Based Alloys	12	TiAl 6 V4 T40	-----	0.50	1.50	0.13	0.18	0.24	35	60	0.5 to 2	0.30
			0.15				0.24	28	40	0.5 to 2	0.28	

\*For all material types and standards, see pages 155 to 158.

Insert designation

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Super Finishing



Finishing



Semi Finishing



Roughing



Interrupted Cut



Lamina Technologies