RCMT 10T3 M0

Machining Conditions

Material Group	Group No.	Material Examples*	Brinell hardness HB	d.o.c [mm]		feed [mm/rev]		A max [mm²]	V_c [m/min]		Optimal cutting conditions	
				min	max	min	max		min	max	d.o.c	feed
Low Carbon Steel	1	Ck 15 9SMnPb28	150	0.50	3.00	0.20	0.49	1.00	180	400	0.5 to 2	0.35
			180		3.00		0.49	1.00		350		
			210		2.00		0.49	0.88		200		
Alloy Steel	2	42 CrMo 4 100 Cr 6 32 NiCrMo 14.5	180	0.50	3.00	0.20	0.42	0.88	120	300	0.5 to 2	0.30
			230		2.00		0.42	0.84		250		
			280		2.00	0.16	0.42	0.75		210		
			320		2.00		0.35	0.50		180		
High Alloy Steel	3	X38 CrMoV 5 X210 CrW 12 X90 CrMoV 8	220	0.50	2.00	0.16	0.42	0.75	70	190	0.5 to 2	0.28
			280		2.00		0.42	0.63		150		
			320		1.50		0.42	0.50		130		
			350		1.50		0.35	0.37		100		
Austenitic Stainless Steel	4	303 / 304 304 L	210 to 250	0.50	2.00	0.18	0.35	0.36	170	270	0.5 to 2	0.35
	5	316 / 316 L	230 to 270		2.00	0.16	0.25	0.27	170	210	0.5 to 2	0.32
	6	316 Ti 630 (F16PH)	--------		1.50	0.16	0.25	0.27	80	130	0.5 to 2	0.28
Ferritic Stainless Steel	7	430 / 439 / 444	Annealed	0.50	2.00	0.20	0.28	0.36	170	250	0.5 to 2	0.32
Martensitic Stainless Steel	8	410 / 420	Annealed	0.50	2.00	0.20	0.28	0.36	170	250	0.5 to 2	0.32
			Treated						120	210		
Grey Cast Iron	9	EN - GJL 200	140 to 230	0.50	3.00	0.14	0.63	1.26	170	280	0.5 to 2	0.35
		EN - GJL 250						1.13		250		
		EN - GJL 300						1.13		230		
Nodular Cast Iron	10	EN - GJS 400	210	0.50	3.00	0.14	0.49	0.94	120	230	0.5 to 2	0.30
		EN - GJS 600	260					0.82		190		
		EN - GJS 800	310					0.75		150		
Nickel Based Alloys	11	Inconel 625	--------	0.50	1.50	0.16	0.25	0.25	25	35	0.5 to 2	0.28
		Inconel 718						0.25		40		
		Hastelloy C						0.30		65		
Titanium Based Alloys	12	TiAl 6 V4	--------	0.50	1.50	0.16	0.25	0.30	35	60	0.5 to 2	0.30
		T40					0.21	0.30	28	40	0.5 to 2	0.28

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

Insert designation	Super Finishing	Finishing	Semi Finishing	Roughing	Interrupted Cut
RCMT 10T3 MO	1 2 3 4	1 2 3 4	1 2 3 4	1 2 3 4	1 2 3 4

Lamina Technologies