

# RCMT 1204 MO

## 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	4.00	0.22	0.70	1.44	180	400	1.5 to 3	0.35	
			180		4.00		0.70	1.44		350			
			210		3.00		0.70	1.26		200			
Alloy Steel	2	42 CrMo 4 100 Cr 6 32 NiCrMo 14.5	180	0.50	4.00	0.22	0.60	1.26	120	300	1.5 to 3	0.30	
			230		3.00		0.60	1.08		250			
			280		3.00	0.18	0.60	0.90		210			
			320		2.50		0.50	0.72		180			
High Alloy Steel	3	X38 CrMoV 5 X210 CrW 12 X90 CrMoV 8	220	0.50	3.00	0.18	0.60	1.08	70	190	1.5 to 3	0.28	
			280		3.00		0.60	0.90		150			
			320		2.00		0.60	0.72		130			
			350		2.00		0.50	0.54		100			
Austenitic Stainless Steel	4	303 / 304 304 L	210 to 250	0.50	3.00	0.20	0.50	0.72	170	270	1.5 to 3	0.35	
			230 to 270		3.00		0.18	0.35		0.54			210
			316 Ti 630 (F16PH)		-----		2.00	0.18		0.35			0.54
Ferritic Stainless Steel	7	430 / 439 / 444	Annealed	0.50	3.00	0.22	0.40	0.72	170	250	1.5 to 3	0.32	
Martensitic Stainless Steel	8	410 / 420	Annealed Treated	0.50	3.00	0.22	0.40	0.72	170 120	250 210	1.5 to 3	0.32	
Grey Cast Iron	9	EN - GJL 200	140 to 230	0.50	4.00	0.15	0.90	1.80	170	280	1.5 to 3	0.35	
		EN - GJL 250						1.62		250			
		EN - GJL 300						1.62		230			
Nodular Cast Iron	10	EN - GJS 400	210 to 310	0.50	4.00	0.15	0.70	1.35	120	230	1.5 to 3	0.30	
		EN - GJS 600						1.17		190			
		EN - GJS 800						1.08		150			
Nickel Based Alloys	11	Inconel 625	-----	0.50	2.00	0.18	0.35	0.50	25	35	1.5 to 3	0.28	
		Inconel 718						0.50		40			
		Hastelloy C						0.60		65			
Titanium Based Alloys	12	TiAl 6 V4	-----	0.50	2.00	0.18	0.35	35	60	1.5 to 3	0.30		
		T40					0.30		0.60			28	40

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

Insert designation

Super Finishing

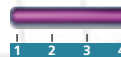
Finishing

Semi Finishing

Roughing

Interrupted Cut

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Lamina Technologies