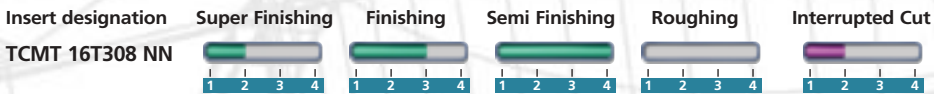


# TCMT 16T308 NN

## 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	5.00	0.21	0.45	1.50	180	400	1 to 2.5	0.32	
			180		4.00		0.40	1.50		350			
			210		4.00		0.35	1.20		200			
Alloy Steel	2	42 CrMo 4 100 Cr 6 32 NiCrMo 14.5	180	0.50	4.00	0.21	0.40	1.00	120	300	1 to 2.5	0.30	
			230		4.00		0.40	1.00		250			
			280		3.00		0.35	1.00		210			
			320		3.00		0.32	0.80		180			
High Alloy Steel	3	X38 CrMoV 5 X210 CrW 12 X90 CrMoV 8	220	0.50	4.00	0.18	0.35	1.00	70	190	1 to 2.5	0.28	
			280		4.00		0.32	1.00		150			
			320		3.00		0.28	0.70		130			
			350		3.00		0.28	0.60		100			
Austenitic Stainless Steel	4	303 / 304 304 L	210 to 250	0.50	4.00	0.20	0.35	0.80	170	270	1 to 2.5	0.30	
			230 to 270		3.00		0.18	0.32		0.60			210
			316 Ti 630 (F16PH)		3.00		0.18	0.28		0.50			80
Ferritic Stainless Steel	7	430 / 439 / 444	Annealed	0.50	3.00	0.22	0.35	0.70	170	250	1 to 2.5	0.28	
Martensitic Stainless Steel	8	410 / 420	Annealed Treated	0.50	3.00	0.22	0.35	0.70	170 120	250 210	1 to 2.5	0.28	
Grey Cast Iron	9	EN - GJL 200	140 to 230	0.50	5.00	0.15	0.40	1.60	170	280	1 to 3	0.32	
		EN - GJL 250						1.50		250			
		EN - GJL 300						1.50		230			
Nodular Cast Iron	10	EN - GJS 400	210	0.50	4.00	0.15	0.35	1.20	120	230	1 to 2.5	0.28	
		EN - GJS 600						1.00		190			
		EN - GJS 800						1.00		150			
Nickel Based Alloys	11	Inconel 625	-----	0.50	3.00	0.20	0.32	0.60	25	35	1 to 2.5	0.25	
		Inconel 718						0.60		40			
		Hastelloy C						0.70		65			
Titanium Based Alloys	12	TiAl 6 V4	-----	0.50	3.00	0.18	0.32	35	60	1 to 2.5	0.25		
		T40					0.28		0.60			28	40

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



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