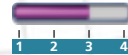


Material Group	Group No.	Material Examples*	Brinell hardness HB	d.o.c [mm]		feed [mm/rev]		A max [mm ²]	V _c [m/min]		Optimal cutting conditions		
				min	max	min	max		min	max	d.o.c	feed	
Low Carbon Steel	1	Ck15 9SMnPb28	150	0.50	7.00	0.21	0.45	1.80	180	400	1.5 to 5	0.35	
			180		7.00		0.45	1.80		350			
			210		5.00		0.40	1.50		200			
Alloy Steel	2	42 CrMo 4 100 Cr 6 32 NiCrMo 14.5	180	0.50	7.00	0.23	0.40	1.50	120	300	1.5 to 4	0.30	
			230		7.00		0.40	1.20		250			
			280		5.00		0.35	1.20		210			
			320		4.00		0.35	1.00		180			
High Alloy Steel	3	X38 CrMoV 5 X210 CrW 12 X90 CrMoV 8	220	0.50	5.00	0.21	0.40	1.20	70	190	1.5 to 4	0.28	
			280		5.00		0.40	1.20		150			
			320		4.00		0.35	0.80		130			
			350		4.00		0.35	0.80		100			
Austenitic Stainless Steel	4	303 / 304 304 L	Annealed	0.50	5.00	0.20	0.40	1.00	170	270	1.5 to 5	0.35	
			Annealed		4.00		0.18	0.35		0.80			210
			Annealed		4.00		0.18	0.35		0.60			130
Ferritic Stainless Steel	7	430 / 439 / 444	Annealed	0.50	4.00	0.22	0.35	0.90	170	250	1.5 to 5	0.32	
Martensitic Stainless Steel	8	410 / 420	Annealed Treated	0.50	4.00	0.22	0.35	0.90	170 120	250 210	1.5 to 5	0.32	
Grey Cast Iron	9	EN - GJL 200 EN - GJL 250 EN - GJL 300	140 to 230	0.50	7.00	0.20	0.60	2.00	170	280	1.5 to 7	0.35	
			1.80					250					
			1.80					230					
Nodular Cast Iron	10	EN - GJS 400 EN - GJS 600 EN - GJS 800	210	0.50	7.00	0.20	0.50	1.50	120	230	1.5 to 5	0.30	
			1.30					190					
			1.20					150					
Nickel Based Alloys	11	Inconel 625 Inconel 718 Hastelloy C	-----	0.50	5.00	0.18	0.35	0.70	25	35	1.5 to 4	0.28	
			0.70					40					
			0.80					65					
Titanium Based Alloys	12	TiAl 6 V4 T40	-----	0.50	5.00	0.18	0.35	35	60	1.5 to 4	0.30		
			0.30				0.60		28			40	1.5 to 4

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

Insert designation **Super Finishing** **Finishing** **Semi Finishing** **Roughing** **Interrupted Cut**

TNMG 220408 NN



Lamina Technologies