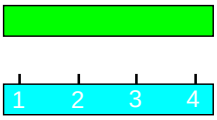
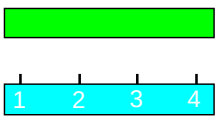
TNGG 160404-Alu

Material grpoup	Group No	Material Examples	Hardness Brinell	d.o.c [mm]		feed [mm/t]		A max [mm2]	Vc [m/min]		Recommended point	
				min	max	min	max		min	max	d.o.c	feed
Low carbon Steel	1	XC 12 S 250 Pb	150	-----	-----	-----	-----	-----	-----	-----	-----	-----
			180									
			210									
Alloy Steel	2	42 CrMo 4 100 Cr 6 32 NiCrMo 14.5	180	-----	-----	-----	-----	-----	-----	-----	-----	-----
			230									
			280									
			320									
High alloy Steel	3	X38 CrMoV 5 X210 CrW 12 X90 CrMoV 8	220	-----	-----	-----	-----	-----	-----	-----	-----	-----
			280									
			320									
			350									
Austenitic Stainless Steel	4	303 / 304 304 L	Annealed	-----	-----	-----	-----	-----	-----	-----	-----	-----
	5	316 / 316 L	Annealed	-----	-----	-----	-----	-----	-----	-----	-----	-----
	6	316 Ti 630 (F16PH)	Annealed	-----	-----	-----	-----	-----	-----	-----	-----	-----
Ferritic Stainless Steel	7	430 / 439 444	Annealed	-----	-----	-----	-----	-----	-----	-----	-----	-----
Martensitic Stainless Steel	8	410 / 420	Annealed	-----	-----	-----	-----	-----	-----	-----	-----	-----
			Treated									
Grey cast Iron	9	EN - GJL 200	140 à 230	-----	-----	-----	-----	-----	-----	-----	-----	------
		EN - GJL 250										
		EN - GJL 300										
Nodular Cast Iron	10	EN - GJS 400	210	-----	-----	-----	-----	-----	-----	-----	-----	------
		EN - GJS 600	260									
		EN - GJS 800	310									
Aluminum		Si < 4%	---------	0.25	5	0.12	0.3	1.5	400	1200	----	----
		4% < Si < 9%		0.25	5	0.1	0.28	1.2	250	800		
		Si > 9%		-----	-----	-----	-----	-----	-----	-----	-----	-----
Nickel based Alloys		Inconel 625	--------	-----	-----	-----	-----	-----	-----	-----	----	----
		Inconel 718	--------									
		Hastelloy C	--------									
Titanium based Alloys		TiAl 6 V4	--------	-----	-----	-----	-----	-----	-----	-----	-----	-----
		T40	--------									

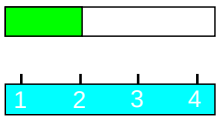
Super finishing



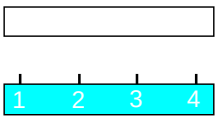
Finishing



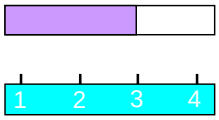
Semi-finishing



Roughing



Interrupted cut



Conclusions:

Super finishing	excellent for the application
Finishing	excellent for the application
Semi-finishing	acceptable for the application
Roughing	not recommanded
Interrupted cut	good for the application