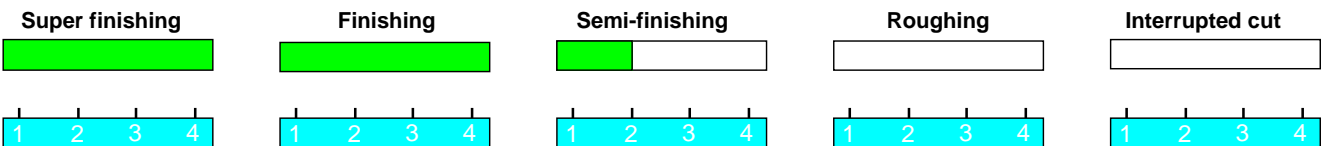


TBMT 060404 L-NN

Material group	Group No	Material Examples	Hardness Brinell	d.o.c [mm]		feed [mm/t]		A max [mm ²]	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	0.2	3	0.11	0.23	0.6	180	400	0.5 to 2	0.18							
			180		2.5		0.2			0.48			350						
			210		2.5		0.18			0.48			200						
Alloy Steel	2	42 CrMo 4 100 Cr 6 32 NiCrMo 14.5	180	0.2	2.5	0.11	0.2	0.48	120	300	0.5 to 1.5	0.15							
			230				0.2			0.4			250						
			280		2	0.1	0.18	0.4		210									
			320				0.16	0.32		180									
High alloy Steel	3	X38 CrMoV 5 X210 CrW 12 X90 CrMoV 8	220	0.2	2.5	0.09	0.18	0.4	70	190	0.5 to 1.5	0.12							
			280				0.16			0.4			150						
			320				2			0.14			0.28	130					
			350											0.14	0.24	100			
Austenitic Stainless Steel	4	303 / 304 304 L	Annealed	0.2	2.5	0.1	0.18	0.32	170	270	0.5 to 2	0.15							
	5	316 / 316 L	Annealed										0.09	0.16	0.24	120	210	0.5 to 2	0.12
	6	316 Ti 630 (F16PH)	Annealed										0.09	0.14	0.2	70	120	0.5 to 2	0.12
Ferritic Stainless Steel	7	430 / 439 444	Annealed	0.2	2	0.11	0.18	0.28	170	250	1 to 2.5	0.15							
Martensitic Stainless Steel	8	410 / 420	Annealed	0.2	2	0.11	0.18	0.28	170	250	1 to 2.5	0.15							
			Treated						120	210									
Grey Cast Iron	9	EN - GJL 200	140 à 230	0.2	3	0.08	0.2	0.64	170	280	0.5 to 2	0.18							
		EN - GJL 250								0.6			250						
		EN - GJL 300								0.6			230						
Nodular Cast Iron	10	EN - GJS 400	210	0.2	2.5	0.08	0.18	0.48	120	230	0.5 to 2	0.15							
		EN - GJS 600	260					0.4		190									
		EN - GJS 800	310					0.4		150									
Aluminum		Si < 4%	-----	---	---	---	---	---	---	---	---	---							
		4% < Si < 9%																	
		Si > 9%																	
Nickel based Alloys		Inconle 625	-----	0.25	2	0.1	0.16	0.24	25	35	0.5 to 1.5	0.12							
		Inconel 718						0.24		28			40						
		Hastelloy C						0.28		40			65						
Titanium based Alloys		TiAl 6 V4	-----	0.25	2	0.1	0.16	0.28	35	60	0.5 to 1.5	0.14							
		T40					0.14					0.24	28	40	0.12				



Conclusions:

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