MACHINING CONDITIONS

DNMG 150608 NX LT 1110S

T0004709

Material Group		Lamina Group	Material Example	Hardness	D.O.C		Feed		Amax	Vc		Advised D.O.C	Advised Feed	Advised Vc
					min[mm]	max[mm]	min[mm/t]	max [mm/t]	[mm^2]	min [m/min]	max [m/min]	[mm]	[mm/t]	[m/min]
NiTi Alloy	Fe, Ni & Co Based	9	Incoloy 800	240 HB	0.5	3	0.18	0.35	0.67	30	50	2	0.27	32
			Inconel 700	250 HB	0.5	3	0.18	0.35	0.67	30	50	2	0.27	30
			Stellite 21	350 HB	0.5	3	0.18	0.35	0.67	20	40	2	0.27	28
	Ti Based	10	T40	-	0.5	3	0.18	0.35	0.67	40	60	2	0.29	45
			TiAl6V4	-	0.5	3.5	0.18	0.4	0.76	50	70	2	0.31	55