MACHINING CONDITIONS

TNMP 160408 NN LT 1120M

T0004754

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]
Stainless Steel	Austentic	4	304, 316, X5CrNi18-9	180 HB	0.5	5	0.2	0.4	1.2	90	270	3	0.25	190
				240 HB	0.5	5	0.2	0.4	1	80	220	3	0.22	170
	Duplex	5	X2CrNiN23-4, S31500	290 HB	0.5	4	0.18	0.35	0.8	40	150	2.5	0.24	100
				310 HB	0.5	4	0.18	0.35	0.8	40	140	2.5	0.24	90
	Ferritic & Martensitic	6	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	5	0.18	0.4	0.7	90	250	2.5	0.2	190
				42 HRc	0.5	4	0.18	0.4	0.7	60	190	2.2	0.2	130