



# MACHINING CONDITIONS

## APKT 1705 PETR LT 3000

M0002212

Material Group	SAPPHIRE TOOLS	Material Example	Hardness	D.O.C		Feed		Vc		Advised D.O.C	Advised Feed	Advised Vc	
				min[mm]	max[mm]	min[mm/t]	max[mm/t]	min[m/min]	max[m/min]	[mm]	[mm/t]	[m/min]	
Steel	Non Alloyed	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.5	15	0.18	0.4	190	330	4	0.28	250
				190 HB	0.5	15	0.18	0.4	190	300	4	0.28	220
				250 HB	0.5	15	0.18	0.4	190	250	4	0.28	200
	Low Alloyed	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	230 HB	0.5	15	0.15	0.31	150	210	4	0.24	180
				280 HB	0.5	15	0.15	0.27	130	190	4	0.22	150
				180 HB	0.5	15	0.15	0.31	150	240	4	0.24	200
				350 HB	0.5	15	0.15	0.27	130	170	4	0.22	140
	High Alloyed	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	10.7	0.12	0.27	90	150	3	0.22	130
				280 HB	0.5	10.7	0.12	0.27	90	130	3	0.22	120
				320 HB	0.5	10.7	0.12	0.22	60	110	3	0.19	100
				350 HB	0.5	10.7	0.12	0.22	60	90	3	0.19	80
	Stainless Steel	Austenitic	4	304, 316, X5CrNi18-9	180 HB	0.5	15	0.15	0.31	190	250	4	0.24
240 HB					0.5	15	0.12	0.27	160	210	4	0.24	190
Duplex		5	X2CrNiN23-4, S31500	290 HB	0.5	10.7	0.12	0.22	70	130	3	0.19	100
				310 HB	0.5	10.7	0.12	0.22	70	120	3	0.19	90
Ferritic & Martensitic		6	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	15	0.15	0.31	150	210	4	0.24	190
				42 HRc	0.5	10.7	0.15	0.25	90	150	3	0.19	130
Cast Iron	Grey	7	GG20, GG40, EN-GJL-250, N030B	150 HB	0.5	15	0.18	0.4	150	240	4	0.28	200
				200 HB	0.5	15	0.18	0.4	150	220	4	0.28	180
				250 HB	0.5	15	0.18	0.4	150	190	4	0.28	160
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.5	15	0.15	0.35	100	200	4	0.24	180
				200 HB	0.5	15	0.15	0.35	100	180	4	0.24	150
				250 HB	0.5	15	0.15	0.35	100	150	4	0.24	130
NITTI Alloy	Fe, Ni & Co Based	9	Incoloy 800	240 HB	0.5	10.7	0.12	0.22	30	50	3	0.19	32
			Inconel 700	250 HB	0.5	10.7	0.12	0.22	30	50	3	0.19	30
			Stellite 21	350 HB	0.5	10.7	0.12	0.22	30	50	3	0.19	30
	Ti Based	10	T40	-	0.5	10.7	0.12	0.22	30	60	3	0.19	40
			TiAl6V4	-	0.5	10.7	0.12	0.25	40	70	3	0.22	55
	Hardened Materials	Steel Chilled Cast Iron White Cast Iron	11	G-X300CrMo15	55 HRc	0.5	1.6	0.1	0.17	30	60	1	0.14
Ni-Hard 2				400 HB	0.5	4.3	0.1	0.22	40	80	1.5	0.17	50
X100CrMo13, 440C, G-X260NiCr42				45 HRc	0.5	5.4	0.1	0.22	40	80	2	0.17	60
				50 HRc	0.5	3.2	0.1	0.2	40	70	1.5	0.16	55
				55 HRc	0.5	1.6	0.1	0.17	40	60	1	0.14	50
Aluminium				Al (>8%Si)	12	AlSi12	130 HB	0.5	15	0.18	0.4	200	400