




MACHINING CONDITIONS

CNGG 09T304 NS LT 1110S

T0004581

Material Group		Material Example	Hardness	D.O.C		Feed		Amax [mm ²]	Vc		Advised D.O.C [mm]	Advised Feed [mm/t]	Advised Vc [m/min]	
				min[mm]	max[mm]	min[mm/t]	max [mm/t]		min [m/min]	max [m/min]				
NITi Alloy	Ti Based	10	T40	-	0.3	1.8	0.06	0.14	0.18	50	70	1.3	0.12	60
			TiAl6V4	-	0.3	1.8	0.06	0.12	0.15	40	60	1.3	0.1	50