




MACHINING CONDITIONS

CNMG 120412 NN LT 1110S

T0004715

Material 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]	
NITTI Alloy	Fe, Ni & Co Based	9	Incoloy 800	240 HB	0.7	3.6	0.25	0.47	1.19	30	50	2.7	0.37	32
			Inconel 700	250 HB	0.7	3.6	0.25	0.47	1.19	30	50	2.7	0.37	30
			Stellite 21	350 HB	0.7	3.6	0.25	0.47	1.19	20	40	2.7	0.37	28
	Ti Based	10	T40	-	0.7	3.6	0.25	0.47	1.19	40	60	2.7	0.4	45
			TiAl6V4	-	0.7	4.2	0.25	0.54	1.36	50	70	2.7	0.44	55