



MACHINING CONDITIONS

LDMT 1504 PDSR LT30

M0001772

Material Group	SAPPHIRE TOOLS	Material Example	Hardness	D.O.C		Feed		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]				
Steel	Non Alloyed	1 C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.5	14	0.18	0.32	190	330	4	0.23	250	
			190 HB	0.5	14	0.18	0.32	190	300	4	0.23	220	
			250 HB	0.5	14	0.18	0.32	190	250	4	0.23	200	
	Low Alloyed	2 42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	230 HB	0.5	14	0.15	0.25	150	210	4	0.2	180	
			280 HB	0.5	14	0.15	0.22	130	190	4	0.18	150	
			180 HB	0.5	14	0.15	0.25	150	240	4	0.2	200	
			350 HB	0.5	14	0.15	0.22	130	170	4	0.18	140	
	High Alloyed	3 X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	10	0.12	0.22	90	150	3	0.18	130	
			280 HB	0.5	10	0.12	0.22	90	130	3	0.18	120	
			320 HB	0.5	10	0.12	0.18	60	110	3	0.16	100	
			350 HB	0.5	10	0.12	0.18	60	90	3	0.16	80	
	Stainless Steel	Austentic	4 304, 316, X5CrNi18-9	180 HB	0.5	14	0.15	0.25	190	250	4	0.2	220
240 HB				0.5	14	0.12	0.22	160	210	4	0.2	190	
Duplex		5 X2CrNiN23-4, S31500	290 HB	0.5	10	0.12	0.18	70	130	3	0.16	100	
			310 HB	0.5	10	0.12	0.18	70	120	3	0.16	90	
Ferritic & Martensitic		6 410, X6Cr17, 17-4 PH, 430	200 HB	0.5	14	0.15	0.25	150	210	4	0.2	190	
			42 HRc	0.5	10	0.15	0.2	90	150	3	0.16	130	
Cast Iron	Grey	7 GG20, GG40, EN-GJL-250, N030B	150 HB	0.5	14	0.18	0.32	150	240	4	0.23	200	
			200 HB	0.5	14	0.18	0.32	150	220	4	0.23	180	
			250 HB	0.5	14	0.18	0.32	150	190	4	0.23	160	
	Malleable & Nodular	8 GGG40, GGG70, 50005	150 HB	0.5	14	0.15	0.28	100	200	4	0.2	180	
			200 HB	0.5	14	0.15	0.28	100	180	4	0.2	150	
			250 HB	0.5	14	0.15	0.28	100	150	4	0.2	130	
NITI Alloy	Fe, Ni & Co Based	9	Incoloy 800	240 HB	0.5	10	0.12	0.18	30	50	3	0.16	32
			Inconel 700	250 HB	0.5	10	0.12	0.18	30	50	3	0.16	30
			Stellite 21	350 HB	0.5	10	0.12	0.18	30	50	3	0.16	30
	Ti Based	10	T40	-	0.5	10	0.12	0.18	30	60	3	0.16	40
TiAl6V4			-	0.5	10	0.12	0.2	40	70	3	0.18	55	
Hardened Materials	Steel Chilled Cast Iron White Cast Iron	11	G-X300CrMo15	55 HRc	0.5	1.5	0.1	0.14	30	60	1	0.12	40
			Ni-Hard 2	400 HB	0.5	4	0.1	0.18	40	80	1.5	0.14	50
			X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	5	0.1	0.18	40	80	2	0.14	60
				50 HRc	0.5	3	0.1	0.16	40	70	1.5	0.13	55
				55 HRc	0.5	1.5	0.1	0.14	40	60	1	0.12	50
Aluminium	Al (>8%Si)	12	AlSi12	130 HB	0.5	14	0.18	0.32	200	400	4	0.25	280