



MACHINING CONDITIONS

SNMG 120412 NN LT 1120M

T0004743

Material Group	SAPPHIRE CUTTING TOOLS 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	0.7	6	0.35	0.76	2.64	90	270	4	0.47	190
				240 HB	0.7	6	0.35	0.76	2.2	80	220	4	0.41	170
	Duplex	5	X2CrNiN23-4, S31500	290 HB	0.7	4.8	0.32	0.67	1.76	40	150	3.4	0.45	100
				310 HB	0.7	4.8	0.32	0.67	1.76	40	140	3.4	0.45	90
	Ferritic & Martensitic	6	410, X6Cr17, 17-4 PH, 430	200 HB	0.7	6	0.32	0.76	1.54	90	250	3.4	0.37	190
				42 HRc	0.7	4.8	0.32	0.76	1.54	60	190	2.9	0.37	130