




MACHINING CONDITIONS

DNGG 110404 NS LT 1110S

T0004593

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 Ti Based	10	T40	-	0.3	1.7	0.06	0.14	0.17	50	70	1.3	0.12	60
		TiAl6V4	-	0.3	1.7	0.06	0.12	0.14	40	60	1.3	0.1	50