



MACHINING CONDITIONS

DNMG 150404 NN LT 1000

T0001907

| Material Group | SAPPHIRE TOOLS | 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] | |
| Steel | Non Alloyed | 1 | C35, Ck45, 1020, 1045, 1060, 28Mn6 | 125 HB | 0.3 | 3 | 0.11 | 0.23 | 0.6 | 180 | 330 | 2 | 0.18 | 300 |
| | | | | 190 HB | 0.3 | 2.5 | 0.11 | 0.22 | 0.52 | 180 | 280 | 2 | 0.18 | 260 |
| | | | | 250 HB | 0.3 | 2.5 | 0.11 | 0.2 | 0.48 | 180 | 250 | 2 | 0.18 | 240 |
| | Low Alloyed | 2 | 42CrMo4, St50, Ck60, 4140, 4340, 100Cr6 | 230 HB | 0.3 | 2.5 | 0.1 | 0.2 | 0.48 | 120 | 250 | 2 | 0.14 | 240 |
| | | | | 280 HB | 0.3 | 2 | 0.1 | 0.18 | 0.4 | 120 | 210 | 2 | 0.13 | 200 |
| | | | | 180 HB | 0.3 | 2.5 | 0.1 | 0.2 | 0.5 | 120 | 280 | 2 | 0.14 | 260 |
| | | | | 350 HB | 0.3 | 2 | 0.1 | 0.18 | 0.36 | 120 | 180 | 2 | 0.13 | 180 |
| | High Alloyed | 3 | X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19 | 220 HB | 0.3 | 2.5 | 0.09 | 0.18 | 0.4 | 70 | 190 | 1.7 | 0.1 | 180 |
| | | | | 280 HB | 0.3 | 2.5 | 0.09 | 0.16 | 0.4 | 70 | 150 | 1.7 | 0.1 | 140 |
| 320 HB | | | | 0.3 | 2 | 0.09 | 0.14 | 0.32 | 70 | 130 | 1.7 | 0.1 | 120 | |
| 350 HB | | | | 0.3 | 2 | 0.09 | 0.14 | 0.26 | 70 | 110 | 1.7 | 0.1 | 110 | |
| Stainless Steel | Austentic | 4 | 304, 316, X5CrNi18-9 | 180 HB | 0.3 | 2.5 | 0.08 | 0.18 | 0.32 | 170 | 270 | 2 | 0.09 | 260 |
| | | | | 240 HB | 0.3 | 2.5 | 0.08 | 0.18 | 0.26 | 160 | 220 | 2 | 0.08 | 210 |
| | Duplex | 5 | X2CrNiN23-4, S31500 | 290 HB | 0.3 | 2 | 0.08 | 0.14 | 0.2 | 80 | 150 | 1.7 | 0.08 | 140 |
| | | | | 310 HB | 0.3 | 2 | 0.08 | 0.14 | 0.2 | 70 | 140 | 1.7 | 0.08 | 140 |
| | Ferritic & Martensitic | 6 | 410, X6Cr17, 17-4 PH, 430 | 200 HB | 0.3 | 2.5 | 0.08 | 0.18 | 0.32 | 170 | 250 | 1.7 | 0.09 | 240 |
| | | | | 42 HRc | 0.3 | 2 | 0.08 | 0.16 | 0.26 | 120 | 190 | 1.5 | 0.08 | 180 |
| Cast Iron | Grey | 7 | GG20, GG40, EN-GJL-250, N030B | 150 HB | 0.3 | 3 | 0.08 | 0.2 | 0.64 | 170 | 250 | 2 | 0.18 | 240 |
| | | | | 200 HB | 0.3 | 3 | 0.08 | 0.2 | 0.6 | 160 | 230 | 2 | 0.18 | 220 |
| | | | | 250 HB | 0.3 | 3 | 0.08 | 0.2 | 0.6 | 150 | 210 | 2 | 0.18 | 200 |
| | Malleable & Nodular | 8 | GGG40, GGG70, 50005 | 150 HB | 0.3 | 2.5 | 0.08 | 0.18 | 0.48 | 120 | 250 | 2 | 0.13 | 240 |
| | | | | 200 HB | 0.3 | 2.5 | 0.08 | 0.18 | 0.4 | 120 | 230 | 2 | 0.13 | 220 |
| | | | | 250 HB | 0.3 | 2.5 | 0.08 | 0.18 | 0.4 | 120 | 190 | 2 | 0.13 | 180 |
| NTI Alloy | Fe, Ni & Co Based | 9 | Incoloy 800 | 240 HB | 0.3 | 2 | 0.09 | 0.15 | 0.26 | 30 | 50 | 1.3 | 0.1 | 40 |
| | | | Inconel 700 | 250 HB | 0.3 | 2 | 0.09 | 0.15 | 0.26 | 30 | 50 | 1.3 | 0.1 | 40 |
| | | | Stellite 21 | 350 HB | 0.3 | 2 | 0.09 | 0.15 | 0.26 | 20 | 50 | 1.3 | 0.1 | 35 |
| Ti Based | 10 | T40 | - | 0.3 | 2 | 0.09 | 0.14 | 0.26 | 40 | 60 | 1.3 | 0.1 | 50 | |
| | | TiAl6V4 | - | 0.3 | 2 | 0.09 | 0.16 | 0.32 | 50 | 70 | 1.3 | 0.14 | 60 | |
| Hardened Materials | Steel Chilled Cast Iron White Cast Iron | 11 | G-X300CrMo15 | 55 HRc | 0.3 | 1.4 | 0.05 | 0.09 | 0.13 | 30 | 50 | 0.9 | 0.06 | 40 |
| | | | Ni-Hard 2 | 400 HB | 0.3 | 1.6 | 0.05 | 0.12 | 0.17 | 40 | 60 | 1.1 | 0.1 | 50 |
| | | | X100CrMo13, 440C, G-X260NiCr42 | 45 HRc | 0.3 | 1.8 | 0.05 | 0.12 | 0.2 | 50 | 100 | 1.4 | 0.1 | 90 |
| | | | | 50 HRc | 0.3 | 1.5 | 0.05 | 0.1 | 0.17 | 40 | 90 | 1.1 | 0.08 | 80 |
| | | | | 55 HRc | 0 | 1.4 | 0.05 | 0.09 | 0.13 | 40 | 80 | 0.9 | 0.06 | 70 |
| Aluminium | Al (>8%Si) | 12 | AlSi12 | 130 HB | 0.3 | 4 | 0.1 | 0.3 | 0.7 | 200 | 400 | 2 | 0.23 | 350 |