




MACHINING CONDITIONS

DNMG 150404 NN LT 1110S

T0004725

| Material Group |  | Material Example | Hardness | D.O.C | | Feed | | Amax [mm ²] | 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] | | | | |
| NITTI 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 |