



MACHINING CONDITIONS

DNMG 150408 NX LT 1000

T0003097

Material Group	SAPPHIRE TOOLS	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]				
Steel	Non Alloyed	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.5	5	0.18	0.5	1.71	180	330	3	0.36	240	
			190 HB	0.5	5	0.18	0.5	1.71	180	280	3	0.33	220	
			250 HB	0.5	5	0.18	0.45	1.43	180	250	3	0.31	200	
	Low Alloyed	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	230 HB	0.5	4	0.18	0.45	1.14	120	250	3	0.3	180	
			280 HB	0.5	4	0.16	0.4	1.14	120	210	3	0.29	150	
			180 HB	0.5	5	0.18	0.45	1.14	120	280	3	0.3	200	
			350 HB	0.5	3.5	0.16	0.4	0.95	120	180	2.7	0.29	130	
	High Alloyed	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	4	0.16	0.4	1.14	70	190	2.5	0.29	140	
			280 HB	0.5	4	0.16	0.4	1.14	70	150	2.5	0.29	120	
320 HB			0.5	3	0.16	0.35	0.76	70	130	2.5	0.27	100		
350 HB			0.5	3	0.16	0.35	0.76	70	110	2.5	0.27	90		
Stainless Steel	Austentic	304, 316, X5CrNi18-9	180 HB	0.5	5	0.18	0.4	1.14	170	270	3	0.24	190	
			240 HB	0.5	5	0.18	0.4	0.95	160	220	3	0.21	170	
	Duplex	X2CrNiN23-4, S31500	290 HB	0.5	4	0.16	0.35	0.76	80	150	2.5	0.23	100	
			310 HB	0.5	4	0.16	0.35	0.76	70	140	2.5	0.23	90	
	Ferritic & Martensitic	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	5	0.16	0.4	0.67	170	250	2.5	0.19	190	
			42 HRc	0.5	4	0.16	0.4	0.67	120	190	2.2	0.19	130	
Cast Iron	Grey	GG20, GG40, EN-GJL-250, N030B	150 HB	0.5	5	0.13	0.6	1.9	170	250	3	0.33	200	
			200 HB	0.5	5	0.13	0.6	1.71	160	230	3	0.33	180	
			250 HB	0.5	5	0.13	0.55	1.71	150	210	3	0.33	160	
	Malleable & Nodular	GGG40, GGG70, 50005	150 HB	0.5	5	0.13	0.5	1.43	120	250	3	0.29	180	
			200 HB	0.5	5	0.13	0.5	1.24	120	230	3	0.29	160	
			250 HB	0.5	5	0.13	0.5	1.14	120	190	3	0.29	140	
NITI Alloy	Fe, Ni & Co Based	Incoloy 800	240 HB	0.5	3	0.18	0.35	0.67	30	50	2	0.27	32	
			Inconel 700	250 HB	0.5	3	0.18	0.35	0.67	30	50	2	0.27	30
			Stellite 21	350 HB	0.5	3	0.18	0.35	0.67	20	40	2	0.27	28
	Ti Based	T40	-	0.5	3	0.18	0.35	0.67	40	60	2	0.29	45	
			TiAl6V4	-	0.5	3.5	0.18	0.4	0.76	50	70	2	0.31	55
			G-X300CrMo15	55 HRc	0.5	1.5	0.1	0.2	0.29	30	50	1	0.14	40
Hardened Materials	Steel Chilled Cast Iron White Cast Iron	Ni-Hard 2	400 HB	0.5	2	0.1	0.25	0.38	40	60	1.5	0.17	50	
			45 HRc	0.5	2.5	0.1	0.3	0.57	50	100	2	0.24	80	
		X100CrMo13, 440C, G-X260NiCr42	50 HRc	0.5	2	0.1	0.25	0.38	40	90	1.5	0.19	70	
			55 HRc	0.5	1.5	0.1	0.2	0.29	40	80	1	0.17	60	
			Aluminium	Al (>8%Si)	12	AISI12	130 HB	0.5	6	0.18	0.6	1.71	200	400