




MACHINING CONDITIONS

DNMG 150412 NN LT 1110S

T0004727

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]				
NIT: Alloy	Fe, Ni & Co Based	9	Incoloy 800	240 HB	0.7	3.6	0.25	0.47	1.19	30	50	2.7	0.37	32
			Inconel 700	250 HB	0.7	3.6	0.25	0.47	1.19	30	50	2.7	0.37	30
			Stellite 21	350 HB	0.7	3.6	0.25	0.47	1.19	20	40	2.7	0.37	28
	Ti Based	10	T40	-	0.7	3.6	0.25	0.47	1.19	40	60	2.7	0.4	45
			TiAl6V4	-	0.7	4.2	0.25	0.54	1.36	50	70	2.7	0.44	55