




MACHINING CONDITIONS

TNMG 160412 NN LT 1110S

T0004720

Material Group	 SAPPHIRE CUTTING TOOLS 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]	
NITI Alloy	Fe, Ni & Co Based	9	Incoloy 800	240 HB	0.7	3	0.25	0.47	1.19	30	50	2.4	0.37	30
			Inconel 700	250 HB	0.7	3	0.25	0.47	1.19	30	50	2.4	0.37	30
			Stellite 21	350 HB	0.7	3	0.25	0.47	1.19	30	40	2.4	0.37	30
	Ti Based	10	T40	-	0.7	3	0.25	0.47	1.19	40	60	2.4	0.4	45
			TiAl6V4	-	0.7	3.5	0.25	0.54	1.36	50	70	2.4	0.44	55