




# MACHINING CONDITIONS

TNMG 220412 NN LT 1110S

T0004722

Material Group	 Group	Material Example	Hardness	D.O.C		Feed		Amax [mm <sup>2</sup> ]	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	0.7	4.2	0.25	0.47	1.19	30	50	2.7	0.37	30
			Inconel 700	250 HB	0.7	4.2	0.25	0.47	1.19	30	50	2.7	0.37	30
			Stellite 21	350 HB	0.7	4.2	0.25	0.47	1.19	30	40	2.7	0.37	30
	Ti Based	10	T40	-	0.7	4.2	0.25	0.47	1.19	40	60	2.7	0.4	45
			TiAl6V4	-	0.7	4.9	0.25	0.54	1.36	50	70	2.7	0.44	55