



MACHINING CONDITIONS

TNMG 220412 NN LT 1120M

T0004751

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]	
Stainless Steel	Austentic	4	304, 316, X5CrNi18-9	180 HB	0.7	7	0.25	0.54	2.04	90	270	4	0.33	190
				240 HB	0.7	7	0.25	0.54	1.7	80	220	4	0.29	170
	Duplex	5	X2CrNiN23-4, S31500	290 HB	0.7	5.6	0.23	0.47	1.36	40	150	3.4	0.32	100
				310 HB	0.7	5.6	0.23	0.47	1.36	40	140	3.4	0.32	90
	Ferritic & Martensitic	6	410, X6Cr17, 17-4 PH, 430	200 HB	0.7	7	0.23	0.54	1.19	90	250	3.4	0.26	190
				42 HRc	0.7	5.6	0.23	0.54	1.19	60	190	2.9	0.26	130