




MACHINING CONDITIONS

VNGG 160408 NS LT 05

T0002831

Material Group	 SAPPHIRE CUTTING TOOLS 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]				
Aluminium	Al (<8%Si)	13	4% < Si < 8%	100 HB	0.5	6	0.18	0.5	2.1	400	1200	4	0.36	400
			Si < 4%	60 HB	0.5	6	0.18	0.5	2.1	250	600	4	0.36	300
	Copper Alloys	14	CuZn30	100 HB	0.5	6	0.18	0.6	2.52	150	800	4	0.45	250
	Non-Metallic	15	Fiber Plastics	-	0.5	5.5	0.18	0.36	1.39	70	500	3.5	0.24	150
			Graphite	-	0.5	4	0.18	0.34	0.95	80	300	3	0.22	150
			Hard Rubber	-	0.5	6	0.18	0.4	1.68	100	200	4	0.26	150