



# MACHINING CONDITIONS

VNMG 160408 NN LT 1120M

T0004756

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	0.5	4	0.18	0.32	0.96	90	270	2.7	0.23	190
				240 HB	0.5	4	0.18	0.32	0.8	80	220	2.7	0.2	170
	Duplex	5	X2CrNiN23-4, S31500	290 HB	0.5	3.2	0.16	0.28	0.64	40	150	2.3	0.22	100
				310 HB	0.5	3.2	0.16	0.28	0.64	40	140	2.3	0.22	90
	Ferritic & Martensitic	6	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	4	0.16	0.32	0.56	90	250	2.3	0.18	190
				42 HRc	0.5	3.2	0.16	0.32	0.56	60	190	2	0.18	130