



MACHINING CONDITIONS

WNGG 060404 NS LT 1110S

T0004610

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]				
NITi Alloy	Ti Based	10	T40	-	0.3	1.7	0.06	0.12	0.14	50	70	1.1	0.12	60
			TiAl6V4	-	0.3	1.7	0.06	0.14	0.17	40	60	1.1	0.1	50