



MACHINING CONDITIONS

WNGG 080404 NS LT 05

T0004598

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	13	4% < Si < 8%	100 HB	0.3	4.5	0.1	0.3	0.95	400	1200	2.3	0.27	400
		Si < 4%	60 HB	0.3	4.5	0.1	0.3	0.95	250	600	2.3	0.27	300
	14	CuZn30	100 HB	0.3	4.5	0.1	0.35	1.1	150	800	2.3	0.25	250
	15	Fiber Plastics	-	0.3	4.5	0.1	0.27	0.85	70	500	2.3	0.2	150
		Graphite	-	0.3	4	0.1	0.26	0.73	80	300	1.6	0.18	150
		Hard Rubber	-	0.3	4.5	0.1	0.22	0.69	100	200	2.3	0.16	150