



MACHINING CONDITIONS

WNGG 080408 NS LT 1110S

T0004613

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]	
NITi Alloy	Ti Based	10	T40	-	0.5	2.3	0.15	0.32	0.52	50	70	1.6	0.23	55
			TiAl6V4	-	0.5	2.3	0.15	0.3	0.48	40	60	1.6	0.2	45