



MACHINING CONDITIONS

WNMP 080408 NN LT 1120M

T0004762

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	3.5	0.2	0.4	0.78	90	270	2.1	0.25	190
				240 HB	0.5	3.5	0.2	0.4	0.65	80	220	2.1	0.22	170
	Duplex	5	X2CrNiN23-4, S31500	290 HB	0.5	2.8	0.18	0.35	0.52	40	150	1.8	0.24	100
				310 HB	0.5	2.8	0.18	0.35	0.52	40	140	1.8	0.24	90
	Ferritic & Martensitic	6	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	3.5	0.18	0.4	0.46	90	250	1.8	0.2	190
				42 HRc	0.5	2.8	0.18	0.4	0.46	60	190	1.5	0.2	130