

SEKT 12T3 AGSN LT 3130

M0004487

Material Group	SAPPHIRE CUTTING TOOLS Group	Material Example	Hardness	D.O.C		Feed		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]				
Steel	Non Alloyed	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.5	6	0.18	0.46	190	350	3	0.34	265	
			190 HB	0.5	6	0.18	0.46	190	320	3	0.34	240	
			250 HB	0.5	6	0.18	0.46	190	280	3	0.34	215	
	Low Alloyed	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	230 HB	0.5	6	0.15	0.36	150	230	3	0.3	200
				280 HB	0.5	6	0.15	0.32	130	210	3	0.27	165
				180 HB	0.5	6	0.15	0.36	150	270	3	0.3	215
				350 HB	0.5	6	0.15	0.32	130	190	3	0.27	155
	High Alloyed	3	X40CrM0V5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	5	0.12	0.32	90	170	2.3	0.27	140
				280 HB	0.5	5	0.12	0.32	90	150	2.3	0.27	130
				320 HB	0.5	5	0.12	0.26	60	120	2.3	0.24	110
				350 HB	0.5	5	0.12	0.26	60	100	2.3	0.24	90
	Stainless Steel	Austenitic	4	304, 316, X5CrNi18-9	180 HB	0.5	6	0.15	0.32	190	260	3	0.27
240 HB					0.5	6	0.12	0.29	160	220	3	0.27	200
Duplex		5	X2CrNiN23-4, S31500	290 HB	0.5	5	0.12	0.26	70	140	2.3	0.24	110
				310 HB	0.5	5	0.12	0.26	70	130	2.3	0.24	100
Ferritic & Martensitic		6	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	6	0.15	0.32	150	220	3	0.27	200
				42 HRc	0.5	5	0.15	0.26	90	160	2.3	0.24	140