




MACHINING CONDITIONS

DNMG 150604 NN LT 1110S

T0004728

Material 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]				
NITTI Alloy	Fe, Ni & Co Based	9	Incoloy 800	240 HB	0.3	2	0.09	0.15	0.26	30	50	1.3	0.1	40
			Inconel 700	250 HB	0.3	2	0.09	0.15	0.26	30	50	1.3	0.1	40
			Stellite 21	350 HB	0.3	2	0.09	0.15	0.26	20	50	1.3	0.1	35
	Ti Based	10	T40	-	0.3	2	0.09	0.14	0.26	40	60	1.3	0.1	50
			TiAl6V4	-	0.3	2	0.09	0.16	0.32	50	70	1.3	0.14	60