



# MACHINING CONDITIONS

WNGG 060408 NS LT 05

T0004551

Material Group	SAPPHIRE CUTTING TOOLS Group	Material Example	Hardness	D.O.C		Feed		Amax [mm <sup>2</sup> ]	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	0.5	5.5	0.18	0.5	1.4	250	600	3	0.32	300
		Si < 4%	60 HB	0.5	5.5	0.18	0.6	1.8	400	1200	3	0.32	400
	14	CuZn30	100 HB	0.5	5.5	0.15	0.4	1.4	150	800	3	0.25	250
	15	Fiber Plastics	-	0.5	5.5	0.15	0.4	1.4	70	500	3	0.25	150
		Graphite	-	0.5	5.5	0.15	0.4	1.4	100	200	3	0.25	150
		Hard Rubber	-	0.5	5.5	0.15	0.4	1.4	80	300	3	0.25	150