



MACHINING CONDITIONS

WNMG 060404 NN LT 1110S

T0004716

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]	
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