

WNMG 080412 NN LT 1110S

T0004718

| Material 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]    |
| NiTi Alloy     | Fe, Ni & Co Based | 9                                                                                 | Incoloy 800      | 240 HB   | 0.7     | 2.1     | 0.24      | 0.46       | 0.84   | 30          | 50          | 1.7           | 0.35         | 30         |
|                |                   |                                                                                   | Inconel 700      | 250 HB   | 0.7     | 2.1     | 0.24      | 0.46       | 0.84   | 30          | 50          | 1.7           | 0.35         | 30         |
|                |                   |                                                                                   | Stellite 21      | 350 HB   | 0.7     | 2.1     | 0.24      | 0.46       | 0.84   | 30          | 40          | 1.7           | 0.35         | 30         |
|                | Ti Based          | 10                                                                                | T40              | -        | 0.7     | 2.1     | 0.24      | 0.46       | 0.84   | 40          | 60          | 1.7           | 0.38         | 45         |
|                |                   |                                                                                   | TiAl6V4          | -        | 0.7     | 2.5     | 0.24      | 0.52       | 0.96   | 50          | 70          | 1.7           | 0.41         | 55         |