

Material Group	Group No	Material Examples*	Brinell hardness	d.o.c [mm]		feed [mm/rev]		A max [mm ²]	V _c [m/min]		Optimal cutting conditions									
				min	max	min	max		min	max	d.o.c	feed								
Low Carbon Steel	1	Ck15, Ck45 1020, 1045	150	0.20	3.0	0.11	0.23	0.60	180	350	2.0	0.18								
			180										2.5	0.20	0.48	280				
			210										2.5	0.18	0.48	250				
Alloy Steel	2	42 CrMo 4 St 50-2 Ck60 1060 4140	180	0.20	2.5	0.11	0.20	0.48	120	280	2.0	0.15								
			230										2.5	0.20	0.40	250				
			280										2.0	0.18	0.40	210				
			320										2.0	0.16	0.32	180				
High Alloy Steel	3	X40 CrMoV 5 1 H 13 40 NiCrMo 6 4340 S 2-10-1-8 HSS M42	220	0.20	2.5	0.09	0.18	0.40	70	190	2.0	0.12								
			280										2.5	0.16	0.40	150				
			320										2.0	0.14	0.28	130				
			350										2.0	0.14	0.24	100				
			400	0.20	1.8	0.05	0.12	0.20	50	90	1.7	0.11								
			480						1.5	0.10	0.17	40	80	1.4	0.09					
			550						1.4	0.08	0.13	30	70	1.2	0.07					
Austenitic Stainless Steel	4	X5 CrNi 18 9 304	210 to 250	0.20	2.5	0.10	0.18	0.32	170	270	2.0	0.15								
			230 to 270										2.0	0.09	0.16	0.24	160	210	2.0	0.12
			-----										2.0	0.09	0.14	0.20	70	150	2.0	0.12
Ferritic Stainless Steel	7	X8 Cr 7 430	Annealed	0.20	2.0	0.11	0.18	0.28	170	250	2.0	0.15								
Martensitic Stainless Steel	8	X15 Cr 13 410	Annealed Treated	0.20	2.0	0.11	0.18	0.28	170	250	2.0	0.12								
									120	190										
Grey Cast Iron	9	GG 20 GG 25 GG 30	140 to 230	0.20	3.0	0.08	0.20	0.64	170	250	2.0	0.18								
										0.60			230							
										0.60			210							
Nodular Cast Iron	10	GGG 40 GGG 50 GGG 70 G-X260NiCr42	210 260 310 450	0.20	2.5	0.08	0.18	0.48	120	230	2.0	0.15								
										0.40			190							
				0.40	150															
				0.17	30	70	1.4	0.09												
Nickel Based Alloys	11	Inconel 625 Inconel 718 Hastelloy C	-----	0.20	2.0	0.10	0.16	0.24	25	35	2.0	0.12								
								0.24	28	40										
								0.28	40	65										
Titanium Based Alloys	12	TiAl 6 V4 T40	-----	0.20	2.0	0.09	0.16	0.28	35	60	2.0	0.14								
							0.14	0.24	28	40	2.0	0.12								

Insert designation Super Finishing Finishing Semi Finishing Roughing Interrupted Cut

WNMG 080404 NN



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