

MACHINING CONDITIONS - TURNING - DEPTH OF CUT AND FEED

CCMT 120412 NN

Material Group	Lamina Gr. N°	Material Examples	Hardness	DOC [mm]		Feed [mm/rev]		Amax [mm ²]	Suggested Starting Parameters						
				min	max	min	max		DOC	Feed					
P	Non Alloyed	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.50	5.00	0.21	0.60	2.16	3.00	0.42					
			190 HB												
			250 HB												
	Low Alloyed	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.50	5.00	0.21	0.54	1.44	3.00	0.38				
				230 HB		4.00									
				280 HB		3.50	0.18	0.48			1.20	0.36			
				350 HB											
	High Alloyed	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.50	4.00	0.18	0.48	1.44	2.50	0.36				
				280 HB											
320 HB				3.00		0.18	0.42	0.96			2.50	0.34			
350 HB															
M	Austenitic	4	304, 316, X5CrNi18-9	0.50	5.00	0.20	0.48	1.44	3.00	0.30					
			240 HB					1.20		0.26					
	Duplex	5	X2CrNiN23-4, S31500	290 HB	0.50	4.00	0.18	0.42	0.96	2.50	0.29				
				310 HB											
	Ferritic & Martensitic	6	410, X6Cr17, 17-4PH, 430	200 HB	0.50	5.00	0.18	0.48	0.84	2.50	0.24				
				42 HRc		4.00				2.20					
K	Grey	7	GG20, GG40, EN-GJL-250, N030B	0.50	5.00	0.15	0.72	2.40	3.00	0.42					
			200 HB					2.16							
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.50	5.00	0.15	0.60	1.80	3.00	0.36				
				200 HB					1.56						
S	Fe, Ni & Co based	9	Incoloy 800	0.50	3.00	0.20	0.42	0.84	2.00	0.34					
			Inconel 700								250 HB				
			Stellite 21								350 HB				
Ti based	10	T40	0.50	4.00	0.20	0.48	0.96	2.00	0.40						
		TiAl6V4		-					3.00	0.42	0.84	0.36			
H	Steel	11	X100 CrMo13, 440C, G-X260NiCr42	0.50	2.50	0.11	0.36	0.72	2.00	0.30					
			45 HRc												
			50 HRc								2.00	0.30	0.48	1.50	0.24
			55 HRc								1.50	0.24	0.36	1.00	0.22
			400 HB								2.00	0.30	0.48	1.50	
Chilled Cast Iron	Ni-Hard 2	400 HB	2.00	0.30	0.48	1.50	0.22								
White Cast Iron	G-X300CrMo15	55 HRc	1.50	0.24	0.36	1.00	0.18								
NF	Aluminium	12	AlSi12	130 HB	0.50	6.00	0.20	0.72	2.16	3.00	0.48				

The depth of cut and feed rate tables are for the geometry and corner radius specified above the table. Refer to cutting speed tables on pages 186 and 187 for recommended materials per grade.