

MACHINING CONDITIONS - TURNING - DEPTH OF CUT AND FEED

CNMG 120408 NN
 DNMG 110408 NN
 DNMG 150408 NN

DNMG 150608 NN
 TNMG 160408 NN
 TNMG 220408 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 | 0.50 | 1.80 | 3.00 | 0.38 | | | | |
| | | | 190 HB | | | | | | | 0.35 | | | | |
| | | | 250 HB | | | | | | | 0.33 | | | | |
| | Low Alloyed | 2 | 42CrMo4, S150, Ck60, 4140, 4340, 100Cr6 | 180 HB | 0.50 | 5.00 | 0.21 | 0.45 | 1.20 | 3.00 | 0.32 | | | |
| | | | | 230 HB | | 4.00 | | | | | | | | |
| | | | | 280 HB | | 3.50 | 0.18 | 0.40 | 1.00 | 2.70 | 0.30 | | | |
| | | | | 350 HB | | | | | | | | | | |
| | High Alloyed | 3 | X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19 | 220 HB | 0.50 | 4.00 | 0.18 | 0.40 | 1.20 | 2.50 | 0.30 | | | |
| | | | | 280 HB | | | | | | | | | | |
| | | | | 320 HB | | 3.00 | | 0.35 | 0.80 | 2.20 | 0.28 | | | |
| | | | | 350 HB | | | | | | | | | | |
| | M | Austenitic | 4 | 304, 316, X5CrNi18-9 | 0.50 | 5.00 | 0.20 | 0.40 | 1.20 | 3.00 | 0.25 | | | |
| 1.00 | | | | | | | | | 0.22 | | | | | |
| Duplex | | 5 | X2CrNi23-4, S31500 | 290 HB | 0.50 | 4.00 | 0.18 | 0.35 | 0.80 | 2.50 | 0.24 | | | |
| | | | | 310 HB | | | | | | | | | | |
| Ferritic & Martensitic | | 6 | 410, X6Cr17, 17-4PH, 430 | 200 HB | 0.50 | 5.00 | 0.18 | 0.40 | 0.70 | 2.50 | 0.20 | | | |
| | | | | 42 HRc | | 4.00 | | | | 2.20 | | | | |
| K | Grey | 7 | GG20, GG40, EN-GJL-250, N030B | 0.50 | 5.00 | 0.15 | 0.60 | 2.00 | 3.00 | 0.35 | | | | |
| | | | | | | | | 1.80 | | | | | | |
| | | | | | | | | 0.55 | | | | | | |
| | Malleable & Nodular | 8 | GGG40, GGG70, 50005 | 150 HB | 0.50 | 5.00 | 0.15 | 0.50 | 1.50 | 3.00 | 0.30 | | | |
| | | | | 200 HB | | | | | 1.30 | | | | | |
| | | | | 250 HB | | | | | 1.20 | | | | | |
| S | Fe, Ni & Co based | 9 | Incoloy 800 | 0.50 | 3.00 | 0.20 | 0.35 | 0.70 | 2.00 | 0.28 | | | | |
| | | | Inconel 700 | | | | | | | | 250 HB | | | |
| | | | Stellite 21 | | | | | | | | 350 HB | | | |
| | Ti based | 10 | T40 | 0.50 | 3.50 | 0.20 | 0.40 | 0.80 | 2.00 | 0.33 | | | | |
| TiAl6V4 | | | 3.00 | | 0.35 | | 0.70 | | | 0.30 | | | | |
| H | Steel | 11 | X100 CrMo13, 440C, G-X260NiCr42 | 0.50 | 1.50 | 0.11 | 2.50 | 0.30 | 0.60 | 2.00 | 0.25 | | | |
| | | | | | | | 50 HRc | 2.00 | 0.25 | 0.40 | 1.50 | 0.20 | | |
| | | | | | | | 55 HRc | 1.50 | 0.20 | 0.30 | 1.00 | 0.18 | | |
| | | | | | | | Ni-Hard 2 | 400 HB | 2.00 | 0.25 | 0.40 | 1.50 | 0.15 | |
| | | | | | | | White Cast Iron | G-X300CrMo15 | 55 HRc | 1.50 | 0.20 | 0.30 | 1.00 | 0.15 |
| | | | | | | | Chilled Cast Iron | | | | | | | |
| NF | Aluminium | 12 | AlSi12 | 130 HB | 0.50 | 6.00 | 0.20 | 0.60 | 1.80 | 3.00 | 0.40 | | | |

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.