

MACHINING CONDITIONS - MILLING - DEPTH OF CUT AND FEED

ADKT 1505 PDTR

Material Group	Lamina Gr. N°	Material Examples	Hardness	DOC [mm]		Feed [mm/z]		Suggested Starting Parameters					
				min	max	min	max	DOC	Feed				
P	Non Alloyed	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.50	14.00	0.18	0.32	4.00	0.23				
			190 HB										
			250 HB										
	Low Alloyed	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.50	14.00	0.15	0.25	4.00	0.20				
			230 HB				0.22		0.18				
			280 HB										
			350 HB										
	High Alloyed	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.50	10.00	0.12	0.22	3.00	0.18				
			280 HB				0.18		0.16				
			320 HB										
			350 HB										
M	Austenitic	304, 316, X5CrNi18-9	180 HB	0.50	14.00	0.15	0.25	4.00	0.20				
			240 HB			0.12	0.22						
	Duplex	X2CrNiN23-4, S31500	290 HB	0.50	10.00	0.12	0.18	3.00	0.16				
			310 HB										
	Ferritic & Martensitic	410, X6Cr17, 17-4PH, 430	200 HB	0.50	14.00	0.15	0.25	4.00	0.20				
			42 HRc		10.00		0.20	3.00	0.16				
K	Grey	GG20, GG40, EN-GJL-250, N030B	150 HB	0.50	14.00	0.18	0.32	4.00	0.23				
			200 HB										
			250 HB										
	Malleable & Nodular	GGG40, GGG70, 50005	150 HB	0.50	14.00	0.15	0.28	4.00	0.20				
			200 HB										
250 HB													
S	Fe, Ni & Co based	Incoloy 800	240 HB	0.50	10.00	0.12	0.18	3.00	0.16				
			Inconel 700							250 HB			
			Stellite 21							350 HB			
	Ti based	TiAl6V4	-	0.50	10.00	0.12	0.20	3.00	0.18				
			T40				-		0.18	0.16			
H	Steel	X100 CrMo13, 440C, G-X260NiCr42	45 HRc	0.50	5.00	0.10	0.18	2.00	0.14				
			50 HRc		3.00		0.16	1.50	0.13				
			55 HRc		1.50		0.14	1.00	0.12				
			Chilled Cast Iron		Ni-Hard 2		400 HB	4.00	0.18	1.50	0.14		
							White Cast Iron	G-X300CrMo15	55 HRc	1.50	0.14	1.00	0.12
NF	Aluminium	AlSi12	130 HB	0.50	14.00	0.18	0.32	4.00	0.25				

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 page 226 for recommended materials per grade.