

MACHINING CONDITIONS - MILLING - DEPTH OF CUT AND FEED

ODMW 060508 TN

Material Group	Lamina Gr. N°	Material Examples	Hardness	DOC [mm]		Feed [mm/z]		Suggested Starting Parameters		
				min	max	min	max	DOC	Feed	
P	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.50	4.00	0.22	0.58	3.00	0.41	
			190 HB							
			250 HB							
	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.50	4.00	0.18	0.45	3.00	0.36	
			230 HB				0.40		0.32	
			280 HB							
			350 HB							
	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.50	2.80	0.14	0.40	2.30	0.32	
			280 HB				0.32		0.29	
			320 HB							
			350 HB							
	K	7	GG20, GG40, EN-GJL-250, N030B	150 HB	0.50	4.00	0.22	0.58	3.00	0.41
200 HB										
250 HB										
8		GGG40, GGG70, 50005	150 HB	0.50	4.00	0.18	0.50	3.00	0.36	
			200 HB							
			250 HB							
H	11	X100 CrMo13, 440C, G-X260NiCr42	45 HRc	0.40	1.40	0.12	0.32	1.10	0.25	
			50 HRc		1.10		0.29	0.90	0.23	
			55 HRc		0.90		0.25	0.70	0.22	
		Chilled Cast Iron	Ni-Hard 2		400 HB		1.10	0.32	0.90	0.25
					White Cast Iron		G-X300CrMo15	55 HRc	0.90	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.