

MACHINING CONDITIONS - MILLING - DEPTH OF CUT AND FEED

ONKX 0806-45

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 Low Alloyed High Alloyed	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.50	4.00	0.16	0.58	3.00	0.46	
			190 HB							
			250 HB							
	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.50	4.00	0.14	0.50	3.00	0.40	
			230 HB				0.44		0.36	
			280 HB							
			350 HB							
	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.50	4.00	0.11	0.44	3.00	0.36	
			280 HB				0.36		0.32	
			320 HB							
			350 HB							
	M Austenitic Duplex Ferritic & Martensitic	4	304, 316, X5CrNi18-9	180 HB	0.50	1.50	0.14	1.20	0.34	
240 HB				0.11						
5		X2CrNiN23-4, S31500	290 HB	0.50	1.50	0.11	0.36	1.20	0.30	
			310 HB							
6		410, X6Cr17, 17-4PH, 430	200 HB	0.50	1.50	0.14	0.44	1.20	0.34	
			42 HRc				0.40		0.30	
K Grey Malleable & Nodular	7	GG20, GG40, EN-GJL-250, N030B	150 HB	0.50	4.00	0.17	0.58	4.00	0.46	
			200 HB							
			250 HB							
	8	GGG40, GGG70, 50005	150 HB	0.50	4.00	0.14	0.52	4.00	0.40	
			200 HB							
			250 HB							
S Fe, Ni & Co based Ti based	9	Incoloy 800	240 HB	0.50	1.50	0.11	0.36	1.20	0.30	
		Inconel 700	250 HB							
		Stellite 21	350 HB							
	10	TiAl6V4 T40	-	0.50	1.50	0.11	0.40	1.20	0.34	
			-				0.36		0.30	
			-							
H Steel Chilled Cast Iron White Cast Iron	11	X100 CrMo13, 440C, G-X260NiCr42	45 HRc	0.40	3.00	0.09	0.36	2.00	0.28	
			50 HRc				0.32	1.00	0.26	
			55 HRc				1.50	0.28	0.50	0.24
			Ni-Hard 2				3.00	0.36	1.50	0.28
			G-X300CrMo15				1.50	0.28	0.50	0.24
			55 HRc							
NF Aluminium	12	AISI12	130 HB	0.50	1.50	0.17	0.60	1.50	0.50	

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.