

MACHINING CONDITIONS - MILLING - DEPTH OF CUT AND FEED

RDMLT 1003 M0
RDMLT 10T3 M0

RDMX 1003 M0
RDMX 10T3 M0

RXMT 10T3 M0
RXMX 10T3 M0

| 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 | 2.50 | 0.18 | 0.64 | 1.00 | 0.34 | |
| | | | 190 HB | | | | | | | |
| | | | 250 HB | | | | | | | |
| P | 2 | 42CrMo4, St50, Ck60, 4140, 4340, 100Cr6 | 180 HB | 0.50 | 2.50 | 0.15 | 0.50 | 1.00 | 0.30 | |
| | | | 230 HB | | | | 0.44 | | 0.27 | |
| | | | 280 HB | | | | | | | |
| | | | 350 HB | | | | | | | |
| M | 3 | X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19 | 220 HB | 0.50 | 1.80 | 0.12 | 0.44 | 0.80 | 0.27 | |
| | | | 280 HB | | | | 0.36 | | 0.24 | |
| | | | 320 HB | | | | | | | |
| | | | 350 HB | | | | | | | |
| Austenitic | 4 | 304, 316, X5CrNi18-9 | 180 HB | 0.50 | 2.50 | 0.15 | 0.50 | 1.00 | 0.30 | |
| | | | 240 HB | | | 0.12 | 0.44 | | | |
| M | 5 | X2CrNiN23-4, S31500 | 290 HB | 0.50 | 2.00 | 0.12 | 0.36 | 0.80 | 0.24 | |
| | | | 310 HB | | | | | | | |
| Ferritic & Martensitic | 6 | 410, X6Cr17, 17-4PH, 430 | 200 HB | 0.50 | 2.50 | 0.15 | 0.50 | 1.00 | 0.30 | |
| | | | 42 HRc | | 2.00 | | 0.40 | | 0.24 | |
| K | 7 | GG20, GG40, EN-GJL-250, N030B | 150 HB | 0.50 | 2.50 | 0.18 | 0.64 | 1.00 | 0.34 | |
| | | | 200 HB | | | | | | | |
| | | | 250 HB | | | | | | | |
| K | 8 | GGG40, GGG70, 50005 | 150 HB | 0.50 | 2.50 | 0.15 | 0.56 | 1.00 | 0.30 | |
| | | | 200 HB | | | | | | | |
| | | | 250 HB | | | | | | | |
| S | 9 | Incoloy 800 | 240 HB | 0.50 | 2.00 | 0.12 | 0.36 | 0.80 | 0.24 | |
| | | | 250 HB | | | | | | | |
| | | | Stellite 21 | | | | | | | |
| S | 10 | TiAl6V4 | - | 0.50 | 2.00 | 0.12 | 0.40 | 0.80 | 0.27 | |
| | | | T40 | | | | 0.36 | | 0.24 | |
| H | 11 | X100 CrMo13, 440C, G-X260NiCr42 | 45 HRc | 0.30 | 0.90 | 0.10 | 0.36 | 0.50 | 0.21 | |
| | | | 50 HRc | | 0.70 | | 0.32 | 0.40 | 0.19 | |
| | | | 55 HRc | | 0.60 | | 0.28 | 0.30 | 0.18 | |
| | | Ni-Hard 2 | 400 HB | | 0.70 | | 0.36 | 0.40 | 0.21 | |
| | | G-X300CrMo15 | 55 HRc | | 0.60 | | 0.28 | 0.30 | 0.18 | |
| NF | 12 | AISI12 | 130 HB | 0.50 | 2.50 | 0.18 | 0.64 | 1.00 | 0.38 | |

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.