MACHINING CONDITIONS - MILLING - DEPTH OF CUT AND FEED

RDMW 1003 M0 RDMW 10T3 M0 RXMW 10T3 M0

	Material Group	Lamina Gr. N°	Material Examples	Hardness	DOC [mm] min	DOC [mm] max	Feed [mm/z] min	Feed [mm/z] max	Suggested Starting Parameters DOC	Suggested Starting Parameters Feed
P	Non Alloyed	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.50	2.50	0.18	0.70	1.00	0.39
				190 HB						
				250 HB						
	Low Alloyed	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB				0.55		0.34
				230 HB						
				280 HB				0.48	1.00	0.31
				350 HB						
	High Alloyed	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.50	1.80	0.12	0.48	0.80	0.31
				280 HB						
				320 HB				0.40		0.27
				350 HB						
K	Grey	7	GG20, GG40, EN-GJL-250, N030B	150 HB	0.50	2.50	0.18	0.70	1.00	0.39
				200 HB						
				250 HB						
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.50	2.50	0.15	0.62	1.00	0.34
				200 HB						
				250 HB						
H	Steel	11	X100 CrMo13, 440C, G-X260NiCr42	45 HRc	0.30	0.90	0.10	0.40	0.50	0.24
				50 HRc		0.70		0.35	0.40	0.22
				55 HRc		0.60		0.31	0.30	0.20
	Chilled Cast Iron		Ni-Hard 2	400 HB		0.70		0.40	0.40	0.24
	White Cast Iron		G-X300CrMo15	55 HRc		0.60		0.31	0.30	0.20

RDMW 1204 M0 RDMW 12T3 M0 RXMW 1204 M0

	Material Group	Lamina Gr. N°	Material Examples	Hardness	DOC [mm] min	DOC [mm] max	Feed [mm/z] min	Feed [mm/z] max	Suggested Starting Parameters DOC	Suggested Starting Parameters Feed
P	Non Alloyed	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.30	4.00	0.27	0.70	1.50	0.60
				190 HB				0.65		0.60
				250 HB		3.00		0.50		0.50
	Low Alloyed	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB		4.00	0.25	0.65		0.60
				230 HB		3.00		0.57	1.50	0.55
				280 HB		2.00	0.23	0.52		0.50
				350 HB		1.50		0.50	1.00	0.50
	High Alloyed	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB		2.00		0.57		0.55
				280 HB			0.20	0.52	1.00	0.50
				320 HB		1.50		0.50		
				350 HB				0.47		0.45
K	Grey	7	GG20, GG40, EN-GJL-250, N030B	150 HB	0.30	3.00	0.20	0.80	2.00	0.80
				200 HB						0.70
				250 HB						0.60
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.30	2.50	0.20	0.60	1.50	0.50
				200 HB						0.55
				250 HB						0.60
H	Steel	11	X100 CrMo13, 440C, G-X260NiCr42	45 HRc	0.30	1.00	0.18	0.38	0.50	0.38
				50 HRc		0.80		0.34		0.34
				55 HRc		0.50		0.30		0.30
	Chilled Cast Iron		Ni-Hard 2	400 HB		1.00		0.38		0.38
	White Cast Iron		G-X300CrMo15	55 HRc		0.50		0.34		0.34

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.