

MACHINING CONDITIONS - PARTING & GROOVING - DEPTH OF CUT AND FEED

GCTX 2002 NN  
GCTX 3003 NN  
GCTX 3003 PP

Material Group	Lamina Gr. N°	Material Examples	Hardness	GCTX 2002 NN Feed [mm/rev]		GCTX 3003 NN Feed [mm/rev]		GCTX 3003 PP Feed [mm/rev]	
				min	max	min	max	min	max
Non Alloyed  P  Low Alloyed   High Alloyed	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.50	0.17	0.05	0.17	0.05	0.17
			190 HB						
			250 HB						
	2	42CrMo4, S150, Ck60, 4140, 4340, 100Cr6	180 HB	0.50	0.15	0.05	0.15	0.05	0.15
			230 HB						
			280 HB						
			350 HB						
	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.50	0.14	0.05	0.14	0.05	0.14
			280 HB						
320 HB									
4	304, 316, X5CrNi18-9	180 HB	0.50	0.10	0.05	0.10	0.05	0.10	
		240 HB							
		290 HB							
5	X2CrNiN23-4, S31500	310 HB	0.50	0.09	0.05	0.09	0.05	0.09	
		200 HB							
		42 HRc							
6	410, X6Cr17, 17-4PH, 430	200 HB	0.50	0.09	0.05	0.09	0.05	0.09	
		42 HRc							
		150 HB							
7	GG20, GG40, EN-GJL-250, N030B	200 HB	0.50	0.16	0.05	0.16	0.05	0.16	
		250 HB							
		150 HB							
8	GGG40, GGG70, 50005	200 HB	0.50	0.14	0.05	0.14	0.05	0.14	
		250 HB							
		240 HB							
9	Incoloy 800	250 HB	0.50	0.08	0.05	0.08	0.05	0.08	
		Inconel 700							
		Stellite 21							
10	T40	-	0.50	0.08	0.05	0.08	0.05	0.08	
	TiAl6V4	-							
Steel  Chilled Cast Iron White Cast Iron	11	X100 CrMo13, 440C, G-X260NiCr42	45 HRc	0.50	0.11	0.05	0.11	0.05	0.11
			50 HRc						
			55 HRc						
			400 HB						
			55 HRc						
12	AlSi12	130 HB	0.50	0.10	0.05	0.11	0.05	0.11	
		45 HRc							