

MACHINING CONDITIONS - SOLID END MILLS - DEPTH OF CUT AND FEED

HIGH FEED, 4 FLUTE – LT 4000 - Ø 3 - 6, 8, 10, 12

Material Group	Lamina Gr. N°	Material Examples	Hardness	Profiling		fz [mm/tooth]							
				ap	ae	Ø 3	Ø 4	Ø 5	Ø 6	Ø 8	Ø 10	Ø 12	
P	Non Alloyed	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.025xØ	0.5xØ	0.140	0.200	0.240	0.260	0.340	0.400	0.450	
			190 HB										
			250 HB										
	Low Alloyed	2	42CrMo4, St50, Ck60, 4140, 4340, 100C6	180 HB	0.025xØ	0.5xØ	0.132	0.188	0.226	0.244	0.320	0.376	0.423
				230 HB									
				280 HB									
	High Alloyed	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.025xØ	0.5xØ	0.111	0.158	0.190	0.205	0.269	0.316	0.356
				280 HB									
				320 HB			0.084	0.120	0.144	0.156	0.204	0.240	0.270
K	Grey	GG20, GG40, EN-GJL-250, N030B	150 HB	0.025xØ	0.5xØ	0.154	0.220	0.264	0.286	0.374	0.440	0.495	
			200 HB										
			250 HB										
	Malleable & Nodular	8	GG20, GG70, 50005	150 HB	0.025xØ	0.5xØ	0.133	0.190	0.228	0.247	0.323	0.380	0.428
				200 HB									
				250 HB									
H	Steel	X100 CrMo13, 440C, G-X260NiCr42	45 HRc	0.025xØ	0.5xØ	0.070	0.100	0.120	0.130	0.170	0.200	0.225	
			50 HRc		0.5xØ								
			55 HRc		0.3xØ								0.056
	Chilled Cast Iron	12	Ni-Hard 2	400 HB	0.025xØ	0.3xØ	0.056	0.080	0.096	0.104	0.136	0.160	0.180
				55 HRc									
White Cast Iron	13	G-X300CrMo15	55 HRc	0.025xØ	0.3xØ	0.056	0.080	0.096	0.104	0.136	0.160	0.180	