

MACHINING CONDITIONS - DRILLING - DEPTH OF CUT AND FEED

WCMX 040208 NN  
WCMX 050308 NN

WCMX 06T308 NN  
WCMX 080412 NN

Material Group	Lamina Gr. N°	Material Examples	Hardness	WCMX 040208 NN		WCMX 050308 NN		WCMX 06T308 NN		WCMX 080412 NN		
				Feed [mm/z] min	Feed [mm/z] max	Feed [mm/z] min	Feed [mm/z] max	Feed [mm/z] min	Feed [mm/z] max	Feed [mm/z] min	Feed [mm/z] max	
P Non Alloyed  Low Alloyed  High Alloyed	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.05	0.10	0.06	0.11	0.06	0.12	0.06	0.16	
			190 HB									
			250 HB									
	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.05	0.10	0.06	0.11	0.06	0.12	0.06	0.06	0.16
			230 HB									
			280 HB									
			350 HB									0.15
	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.07	0.10	0.09	0.11	0.08	0.12	0.09	0.09	0.16
			280 HB									
320 HB			0.07	0.09	0.09	0.10	0.08	0.11	0.09	0.14		
350 HB												
M Austenitic  Duplex  Ferritic & Martensitic	4	304, 316, X5CrNi18-9	180 HB	0.05	0.10	0.06	0.11	0.06	0.12	0.06	0.15	
			240 HB									0.07
	5	X2CrNiN23-4, S31500	290 HB	0.07	0.09	0.09	0.10	0.08	0.11	0.09	0.09	0.14
			310 HB									
	6	410, X6Cr17, 17-4PH, 430	200 HB	0.07	0.09	0.09	0.10	0.08	0.11	0.09	0.09	0.14
			42 HRc									
K Grey  Malleable & Nodular	7	GG20, GG40, EN-GJL-250, N030B	150 HB	0.09	0.11	0.09	0.12	0.09	0.13	0.10	0.18	
			200 HB									
			250 HB									
	8	GGG40, GGG70, 50005	150 HB	0.09	0.11	0.09	0.12	0.09	0.13	0.10	0.10	0.18
			200 HB									
			250 HB									
S Fe, Ni & Co based  Ti based	9	Incoloy 800	0.05	0.08	0.06	0.09	0.06	0.10	0.06	0.10	0.13	
		Inconel 700										250 HB
		Stellite 21										350 HB
	10	TiAl6V4	0.05	0.08	0.06	0.09	0.06	0.10	0.06	0.10	0.06	0.13
		T40										
	H Steel  Chilled Cast Iron White Cast Iron	11	X100 CrMo13, 440C, G-X260NiCr42	45 HRc	0.05	0.08	0.06	0.09	0.06	0.10	0.06	0.13
50 HRc												
55 HRc												
400 HB												
55 HRc												
NF Aluminium	12	AlSi12	130 HB	0.05	0.10	0.06	0.11	0.10	0.12	0.10	0.16	