

MACHINING CONDITIONS - TURNING - DEPTH OF CUT AND FEED

WNMG 060408 NN

WNMG 080408 NN

Material Group	Lamina Gr. N°	Material Examples	Hardness	DOC [mm]		Feed [mm/rev]		Amax [mm ²]	Suggested Starting Parameters						
				min	max	min	max		DOC	Feed					
P	Non Alloyed	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.50	2.50	0.21	0.50	1.17	1.80	0.38					
			190 HB							0.35					
			250 HB							0.33					
	Low Alloyed	2	42CrMo4, S150, Ck60, 4140, 4340, 100Cr6	180 HB	0.50	2.50	0.21	0.45	0.78	1.80	0.32				
				230 HB		2.00									
				280 HB		1.80	0.18	0.40	0.65	1.60	0.30				
				350 HB											
	High Alloyed	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.50	2.00	0.18	0.40	0.78	1.50	0.30				
				280 HB											
				320 HB		1.50		0.35	0.52	1.30	0.28				
				350 HB											
	M	Austenitic	4	304, 316, X5CrNi18-9	0.50	2.50	0.20	0.40	0.78	1.80	0.25				
0.65									0.22						
Duplex		5	X2CrNiN23-4, S31500	290 HB	0.50	2.00	0.18	0.35	0.52	1.50	0.24				
				310 HB											
Ferritic & Martensitic		6	410, X6Cr17, 17-4PH, 430	200 HB	0.50	2.50	0.18	0.40	0.46	1.50	0.20				
				42 HRc		2.00				1.30					
K	Grey	7	GG20, GG40, EN-GJL-250, N030B	0.50	2.50	0.15	0.60	1.30	1.80	0.35					
								200 HB			0.55	1.17			
								250 HB							
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.50	2.50	0.15	0.50	0.98	1.80	0.30				
				200 HB					0.85						
				250 HB					0.78						
S	Fe, Ni & Co based	9	Incoloy 800	0.50	1.50	0.20	0.35	0.46	1.20	0.28					
			Inconel 700												
			Stellite 21												
	Ti based	10	T40	0.50	1.80	0.20	0.40	0.52	1.20	0.33					
			TiAl6V4		1.50					0.35	0.46	0.30			
H	Steel	11	X100 CrMo13, 440C, G-X260NiCr42	0.50	1.30	0.11	0.30	0.39	1.20	0.25					
										50 HRc	1.00	0.25	0.26	0.90	0.20
										55 HRc	0.80	0.20	0.20	0.60	0.18
										Ni-Hard 2	1.00	0.25	0.26	0.90	
										400 HB	0.80	0.20	0.20	0.60	0.15
										G-X300CrMo15					
NF	Aluminium	12	AlSi12	0.50	3.00	0.20	0.60	1.17	1.80	0.40					

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 pages 186 and 187 for recommended materials per grade.