

# CNMA 120408 LT 1000

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [mm]		Feed [mm/rev]		Amax [mm²]	V <sub>c</sub> [m/min]		Optimal cutting conditions										
					min	max	min	max		min	max	D.O.C.	Feed	V <sub>c</sub>								
Cast Iron	Grey	7	15	GG20, GG40,	150 HB	0.7	6.0	0.20	0.78	3.40	170	250	4.0	0.44	200							
			15	EN-GJL-250,	200 HB						6.0	0.78			3.06	160	230	180				
			16	No30B	250 HB						6.0	0.72			3.06	150	210	160				
	Malleable & Nodular	8	17,19	GGG40, GGG70,	150 HB	0.7	6.0	0.20	0.65	2.55	120	230	4.0	0.38	180							
															17,19	50005	200 HB	6.0	0.65	2.21	210	160
															18,20	250 HB	6.0	0.65	2.04	190	140	
H	Chilled Cast Iron	11	40	Ni-Hard 2	400 HB	0.7	2.4	0.14	0.33	0.68	40	60	2.0	0.23	50							
			White Cast Iron	41	G-X300CrMo15	55 HRC	0.7	1.8	0.14	0.26	0.51	30	50	1.3	0.19	40						

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					min	max	min	max		min	max	D.O.C.	Feed	V <sub>c</sub>								
Cast Iron	Grey	7	15	GG20, GG40,	150 HB	0.7	6.0	0.20	0.81	3.40	170	250	4.0	0.46	200							
			15	EN-GJL-250,	200 HB						6.0	0.81			3.06	160	230	180				
			16	No30B	250 HB						6.0	0.74			3.06	150	210	160				
	Malleable & Nodular	8	17,19	GGG40, GGG70,	150 HB	0.7	6.0	0.20	0.68	2.55	120	230	4.0	0.40	180							
															17,19	50005	200 HB	6.0	0.68	2.21	210	160
															18,20	250 HB	6.0	0.68	2.04	190	140	
H	Chilled Cast Iron	11	40	Ni-Hard 2	400 HB	0.7	2.4	0.14	0.34	0.68	40	60	2.0	0.24	50							
			White Cast Iron	41	G-X300CrMo15	55 HRC	0.7	1.8	0.14	0.27	0.51	30	50	1.3	0.20	40						

# CNMA 120416 NN LT 1000

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [mm]		Feed [mm/rev]		Amax [mm²]	V <sub>c</sub> [m/min]		Optimal cutting conditions										
					min	max	min	max		min	max	D.O.C.	Feed	V <sub>c</sub>								
Cast Iron	Grey	7	15	GG20, GG40,	150 HB	0.7	6.0	0.20	0.90	3.60	170	250	4.0	0.58	200							
			15	EN-GJL-250,	200 HB						6.0	0.90			3.24	160	230	180				
			16	No30B	250 HB						6.0	0.83			3.24	150	210	160				
	Malleable & Nodular	8	17,19	GGG40, GGG70,	150 HB	0.7	6.0	0.20	0.75	2.70	120	230	4.0	0.50	180							
															17,19	50005	200 HB	6.0	0.75	2.34	210	160
															18,20	250 HB	6.0	0.75	2.16	190	140	
H	Chilled Cast Iron	11	40	Ni-Hard 2	400 HB	0.7	2.4	0.14	0.38	0.72	40	60	2.0	0.30	50							
			White Cast Iron	41	G-X300CrMo15	55 HRC	0.7	1.8	0.14	0.30	0.54	30	50	1.3	0.25	40						