



LT 05 - NS MACHINING CONDITIONS



MATERIAL GROUP		LAMINA GROUP	MATERIAL EXAMPLE	HARDNESS
Aluminium	Al (< 8%Si)	13	Si < 4%	100 HB
				60 HB
	Copper Alloys	14	CuZn30	100 HB
	Non-Metallic	15	Fiber Plastics	-
			Hard Rubber	-
Graphite	-			

DESIGNATION	MATERIAL EXAMPLE	DOC (mm)		FEED (mm/t)		Amax (mm ²)	Vc (m/min)		SUGGESTED STARTING PARAMETERS		
		min	max	min	max		min	max	doc (mm)	feed (mm/t)	Vc (m/min)
CCGT 060204 NS	Si < 4%	0.30	2.50	0.10	0.29	1.02	250	600	1.50	0.23	300
					0.12		0.33	1.28			400
	CuZn30			0.10	0.29	1.02	150	800	1.20	0.15	150
	Fiber Plastics						70	500			
	Hard Rubber			80	300						
	Graphite			100	200						
CCGT 09T304 NS	Si < 4%	0.30	4.50	0.10	0.30	1.20	250	600	2.50	0.23	300
					0.12		0.35	1.50			400
	CuZn30			0.10	0.30	1.20	150	800	2.00	0.15	150
	Fiber Plastics						70	500			
	Hard Rubber			80	300						
	Graphite			100	200						
CNGG 120408 NS	Si < 4%	0.50	6.00	0.18	0.50	2.10	400	1,200	4.00	0.36	400
					0.60		2.52	150			800
	CuZn30			0.18	0.36	1.39	70	500	3.50	0.24	150
	Fiber Plastics						0.40	1.68			
	Hard Rubber			0.34	0.95	80	300	3.00	0.22		
	Graphite			4.00							
CNGG 09T304 NS DNGG 110404 NS TNGG 160404 NS WNGG 080404 NS	Si < 4%	0.30	4.50	0.10	0.30	0.95	400	1,200	2.30	0.27	400
					0.35		1.10	150			800
	CuZn30			0.10	0.27	0.85	70	500	1.60	0.18	150
	Fiber Plastics						0.22	0.69			
	Hard Rubber			0.26	0.73	80	300				
	Graphite			4.00							
DCGT 11T304 NS	Si < 4%	0.30	4.50	0.10	0.30	1.20	250	600	2.30	0.23	300
					0.12		0.35	1.50			400
	CuZn30			0.10	0.30	1.20	150	800	1.80	0.15	150
	Fiber Plastics						70	500			
	Hard Rubber			80	300						
	Graphite			100	200						
DNGG 110408 NS	Si < 4%	0.50	5.00	0.18	0.46	1.61	400	1,200	3.00	0.30	400
					0.60		2.10	150			800
	CuZn30			0.18	0.38	1.20	70	500	2.80	0.24	150
	Fiber Plastics						0.40	1.40			
	Hard Rubber			0.34	0.95	80	300	2.50	0.22		
	Graphite			4.00							

LT 05 - NS - MACHINING CONDITIONS (CON'T)

MATERIAL GROUP		LAMINA GROUP	MATERIAL EXAMPLE	HARDNESS
Aluminium	Al (< 8%Si)	13	Si < 4%	100 HB
				60 HB
	Copper Alloys	14	CuZn30	100 HB
	Non-Metallic	15	Fiber Plastics	-
			Hard Rubber	-
Graphite			-	

DESIGNATION	MATERIAL EXAMPLE	DOC (mm)		FEED (mm/t)		Amax (mm ²)	Vc (m/min)		SUGGESTED STARTING PARAMETERS			
		min	max	min	max		min	max	doc (mm)	feed (mm/t)	Vc (m/min)	
DNGG 150604 NS	Si < 4%	0.30	5.50	0.10	0.30	1.40	250	600	2.50	0.23	300	
					0.12		0.35	1.80			400	1,200
	CuZn30			0.10	0.20	1.40	150	800	2.00	0.15	150	
	Fiber Plastics						70	500				
	Hard Rubber						80	300				
Graphite	100	200										
DNGG 150608 NS WNGG 080408 NS	Si < 4%	0.50	5.50	0.18	0.50	1.40	250	600	3.00	0.32	300	
					0.60		1.80	400			1,200	400
	CuZn30			0.15	0.40	1.40	150	800	0.25	150		
	Fiber Plastics						70	500				
	Hard Rubber						80	300				
Graphite	100	200										
TNGG 160408 NS	Si < 4%	0.30	4.50	0.18	0.50	1.58	400	1,200	2.30	0.36	400	
							250	600			300	
	CuZn30				0.18	0.60	1.89	150	800	0.45	250	
	Fiber Plastics							0.36	1.13			70
	Hard Rubber		0.40					1.26	100			200
Graphite	0.34	0.95	80	300	1.60	0.22						
WNGG 060404 NS	Si < 4%	0.30	3.00	0.10	0.30	0.95	400	1,200	1.80	0.27	400	
							250	600			300	
	CuZn30				0.10	0.35	1.10	150	800	0.25	250	
	Fiber Plastics							0.27	0.85			70
	Hard Rubber		0.22					0.69	100			200
Graphite	0.26	0.73	80	300	1.60	0.18						
WNGG 060408 NS	Si < 4%	0.50	3.00	0.18	0.50	1.40	250	600	1.80	0.32	300	
					0.60		1.80	400			1,200	400
	CuZn30			0.15	0.40	1.40	150	800	0.25	150		
	Fiber Plastics						70	500				
	Hard Rubber						80	300				
Graphite	100	200										