

CBN

MACHINING CONDITIONS

LTCBN55H

H

MATERIAL GROUP	LAMINA GR. N°	VDI	MATERIAL EXAMPLE	HARDNESS
Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	50 HRc
				55 HRc
				60 HRc

CCGW 060202T1-01215	DCGW 070202T1-01215	SCMW 120408T1-01225	TCGW 090202T1-01215	VCGW 110302T1-01215
CCGW 060204T1-01215	DCGW 070204T1-01215	SNGA 120404S4-01215	TCGW 090204T1-01215	VCGW 110304T1-01215
CCGW 09T304T1-01215	DCGW 11T304T1-01215	SNGA 120408S4-01225	TCGW 110204T1-01215	VCGW 160404T1-01215
CCGW 09T308T1-01225	DCGW 11T308T1-01225	SNGA 120412S4-01225	TCGW 110208T1-01225	VCGW 160408T1-01225
CNGA 120404S2-01225	DNGA 150404S2-01215		TNGA 160404S3-01215	VNGA 160404S2-01215
CNGA 120408S2-01225	DNGA 150408S2-01225		TNGA 160408S3-01225	VNGA 160408S2-01225
CNGA 20412S2-01225	DNGA 150604S2-01215		TNGA 160412S3-01225	VNGA 160412S2-01225
	DNGA 150608S2-01225			WNGA 080404S3-01215
	DNGA 150612S2-01225			WNGA 080408S3-01215
				WNGA 080412S3-01215

VDI	HARDNESS	DOC (MM)		FEED (MM/T)		VC (M/MIN)		SUGGESTED STARTING PARAMETERS		
		MIN	MAX	MIN	MAX	MIN	MAX	DOC (MM)	FEED (MM/T)	VC (M/MIN)
38	50 HRc								0.15	180
	55 HRc	0.05	0.4	0.05	0.25	100	220	0.1	0.12	150
	60 HRc								0.10	120

CBN

MACHINING CONDITIONS



LAMINA
TECHNOLOGIES

LTCBN70H

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MATERIAL GROUP	LAMINA GR. N°	VDI	MATERIAL EXAMPLE	HARDNESS
Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	50 HRc
				55 HRc
				60 HRc

CNGA 120404S2-01235 CNGA 120408S2-01235	DNGA 150408S2-01235	SNGA 120408S4-01235	TNGA 160408S3-01235	VNGA 160408S2-01235 WNGA 080408S3-01235
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VDI	HARDNESS	DOC (MM)		FEED (MM/T)		VC (M/MIN)		SUGGESTED STARTING PARAMETERS		
		MIN	MAX	MIN	MAX	MIN	MAX	DOC (MM)	FEED (MM/T)	VC (M/MIN)
38	50 HRc								0.12	170
	55 HRc	0.05	0.3	0.05	0.20	100	220	0.1	0.10	140
	60 HRc								0.08	110

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MACHINING CONDITIONS



LTCBN90K

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MATERIAL GROUP	LAMINA GR. N°	VDI	MATERIAL EXAMPLE	HARDNESS
Cast Iron	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB
				200 HB
				250 HB

CNGA 120408S2-01225 CNGA 120412S2-01225	DNGA 150608S2-01225 DNGA 150612S2-01225	SNGA 20408S4-01225 SNGA 120412S4-01225	TNGA 160408S3-01225 TNGA 160412S3-01225	VNGA 160408S2-01225 VNGA 160412S2-01225 WNGA 080408S3-01225 WNGA 080412S3-01225
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VDI	HARDNESS	DOC (MM)		FEED (MM/T)		VC (M/MIN)		SUGGESTED STARTING PARAMETERS		
		MIN	MAX	MIN	MAX	MIN	MAX	DOC (MM)	FEED (MM/T)	VC (M/MIN)
15	150 HB	0.1	1.0	0.05	0.30	500	1200	0.5	0.28	1000
	200 HB						1100		0.26	900
16	250 HB						1000		0.24	800

CBN

MACHINING CONDITIONS

LTCBN90K



MATERIAL GROUP	LAMINA GR. N°	VDI	MATERIAL EXAMPLE	HARDNESS
Cast Iron	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB
				200 HB
		16		250 HB
Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	50 HRc
				55 HRc
				60 HRc

CNGN 120404S-01215*	RNGN 120400S-01225	SNGN 120404S-01215
CNGN 120408S-01225	RNGN 120700S-01225	SNGN 120408S-01225
CNGN 120412S-01225		SNGN 120412S-01225

MATERIAL EXAMPLES	VDI	HARDNESS	DOC (MM)		FEED (MM/T)		VC (M/MIN)		SUGGESTED STARTING PARAMETERS		
			MIN	MAX	MIN	MAX	MIN	MAX	DOC (MM)	FEED (MM/T)	VC (M/MIN)
GG20, GG40, EN-GJL-250, No30B	15	150 HB	0.5	4.0	0.05	0.50	500	1200	2.0	0.40	1000
		200 HB				0.40		1100		0.35	900
	16	250 HB				1000		0.30		800	
X100CrMo13, 440C, G-X260NiCr42	38	50 HRc	0.20	2.0	0.05	0.25	100	200	0.5	0.22	170
		55 HRc				0.20				0.18	140
		60 HRc				1.0				0.15	110

* Doc / Feed = 50% from recommended