



LT 1125P MACHINING CONDITIONS



MATERIAL GROUP		LAMINA GROUP	MATERIAL EXAMPLE	HARDNESS
Steel	Non-alloyed	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB
				190 HB
				250 HB
	Low alloyed	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB
				230 HB
				280 HB
				350 HB
	High alloyed	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB
				280 HB
350 HB				

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)			
CNMG 120404 MP DNMG 110404 MP DNMG 150404 MP DNMG 150604 MP TNMG 160404 MP VNMG 160404 MP WNMG 080404 MP	C35, Ck45, 1020, 1045, 1060, 28Mn6	0.30	3.00	0.11	0.23	0.60	90	330	2.00	0.18	240			
					0.22	0.52					280			
			2.50	0.10	0.20	0.48	60	280			2.00	0.14	200	
						0.40							250	
			2.00	0.09	0.18	0.36	35	190			1.70	0.10	180	
						0.40							150	
	2.50	0.16	0.16	0.32	110	130	0.29	0.27	120					
				0.26					90					
	CNMG 120408 MP DNMG 110408 MP DNMG 150408 MP DNMG 150608 MP SNMG 120408 MP TNMG 160408 MP TNMG 220408 MP VNMG 160408 MP	C35, Ck45, 1020, 1045, 1060, 28Mn6	0.50	5.00	0.18	0.50	1.71	90	330	3.00	0.36	240		
						0.45	1.42					280		
				5.00	0.18	0.45	60	1.14	250			3.00	0.30	200
														0.40
4.00				0.16	0.40	35	0.95	180	2.70			0.29	180	
													0.40	140
3.50		0.16	0.35	110	0.76	130	2.50	0.27	120					
									0.76	90				
WNMG 060408 MP WNMG 080408 MP		C35, Ck45, 1020, 1045, 1060, 28Mn6	0.50	2.50	0.18	0.50	1.13	90	330	1.80	0.36	240		
						0.45	0.95					280		
				2.50	0.18	0.45	60	0.76	250			1.80	0.30	200
														0.40
	2.00			0.16	0.40	35	0.63	180	1.60			0.29	180	
													0.40	140
	1.80	0.16	0.35	110	0.50	130	1.30	0.27	120					
									0.50	90				
	CNMG 120412 MP DNMG 150412 MP DNMG 150612 MP TNMG 160404 MP SNMG 120412 MP TNMG 160412 MP TNMG 220412 MP	C35, Ck45, 1020, 1045, 1060, 28Mn6	0.70	6.00	0.26	0.68	3.06	90	330	4.00	0.50	240		
						0.61	2.55					280		
				6.00	0.26	0.61	60	2.04	250			4.00	0.42	200
														0.54
4.80				0.22	0.54	35	1.70	180	3.60			0.40	180	
													0.54	140
4.20		0.22	0.47	110	1.36	130	3.40	0.37	120					
									0.47	90				

LT 1125P MACHINING CONDITIONS (CON'T)

WNMG 080412 MP	C35, Ck45, 1020, 1045, 1060, 28Mn6	0.70	3.50	0.25	0.65	2.16	90	330	2.60	0.48	240	
					0.59	1.80		280		0.44	220	
					0.59	1.44		250		0.41	200	
	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6		0.22	0.52	1.20	60	280	2.60	0.40	200		
							250		180	0.38	150	
							210		180	0.38	130	
	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	0.22	0.52	1.44	35	190	2.10	0.38	140			
						150		130	0.35	100		
						110		110	0.35	90		
	CNMG 160616 MP	C35, Ck45, 1020, 1045, 1060, 28Mn6	1.50	7.60	0.44	0.8	4.40	90	330	6.00	0.70	240
						0.78	4.20		280		0.65	220
						0.74	4.00		250		0.62	200
42CrMo4, St50, Ck60, 4140, 4340, 100Cr6		0.40		0.70	3.40	60	280	6.00	0.60	200		
							250		180	0.53	150	
							210		180	0.53	130	
X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19		0.40	0.72	3.00	35	190	5.00	0.50	140			
						150		130	0.48	120		
						110		110	0.48	100		



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