

# Technical Data and Settings

## Cutting Data SNAP18 Module

Material	Condition	Tensile strength (N/mm <sup>2</sup> )	Hardness HB	SNAP18 Module	
				Cutting speed (m/min)	Feed* (mm/rev)
Unalloyed steel		<500	<150	40-70	0.05-0.1
Cast steel		500 - 850	150 - 250	40-70	0.05-0.1
Grey cast iron		<500	<150	50-90	0.05-0.1
Ductile cast iron		300 - 800	90 - 240	40-70	0.05-0.1
Low alloy steel	annealed	<850	<250	40-70	0.05-0.1
	tempered	850 - 1000	250 - 300	30-50	0.05-0.1
	tempered	>1000 - 1200	>300 - 350	20-40	0.05-0.06
High alloy steel	annealed	<850	<250	20-50	0.05-0.08
	tempered	850 - 1100	250 - 320	15-30	0.02-0.06
Stainless steel	ferritic	450 - 650	130 - 190	15-30	0.05-0.1
	austenitic	650 - 900	190 - 270	10-20	0.05-0.08
	martensitic	500 - 700	150 - 200	15-30	0.02-0.06
Special alloy (Inconel, titanium)		<1200	<350	10-20	0.02-0.06
Wrought or cast aluminium alloys				70-120	0.02-0.2
Copper alloy	Brass			60-90	0.05-0.1
	Bronze short-chipping			30-50	0.05-0.1
	Bronze long-chipping			20-30	0.05-0.1

\*When using two modules it is possible to double the feedrate.