

CNGG 120404 ALU LT 05

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [mm]		Feed [mm/rev]		Amax [mm ²]	V _c [m/min]		Optimal cutting conditions		
					min	max	min	max		min	max	D.O.C	Feed	V _c
NF	13	21, 22 23, 24	Si < 4 %	60 HB	0.3	5.0	0.12	0.35	1.50	400	1200	2.5	0.23	400
			4% < Si < 8 %	100 HB		5.0				0.10				0.30
	14	26,27,28	CuZn30	100 HB	0.3	5.0	0.10	0.30	1.20	150	800	2.5	0.23	250
	15	29	Fiber Plastics	-	0.3	5.0	0.10	0.20	1.20	70	500	2.0	0.15	150
30		Hard Rubber	-	5.0		0.20		80		300				
-		Graphite	-	5.0		0.20		100		200				
H.T.A.	10	36	Ti 1	-	0.3	2.0	0.09	0.16	0.28	35	60	1.5	0.13	45
		37	TiAl 6 V4	-		2.0	0.12	0.20	0.24	28	40		0.12	35

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					min	max	min	max		min	max	D.O.C	Feed	V _c
NF	13	21, 22 23, 24	Si < 4 %	60 HB	0.3	5.0	0.18	0.60	1.50	400	1200	3.0	0.32	400
			4% < Si < 8 %	100 HB		5.0		0.50		1.20				250
	14	26,27,28	CuZn30	100 HB	0.3	5.0	0.15	0.40	1.20	150	800	3.0	0.25	250
	15	29	Fiber Plastics	-	0.3	5.0	0.15	0.40	1.20	70	500	3.0	0.25	150
30		Hard Rubber	-	5.0		0.40		80		300				
-		Graphite	-	5.0		0.40		100		200				
H.T.A.	10	36	Ti 1	-	0.3	4.0	0.15	0.28	0.28	35	60	2.5	0.20	45
		37	TiAl 6 V4	-		4.0		0.26	0.24	28	40		2.5	0.18