

DNGG 110404 ALU LT 05

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [mm]		Feed [mm/rev]		Amax [mm²]	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	4.0	0.12	0.35	1.50	400	1200	2.5	0.23	400							
			4% < Si < 8 %	100 HB		4.0		0.10		0.30				1.20	250	600	300				
	14	26,27,28	CuZn30	100 HB	0.3	4.0	0.10	0.30	1.20	150	800	2.5	0.23	250							
															29	Fiber Plastics	-	4.0	0.20	70	500
15	30	-	Hard Rubber	-	0.3	4.0	0.10	0.20	1.20	80	300	2.0	0.15	150							
															-	Graphite	-	4.0	0.20	100	200
H.T.A.	10	36 37	Ti 1	-	0.3	2.0	0.09	0.16	0.28	35	60	1.5	0.13	45							
			TiAl 6 V4	-		2.0		0.12		0.20				0.24	28	40	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	4.0	0.18	0.60	1.50	400	1200	2.0	0.25	400							
			4% < Si < 8 %	100 HB		4.0		0.50		1.20				250	600	300					
	14	26,27,28	CuZn30	100 HB	0.3	4.0	0.15	0.40	1.20	150	800	2.0	0.25	250							
															29	Fiber Plastics	-	4.0	0.40	70	500
15	30	-	Hard Rubber	-	0.3	4.0	0.15	0.40	1.20	80	300	2.0	0.25	150							
															-	Graphite	-	4.0	0.40	100	200
H.T.A.	10	36 37	Ti 1	-	0.3	3.0	0.15	0.28	0.28	35	60	2.0	0.20	45							
			TiAl 6 V4	-		3.0		0.26		0.24				28	40	35					