

SEGT 1204 AFEN ALU LT 05

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [mm]		Feed [mm/tooth]		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	9.0	0.12	0.35	400	1200	3.0	0.25	500
			4% < Si < 8 %	100 HB		9.0	0.10	0.35	250	600			400
	14	26,27,28	CuZn30	100 HB	0.3	9.0	0.10	0.35	100	800	3.0	0.25	300
	15	29	Fiber Plastics	-	0.3	9.0	0.12	0.35	80	500	3.0	0.20	200
30		Hard Rubber	-	9.0		0.35		80	300	150			
-		Graphite	-	9.0		0.35		100	200	150			
H.T.A.	10	36	Ti 1	-	0.3	5.0	0.08	0.35	35	60	2.0	0.20	45
37		TiAl 6 V4	-	5.0		0.28		28	45	35			