

TNGG 160404 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 | Al (<8%Si) | 13 | 21, 22 | Si < 4 % | 60 HB | 0.3 | 4.0 | 0.12 | 0.35 | 1.50 | 400 | 1200 | 2.5 | 0.23 | 400 |
| | | | 23, 24 | 4% < Si < 8 % | 100 HB | | 4.0 | 0.10 | 0.30 | 1.20 | 250 | 600 | | | 300 |
| | Cooper Alloys | 14 | 26,27,28 | CuZn30 | 100 HB | 0.3 | 4.0 | 0.10 | 0.30 | 1.20 | 150 | 800 | 2.5 | 0.23 | 250 |
| | Non-Metallic | 15 | 29 | Fiber Plastics | - | 0.3 | 4.0 | 0.10 | 0.20 | 1.20 | 70 | 500 | 2.0 | 0.15 | 150 |
| | | | 30 | Hard Rubber | - | | 4.0 | | 0.20 | 1.20 | 80 | 300 | | | |
| - | | | Graphite | - | 4.0 | | 0.20 | | 1.20 | 100 | 200 | | | | |
| H.T.A. | Ti based Alloys | 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 | | | | |