

VNGG 160404 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	Al (<8%Si)	13	21, 22	Si < 4 %	60 HB	0.3	4.0	0.12	0.30	1.50	400	1200	2.5	0.23	400
			23, 24	4% < Si < 8 %	100 HB		4.0	0.10	0.25	1.20	250	600			300
	Cooper Alloys	14	26, 27, 28	CuZn30	100 HB	0.3	4.0	0.10	0.25	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		80	300			
-			Graphite	-	4.0		0.20		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

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						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	6.0	0.18	0.60	1.50	400	1200	3.0	0.25	400
			23, 24	4% < Si < 8 %	100 HB		6.0		0.50	1.20	250	600			300
	Cooper Alloys	14	26, 27, 28	CuZn30	100 HB	0.3	6.0	0.15	0.40	1.20	150	800	3.0	0.25	250
	Non-Metallic	15	29	Fiber Plastics	-	0.3	6.0	0.15	0.40	1.20	70	500	3.0	0.25	150
			30	Hard Rubber	-		6.0		0.40	1.20	80	300			150
-			Graphite	-	6.0		0.40		1.20	100	200	150			
H.T.A.	Ti based Alloys	10	36	Ti 1	-	0.3	3.0	0.15	0.28	0.28	35	60	2.0	0.20	45
			37	TiAl 6 V4	-		3.0		0.26	0.24	28	40		0.18	35