ALU-TURNING

LT 05

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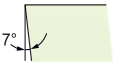
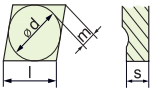
C C G T

Shape

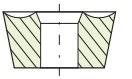


Clearance Angle



Tolerance

d ± 0.025
m ± 0.025
s ± 0.130



Fixing, Chipbreaker

LT 05					Application Guide		
Insert Designation	l	s	r	Catalog Nr.	F	M	R
CCGT 060204 ALU LT 05	6	2.38	0.4	T0004162	●	●	●
CCGT 09T304 ALU LT 05	9	3.97	0.4	T0004163	●	●	●

ISO standard with extreme and unique positive chipbreaker geometry for aluminium turning operations. Suitable mostly for external operations but good also for internal operations, roughing and finishing.

Machining Recommendations

Details on page 14

Application Guide

Finishing: (**F**)
d.o.c. =0.30 - 1.50 mm
fn =0.08 - 0.20 mm/rev

Medium: (**M**)
d.o.c. =0.70 - 4.50 mm
fn =0.15 - 0.45 mm/rev

Roughing: (**R**)
d.o.c. =3.00 - 7.00 mm
fn =0.35 - 0.70 mm/rev

● = Good ● = Acceptable ● = Not recommended

CCGT 060204 ALU – **LT 05**

	Material Group	Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm] min	D.O.C [mm] max	Feed [mm/rev] min	Feed [mm/rev] max	Amax [mm²]	V_c [m/min] min	V_c [m/min] max	Suggested Starting Parameters D.O.C	Feed	V_c
NF	Al (<8%Si)	13	21, 22 23, 24	Si < 4 %	60 HB	0.3	2.5	0.12	0.33		400	1200	**1.5**	**0.23**	**400**
				4% < Si < 8 %	100 HB	0.3	2.5	0.10	0.29		250	600	**1.5**	**0.23**	**300**
	Copper Alloys	14	26,27,28	CuZn30	100 HB	0.3	2.5	0.10	0.29		150	800	**1.5**	**0.23**	**250**
	Non-Metallic	15	29	Fiber Plastics	-	0.3	2.5	0.10	0.19		70	500	**1.2**	**0.15**	**150**
			30	Hard Rubber	-	0.3	2.5	0.10	0.19		80	300	**1.2**	**0.15**	**150**
			-	Graphite	-	0.3	2.5	0.10	0.19		100	200	**1.2**	**0.15**	**150**
H.T.A	Ti Based Alloys	10	36	Ti 1	-	0.3	1.0	0.09	0.15		35	60	**0.9**	**0.13**	**45**
			37	TiAl 6 V4	-	0.3	1.0	0.12	0.19		28	40	**0.9**	**0.12**	**35**

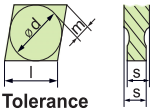
CCGT 09T304 ALU – **LT 05**

	Material Group	Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm] min	D.O.C [mm] max	Feed [mm/rev] min	Feed [mm/rev] max	Amax [mm²]	V_c [m/min] min	V_c [m/min] max	Suggested Starting Parameters D.O.C	Feed	V_c
NF	Al (<8%Si)	13	21, 22 23, 24	Si < 4 %	60 HB	0.3	4.5	0.12	0.35	1.50	400	1200	**2.5**	**0.23**	**400**
				4% < Si < 8 %	100 HB	0.3	4.5	0.10	0.30	1.20	250	600	**2.5**	**0.23**	**300**
	Copper Alloys	14	26,27,28	CuZn30	100 HB	0.3	4.5	0.10	0.30	1.20	150	800	**2.5**	**0.23**	**250**
	Non-Metallic	15	29	Fiber Plastics	-	0.3	4.5	0.10	0.20	1.20	70	500	**2.0**	**0.15**	**150**
			30	Hard Rubber	-	0.3	4.5	0.10	0.20	1.20	80	300	**2.0**	**0.15**	**150**
			-	Graphite	-	0.3	4.5	0.10	0.20	1.20	100	200	**2.0**	**0.15**	**150**
H.T.A	Ti Based Alloys	10	36	Ti 1	-	0.3	1.8	0.09	0.16	0.28	35	60	**1.5**	**0.13**	**45**
			37	TiAl 6 V4	-	0.3	1.8	0.12	0.20	0.24	28	40	**1.5**	**0.12**	**35**

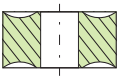
C N G G

Shape

Clearance Angle



Tolerance
d ± 0.025
m ± 0.025
s ± 0.13



Fixing, Chipbreaker

LT 05					Application Guide		
Insert Designation	l	s	r	Catalog Nr.	F	M	R
CNGG 09T304 ALU LT 05	9	3.97	0.4	T0003298	●	●	●
CNGG 120404 ALU LT 05	12	4.76	0.4	T0001025	●	●	●
CNGG 120408 ALU LT 05	12	4.76	0.8	T0001019	●	●	●

ISO standard with extreme and unique positive chipbreaker geometry for aluminium turning operations. Suitable mostly for external operations but good also for internal op-erations, roughing and finishing.

Machining Recommendations

Details on page 14

Application Guide

Finishing: (**F**)
d.o.c. =0.30 - 1.50 mm
fn =0.08 - 0.20 mm/rev

Medium: (**M**)
d.o.c. =0.70 - 4.50 mm
fn =0.15 - 0.45 mm/rev

Roughing: (**R**)
d.o.c. =3.00 - 7.00 mm
fn =0.35 - 0.70 mm/rev

● = Good ● = Acceptable ● = Not recommended

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www.akytec.ru

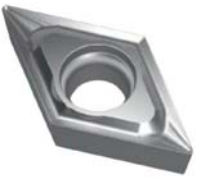
CNGG 09T304 ALU – LT 05

CNGG 120404 ALU – LT 05

	Material Group	Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm] min	D.O.C [mm] max	Feed [mm/rev] min	Feed [mm/rev] max	Amax [mm²]	V_c [m/min] min	V_c [m/min] max	Suggested Starting Parameters D.O.C	Feed	V_c
NF	Al (<8%Si)	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	0.3	5.0	0.10	0.30	1.20	250	600	2.5	0.23	300
	Copper Alloys	14	26,27,28	CuZn30	100 HB	0.3	5.0	0.10	0.30	1.20	150	800	2.5	0.23	250
	Non-Metallic	15	29	Fiber Plastics	-	0.3	5.0	0.10	0.20	1.20	70	500	2.0	0.15	150
			30	Hard Rubber	-	0.3	5.0	0.10	0.20	1.20	80	300	2.0	0.15	150
			-	Graphite	-	0.3	5.0	0.10	0.20	1.20	100	200	2.0	0.15	150
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	-	0.3	2.0	0.12	0.20	0.24	28	40	1.5	0.12	35

CNGG 120408 ALU – LT 05

	Material Group	Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm] min	D.O.C [mm] max	Feed [mm/rev] min	Feed [mm/rev] max	Amax [mm²]	V_c [m/min] min	V_c [m/min] max	Suggested Starting Parameters D.O.C	Feed	V_c
NF	Al (<8%Si)	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	0.3	5.0	0.18	0.50	1.20	250	600	3.0	0.32	300
	Copper Alloys	14	26,27,28	CuZn30	100 HB	0.3	5.0	0.15	0.40	1.20	150	800	3.0	0.25	250
	Non-Metallic	15	29	Fiber Plastics	-	0.3	5.0	0.15	0.40	1.20	70	500	3.0	0.25	150
			30	Hard Rubber	-	0.3	5.0	0.15	0.40	1.20	80	300	3.0	0.25	150
			-	Graphite	-	0.3	5.0	0.15	0.40	1.20	100	200	3.0	0.25	150
H.T.A	Ti Based Alloys	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	-	0.3	4.0	0.15	0.26	0.24	28	40	2.5	0.18	35



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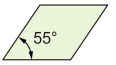
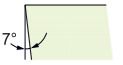
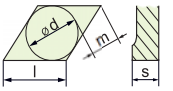


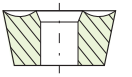
Shape



Clearance Angle



Tolerance
d ± 0.025
m ± 0.025
s ± 0.130



Fixing, Chipbreaker

LT 05					Application Guide		
Insert Designation	l	s	r	Catalog Nr.	F	M	R
DCGT 11T304 ALU LT 05	11	3.97	0.4	T0006164	●	●	●

ISO standard with extreme and unique positive chipbreaker geometry for aluminium turning operations.
Suitable mostly for external operations but good also for internal operations, roughing and finishing.

Machining Recommendations

Details on page 14

Application Guide

Finishing: (**F**)
d.o.c. =0.30 - 1.50 mm
fn =0.08 - 0.20 mm/rev

Medium: (**M**)
d.o.c. =0.70 - 4.50 mm
fn =0.15 - 0.45 mm/rev

Roughing: (**R**)
d.o.c. =3.00 - 7.00 mm
fn =0.35 - 0.70 mm/rev

● = Good ● = Acceptable ● = Not recommended

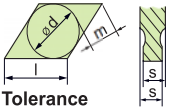
DCGT 11T304 ALU – **LT 05**

	Material Group	Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		Amax [mm²]	V_c [m/min]		Suggested Starting Parameters		
						min	max	min	max		min	max	D.O.C	Feed	V_c
NF	Al (<8%Si)	13	21, 22 23, 24	Si < 4 %	60 HB	0.3	4.5	0.12	0.35	1.50	400	1200	**2.3**	**0.23**	**400**
				4% < Si < 8 %	100 HB	0.3	4.5	0.10	0.30	1.20	250	600	**2.3**	**0.23**	**300**
	Copper Alloys	14	26,27,28	CuZn30	100 HB	0.3	4.5	0.10	0.30	1.20	150	800	**2.3**	**0.23**	**250**
	Non-Metallic	15	29	Fiber Plastics	-	0.3	4.5	0.10	0.20	1.20	70	500	**1.8**	**0.15**	**150**
			30	Hard Rubber	-	0.3	4.5	0.10	0.20	1.20	80	300	**1.8**	**0.15**	**150**
			-	Graphite	-	0.3	4.5	0.10	0.20	1.20	100	200	**1.8**	**0.15**	**150**
H.T.A	Ti Based Alloys	10	36	Ti 1	-	0.3	1.8	0.09	0.16	0.28	35	60	**1.4**	**0.13**	**45**
			37	TiAl 6 V4	-	0.3	1.8	0.12	0.20	0.24	28	40	**1.4**	**0.12**	**35**

D N G G

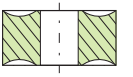
Shape

Clearance Angle



Tolerance

d ± 0.025
m ± 0.025
s ± 0.13



Fixing, Chipbreaker

LT 05					Application Guide		
Insert Designation	l	s	r	Catalog Nr.	F	M	R
DNGG 110404 ALU LT 05	11	4.76	0.4	T0001026	●	●	●
DNGG 110408 ALU LT 05	11	4.76	0.8	T0001010	●	●	●

ISO standard with extreme and unique positive chipbreaker geometry for aluminium turning operations. Suitable mostly for external operations but good also for internal op-erations, roughing and finishing.

Machining Recommendations

Details on page 14

Application Guide

Finishing: (**F**)
d.o.c. =0.30 - 1.50 mm
fn =0.08 - 0.20 mm/rev

Medium: (**M**)
d.o.c. =0.70 - 4.50 mm
fn =0.15 - 0.45 mm/rev

Roughing: (**R**)
d.o.c. =3.00 - 7.00 mm
fn =0.35 - 0.70 mm/rev

● = Good ● = Acceptable ● = Not recommended

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DNGG 110404 ALU – LT 05

	Material Group	Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm] min	D.O.C [mm] max	Feed [mm/rev] min	Feed [mm/rev] max	Amax [mm²]	V_c [m/min] min	V_c [m/min] max	Suggested Starting Parameters D.O.C	Feed	V_c
NF	Al (<8%Si)	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	0.3	4.0	0.10	0.30	1.20	250	600	**2.5**	**0.23**	**300**
	Copper 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	-	0.3	4.0	0.10	0.20	1.20	80	300	**2.0**	**0.15**	**150**
			-	Graphite	-	0.3	4.0	0.10	0.20	1.20	100	200	**2.0**	**0.15**	**150**
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	-	0.3	2.0	0.12	0.20	0.24	28	40	**1.5**	**0.12**	**35**

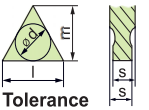
DNGG 110408 ALU – LT 05

	Material Group	Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm] min	D.O.C [mm] max	Feed [mm/rev] min	Feed [mm/rev] max	Amax [mm²]	V_c [m/min] min	V_c [m/min] max	Suggested Starting Parameters D.O.C	Feed	V_c
NF	Al (<8%Si)	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	0.3	4.0	0.18	0.50	1.20	250	600	**2.0**	**0.25**	**300**
	Copper Alloys	14	26,27,28	CuZn30	100 HB	0.3	4.0	0.15	0.40	1.20	150	800	**2.0**	**0.25**	**250**
	Non-Metallic	15	29	Fiber Plastics	-	0.3	4.0	0.15	0.40	1.20	70	500	**2.0**	**0.25**	**150**
			30	Hard Rubber	-	0.3	4.0	0.15	0.40	1.20	80	300	**2.0**	**0.25**	**150**
			-	Graphite	-	0.3	4.0	0.15	0.40	1.20	100	200	**2.0**	**0.25**	**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	-	0.3	3.0	0.15	0.26	0.24	28	40	**2.0**	**0.18**	**35**

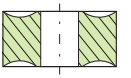
T N G G

Shape

Clearance Angle



Tolerance
d ± 0.025
m ± 0.025
s ± 0.13



Fixing, Chipbreaker

LT 05					Application Guide		
Insert Designation	l	s	r	Catalog Nr.	F	M	R
TNGG 160404 ALU LT 05	16	4.76	0.4	T0001105	●	●	●

ISO standard with extreme and unique positive chipbreaker geometry for aluminium turning operations. Suitable mostly for external operations but good also for internal op-erations, roughing and finishing.

Machining Recommendations

Details on page 14

Application Guide

Finishing: (**F**)
d.o.c. =0.30 - 1.50 mm
fn =0.08 - 0.20 mm/rev

Medium: (**M**)
d.o.c. =0.70 - 4.50 mm
fn =0.15 - 0.45 mm/rev

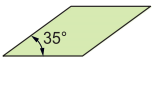
Roughing: (**R**)
d.o.c. =3.00 - 7.00 mm
fn =0.35 - 0.70 mm/rev

● = Good ● = Acceptable ● = Not recommended

TNGG 160404 ALU – **LT 05**

	Material Group	Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm]		Feed [mm/rev]		Amax [mm²]	V_c [m/min]		Suggested Starting Parameters		
						min	max	min	max		min	max	D.O.C	Feed	V_c
NF	Al (<8%Si)	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	0.3	4.0	0.10	0.30	1.20	250	600	**2.5**	**0.23**	**300**
	Copper 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	-	0.3	4.0	0.10	0.20	1.20	80	300	**2.0**	**0.15**	**150**
			-	Graphite	-	0.3	4.0	0.10	0.20	1.20	100	200	**2.0**	**0.15**	**150**
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	-	0.3	2.0	0.12	0.20	0.24	28	40	**1.5**	**0.12**	**35**

V N G G



Shape | **Clearance Angle** | **Tolerance** | **Fixing, Chipbreaker**

Tolerance
d ± 0.025
m ± 0.025
s ± 0.13

LT 05					Application Guide		
Insert Designation	l	s	r	Catalog Nr.	F	M	R
VNGG 160404 ALU LT 05	16	4.76	0.4	T0001006	●	●	●
VNGG 160408 ALU LT 05	16	4.76	0.8	T0001032	●	●	●

ISO standard with extreme and unique positive chipbreaker geometry for aluminium turning operations. Suitable mostly for external operations but good also for internal op-erations, roughing and finishing.

Machining Recommendations

Details on page 14

Application Guide

Finishing: (**F**)
d.o.c. =0.30 - 1.50 mm
fn =0.08 - 0.20 mm/rev

Medium: (**M**)
d.o.c. =0.70 - 4.50 mm
fn =0.15 - 0.45 mm/rev

Roughing: (**R**)
d.o.c. =3.00 - 7.00 mm
fn =0.35 - 0.70 mm/rev

● = Good ● = Acceptable ● = Not recommended

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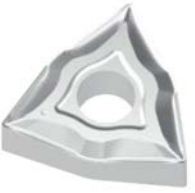
тел. 8 (499) 550 5039, mail@akytec.ru
www.akytec.ru

VNGG 160404 ALU – **LT 05**

	Material Group	Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm] min	D.O.C [mm] max	Feed [mm/rev] min	Feed [mm/rev] max	Amax [mm²]	V_c [m/min] min	V_c [m/min] max	Suggested Starting Parameters D.O.C	Feed	V_c
NF	Al (<8%Si)	13	21, 22 23, 24	Si < 4 %	60 HB	0.3	4.0	0.12	0.35	1.20	400	1200	**2.3**	**0.23**	**400**
				4% < Si < 8 %	100 HB	0.3	4.0	0.10	0.30	0.96	250	600	**2.3**	**0.23**	**300**
	Copper Alloys	14	26,27,28	CuZn30	100 HB	0.3	4.0	0.10	0.30	0.96	150	800	**2.3**	**0.23**	**250**
	Non-Metallic	15	29	Fiber Plastics	-	0.3	4.0	0.10	0.20	0.96	70	500	**1.8**	**0.15**	**150**
			30	Hard Rubber	-	0.3	4.0	0.10	0.20	0.96	80	300	**1.8**	**0.15**	**150**
			-	Graphite	-	0.3	4.0	0.10	0.20	0.96	100	200	**1.8**	**0.15**	**150**
H.T.A	Ti Based Alloys	10	36	Ti 1	-	0.3	2.0	0.09	0.16	0.22	35	60	**1.4**	**0.13**	**45**
			37	TiAl 6 V4	-	0.3	2.0	0.12	0.20	0.19	28	40	**1.4**	**0.12**	**35**

VNGG 160408 ALU – **LT 05**

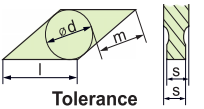
	Material Group	Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm] min	D.O.C [mm] max	Feed [mm/rev] min	Feed [mm/rev] max	Amax [mm²]	V_c [m/min] min	V_c [m/min] max	Suggested Starting Parameters D.O.C	Feed	V_c
NF	Al (<8%Si)	13	21, 22 23, 24	Si < 4 %	60 HB	0.010	0.236	0.007	0.024	0.0023	1320	3960	**0.118**	**0.010**	**1320**
				4% < Si < 8 %	100 HB	0.010	0.236	0.007	0.020	0.0019	825	1980	**0.118**	**0.010**	**990**
	Copper Alloys	14	26,27,28	CuZn30	100 HB	0.010	0.236	0.006	0.016	0.0019	495	2640	**0.118**	**0.010**	**825**
	Non-Metallic	15	29	Fiber Plastics	-	0.010	0.236	0.006	0.016	0.0019	231	1650	**0.118**	**0.010**	**495**
			30	Hard Rubber	-	0.010	0.236	0.006	0.016	0.0019	264	990	**0.118**	**0.010**	**495**
			-	Graphite	-	0.010	0.236	0.006	0.016	0.0019	330	660	**0.118**	**0.010**	**495**
H.T.A	Ti Based Alloys	10	36	Ti 1	-	0.010	0.118	0.006	0.011	0.0004	115.5	198	**0.079**	**0.008**	**148.5**
			37	TiAl 6 V4	-	0.010	0.118	0.006	0.010	0.0004	92.4	132	**0.079**	**0.007**	**115.5**



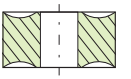
W N G G

Shape

Clearance Angle



Tolerance
d ± 0.025
m ± 0.025
s ± 0.13



Fixing, Chipbreaker

LT 05					Application Guide		
Insert Designation	l	s	r	Catalog Nr.	F	M	R
WNGG 060404 ALU LT 05	6	4.76	0.4	T0003299	●	●	●
WNGG 080404 ALU LT 05	8	4.76	0.4	T0003300	●	●	●

ISO standard with extreme and unique positive chipbreaker geometry for aluminium turning operations. Suitable mostly for external operations but good also for internal op-erations, roughing and finishing.

Machining Recommendations

Details on page 14

Application Guide

Finishing: (**F**)
d.o.c. =0.30 - 1.50 mm
fn =0.08 - 0.20 mm/rev

Medium: (**M**)
d.o.c. =0.70 - 4.50 mm
fn =0.15 - 0.45 mm/rev

Roughing: (**R**)
d.o.c. =3.00 - 7.00 mm
fn =0.35 - 0.70 mm/rev

● = Good ● = Acceptable ● = Not recommended

WNGG 060404 ALU – **LT 05**

	Material Group	Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm] min	D.O.C [mm] max	Feed [mm/rev] min	Feed [mm/rev] max	Amax [mm²]	V_c [m/min] min	V_c [m/min] max	Suggested Starting Parameters D.O.C	Feed	V_c
NF	Al (<8%Si)	13	21, 22 23, 24	Si < 4 %	60 HB	0.3	4.0	0.12	0.35	1.20	400	1200	**2.3**	**0.23**	**400**
				4% < Si < 8 %	100 HB	0.3	4.0	0.10	0.30	0.96	250	600	**2.3**	**0.23**	**300**
	Copper Alloys	14	26,27,28	CuZn30	100 HB	0.3	4.0	0.10	0.30	0.96	150	800	**2.3**	**0.23**	**250**
	Non-Metallic	15	29	Fiber Plastics	-	0.3	4.0	0.10	0.20	0.96	70	500	**1.8**	**0.15**	**150**
			30	Hard Rubber	-	0.3	4.0	0.10	0.20	0.96	80	300	**1.8**	**0.15**	**150**
			-	Graphite	-	0.3	4.0	0.10	0.20	0.96	100	200	**1.8**	**0.15**	**150**
H.T.A	Ti Based Alloys	10	36	Ti 1	-	0.3	2.0	0.09	0.16	0.22	35	60	**1.4**	**0.13**	**45**
			37	TiAl 6 V4	-	0.3	2.0	0.12	0.20	0.19	28	40	**1.4**	**0.12**	**35**

WNGG 080404 ALU – **LT 05**

	Material Group	Gr. N°	VDI Group	Material Exemples	Hardness	D.O.C [mm] min	D.O.C [mm] max	Feed [mm/rev] min	Feed [mm/rev] max	Amax [mm²]	V_c [m/min] min	V_c [m/min] max	Suggested Starting Parameters D.O.C	Feed	V_c
NF	Al (<8%Si)	13	21, 22 23, 24	Si < 4 %	60 HB	0.3	4.0	0.12	0.35	1.20	400	1200	**2.3**	**0.23**	**400**
				4% < Si < 8 %	100 HB	0.3	4.0	0.10	0.30	0.96	250	600	**2.3**	**0.23**	**300**
	Copper Alloys	14	26,27,28	CuZn30	100 HB	0.3	4.0	0.10	0.30	0.96	150	800	**2.3**	**0.23**	**250**
	Non-Metallic	15	29	Fiber Plastics	-	0.3	4.0	0.10	0.20	0.96	70	500	**1.8**	**0.15**	**150**
			30	Hard Rubber	-	0.3	4.0	0.10	0.20	0.96	80	300	**1.8**	**0.15**	**150**
			-	Graphite	-	0.3	4.0	0.10	0.20	0.96	100	200	**1.8**	**0.15**	**150**
H.T.A	Ti Based Alloys	10	36	Ti 1	-	0.3	2.0	0.09	0.16	0.22	35	60	**1.4**	**0.13**	**45**
			37	TiAl 6 V4	-	0.3	2.0	0.12	0.20	0.19	28	40	**1.4**	**0.12**	**35**