




MACHINING CONDITIONS

APGT 160408 PDER-ALU
LT 05

M0001010

Material Group		Material Example	Hardness	D.O.C		Feed		Vc		Advised D.O.C [mm]	Advised Feed [mm/t]	Advised Vc [m/min]	
				min[mm]	max[mm]	min[mm/t]	max [mm/t]	min [m/min]	max [m/min]				
NiTi Alloy	Ti Based	10	T40	-	0.5	15	0.1	0.24	30	50	4	0.14	35
			TiAl6V4	-	0.5	15	0.1	0.32	40	60	4	0.14	45
Aluminium	Al (<8%Si)	13	4% < Si < 8%	100 HB	0.5	15	0.13	0.29	250	600	4	0.16	400
			Si < 4%	60 HB	0.5	15	0.15	0.32	400	1200	4	0.16	500
	Copper Alloys	14	CuZn30	100 HB	0.5	15	0.13	0.29	100	800	4	0.16	300
	Non-Metallic	15	Fiber Plastics	-	0.5	15	0.15	0.32	80	500	4	0.16	200
			Graphite	-	0.5	15	0.15	0.32	100	200	4	0.16	150
Hard Rubber			-	0.5	15	0.15	0.32	80	300	4	0.16	150	