



# MACHINING CONDITIONS

## SEGT 1204 AFEN-ALU LT 05

M0001008

Material Group	SAPPHIRE CUTTING TOOLS 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	-	0.3	5	0.08	0.28	30	50	2	0.2	35
			TiAl6V4	-	0.3	5	0.08	0.35	40	60	2	0.2	45
Aluminium	Al (<8%Si)	13	4% < Si < 8%	100 HB	0.3	9	0.1	0.35	250	600	3	0.25	400
			Si < 4%	60 HB	0.3	9	0.12	0.35	400	1200	3	0.25	500
	Copper Alloys	14	CuZn30	100 HB	0.3	9	0.1	0.35	100	800	3	0.25	300
	Non-Metallic	15	Fiber Plastics	-	0.3	9	0.12	0.35	80	500	3	0.2	200
			Graphite	-	0.3	9	0.12	0.35	100	200	3	0.2	150
Hard Rubber			-	0.3	9	0.12	0.35	80	300	3	0.2	150	