




MACHINING CONDITIONS

DCGT 11T304 NS LT 05

T0004775

Material Group		Material Example	Hardness	D.O.C		Feed		Amax [mm ²]	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]				
Aluminium	Al (<8%Si)	13	4% < Si < 8%	100 HB	0.3	4.5	0.1	0.3	1.2	250	600	2.3	0.23	300
			Si < 4%	60 HB	0.3	4.5	0.12	0.35	1.5	400	1200	2.3	0.23	400
	Copper Alloys	14	CuZn30	100 HB	0.3	4.5	0.1	0.3	1.2	150	800	2.3	0.23	250
	Non-Metallic	15	Fiber Plastics	-	0.3	4.5	0.1	0.2	1.2	70	500	1.8	0.15	150
			Graphite	-	0.3	4.5	0.1	0.2	1.2	100	200	1.8	0.15	150
			Hard Rubber	-	0.3	4.5	0.1	0.2	1.2	80	300	1.8	0.15	150