

# MACHINING CONDITIONS - ALU TURNING & MILLING - CUTTING SPEED (Vc)

## LT 05 — NON FERROUS

Material Group	Lamina Gr. N°	Material Examples	Hardness	LT 05 ALU- Turning Vc [m/min]			LT 05 ALU - Milling Vc [m/min]		
				min	max	sugg. start speed	min	max	sugg. start speed
NF	13	4% < Si < 8%	100 HB	250	600	300	250	600	400
		Si < 4%	60 HB	400	1200	400	400	1200	500
	14	CuZn30	100HB	150	800	250	100	800	300
	15	Fiber Plastics	-	70	500	150	80	500	200
		Graphite	-	100	200	150	100	200	150
		Hard Rubber	-	80	300	150	80	300	150