

MACHINING CONDITIONS - ALU TURNING - DEPTH OF CUT AND FEED

CCGT 060204 ALU

Material Group	Lamina Gr. N°	Material Examples	Hardness	DOC [mm]		Feed [mm/rev]		Amax [mm ²]	Suggested Starting Parameters	
				min	max	min	max		DOC	Feed
AL (<8%Si)	13	4% < Si < 8%	100 HB	0.30	2.50	0.10	0.29	1.02	1.50	0.23
		Si < 4%	60 HB			0.12	0.33	1.28		
	Copper Alloys	14	CuZn30	100HB	0.30	2.50	0.10	0.29	1.02	1.50
Non Metallic	15	Fiber Plastics	-	0.30	2.50	0.10	0.19	1.02	1.20	0.15
		Graphite	-							
		Hard Rubber	-							

CCGT 09T304 ALU CNGG 09T304 ALU CNGG 120404 ALU

DCGT 11T304 ALU DNGG 110404 ALU TNGG 160404 ALU

VNGG 160404 ALU WNGG 060404 ALU WNGG 080404 ALU

Material Group	Lamina Gr. N°	Material Examples	Hardness	DOC [mm]		Feed [mm/rev]		Amax [mm ²]	Suggested Starting Parameters	
				min	max	min	max		DOC	Feed
AL (<8%Si)	13	4% < Si < 8%	100 HB	0.30	4.50	0.10	0.30	1.20	2.30	0.23
		Si < 4%	60 HB			0.12	0.35	1.50		
Copper Alloys	14	CuZn30	100HB	0.30	4.50	0.10	0.30	1.20	2.30	0.23
Non Metallic	15	Fiber Plastics	-	0.30	4.50	0.10	0.20	1.20	1.80	0.15
		Graphite	-							
		Hard Rubber	-							

CNGG 120408 ALU DNGG 110408 ALU

DNGG 150608 ALU VNGG 160408 ALU

Material Group	Lamina Gr. N°	Material Examples	Hardness	DOC [mm]		Feed [mm/rev]		Amax [mm ²]	Suggested Starting Parameters	
				min	max	min	max		DOC	Feed
AL (<8%Si)	13	4% < Si < 8%	100 HB	0.50	6.00	0.18	0.50	1.20	3.00	0.32
		Si < 4%	60 HB				0.60	1.50		
Copper Alloys	14	CuZn30	100HB	0.50	6.00	0.15	0.40	1.20	3.00	0.25
Non Metallic	15	Fiber Plastics	-	0.50	6.00	0.15	0.40	1.20	3.00	0.25
		Graphite	-							
		Hard Rubber	-							