

MACHINING CONDITIONS - ALU MILLING - DEPTH OF CUT AND FEED

APGT 100304 PDER ALU

Material Group	Lamina Gr. N°	Material Examples	Hardness	DOC [mm]		Feed [mm/rev]		Suggested Starting Parameters	
				min	max	min	max	DOC	Feed
AL (<8%Si)	13	4% < Si < 8%	100 HB	0.30	9.00	0.10	0.18	3.00	0.14
		Si < 4%	60 HB			0.12	0.20		
	Copper Alloys	14	CuZn30	100HB	0.30	9.00	0.10	0.18	3.00
Non Metallic	15	Fiber Plastics	-	0.30	9.00	0.12	0.20	3.00	0.12
		Graphite	-						
		Hard Rubber	-						

APGT 160408 PDER ALU

Material Group	Lamina Gr. N°	Material Examples	Hardness	DOC [mm]		Feed [mm/rev]		Suggested Starting Parameters	
				min	max	min	max	DOC	Feed
AL (<8%Si)	13	4% < Si < 8%	100 HB	0.50	15.00	0.13	0.29	4.00	0.16
		Si < 4%	60 HB			0.15	0.32		
Copper Alloys	14	CuZn30	100HB	0.50	15.00	0.13	0.29	4.00	0.16
Non Metallic	15	Fiber Plastics	-	0.50	15.00	0.15	0.32	4.00	0.16
		Graphite	-						
		Hard Rubber	-						

SEGT 1204 AFEN ALU

Material Group	Gr. N°	Material Examples	Hardness	DOC [mm]		Feed [mm/rev]		Suggested Starting Parameters	
				min	max	min	max	DOC	Feed
AL (<8%Si)	13	4% < Si < 8%	100 HB	0.30	9.00	0.10	0.35	3.00	0.25
		Si < 4%	60 HB			0.12			
Copper Alloys	14	CuZn30	100HB	0.30	9.00	0.10	0.35	3.00	0.25
Non Metallic	15	Fiber Plastics	-	0.30	9.00	0.12	0.35	3.00	0.20
		Graphite	-						
		Hard Rubber	-						