

CNGG 431 & 432 ALU LT 05

Speeds & Feeds

CNGG 431 ALU LT 05

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/rev]		Amax	V _c [sfm]		Suggested Starting Parameters				
					min	max	min	max		min	max	D.O.C.	Feed	V _c		
NF	Al (<8%Si)	13	21, 22	Si < 4 %	60 HB	0.010	0.197	0.005	0.014	0.0023	1320	3960	0.098	0.009	1320	
			23, 24	4% < Si < 8 %	100 HB		0.197				0.004				0.012	0.0019
	Cooper Alloys	14	26,27,28	CuZn30	100 HB	0.010	0.197	0.004	0.012	0.0019	495	2640	0.098	0.009	825	
NF	Non-Metallic	15	29	Fiber Plastics	-	0.010	0.197	0.004	0.008	0.0019	231	1650	0.079	0.006	495	
			30	Hard Rubber	-		0.197				0.008	264				990
			-	Graphite	-		0.197				0.008	330				660
H.T.A.	Ti based Alloys	10	36	Ti 1	-	0.010	0.079	0.004	0.006	0.0004	115.5	198	0.059	0.005	148.5	
			37	TiAl 6 V4	-		0.079				0.005	0.008			0.0004	92.4

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Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/rev]		Amax	V _c [sfm]		Suggested Starting Parameters				
					min	max	min	max		min	max	D.O.C.	Feed	V _c		
NF	Al (<8%Si)	13	21, 22	Si < 4 %	60 HB	0.010	0.197	0.007	0.024	0.0023	1320	3960	0.118	0.013	1320	
			23, 24	4% < Si < 8 %	100 HB		0.197				0.020				0.0019	825
	Cooper Alloys	14	26,27,28	CuZn30	100 HB	0.010	0.197	0.006	0.016	0.0019	495	2640	0.118	0.010	825	
NF	Non-Metallic	15	29	Fiber Plastics	-	0.010	0.197	0.006	0.016	0.0019	231	1650	0.118	0.010	495	
			30	Hard Rubber	-		0.197				0.016	264				990
			-	Graphite	-		0.197				0.016	330				660
H.T.A.	Ti based Alloys	10	36	Ti 1	-	0.010	0.157	0.006	0.011	0.0004	115.5	198	0.098	0.008	148.5	
			37	TiAl 6 V4	-		0.157				0.010	92.4			132	0.007



(800) 597-3921 or (317) 803-8000 for Application Support.
For additional suggested Speeds & Feeds: <http://delivr.com/1kmpm>

