

DNGG 331 & 332 ALU LT 05

Speeds & Feeds

DNGG 331 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 %	0.010	0.157	0.005	0.014	0.0023	1320	3960	0.098	0.009	1320
			23, 24	4% < Si < 8 %		0.157		0.012		825	1980			990
	Cooper Alloys	14	26,27,28	CuZn30	0.010	0.157	0.004	0.012	0.0019	495	2640	0.098	0.009	825
	Non-Metallic	15	29	Fiber Plastics	0.010	0.157	0.004	0.008	0.0019	231	1650	0.079	0.006	495
			30	Hard Rubber		0.157		0.008		264	990			495
			-	Graphite		0.157		0.008		330	660			495
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		0.008		92.4	132			115.5

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Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [inch]		Feed [inch/rev]		Amax	V _c [sfm]		Optimal cutting conditions		
					min	max	min	max		min	max	D.O.C.	Feed	V _c
NF	Al (<8%Si)	13	21, 22	Si < 4 %	0.010	0.157	0.007	0.024	0.0023	1320	3960	0.079	0.010	1320
			23, 24	4% < Si < 8 %		0.157		0.020		825	1980			990
	Cooper Alloys	14	26,27,28	CuZn30	0.010	0.157	0.006	0.016	0.0019	495	2640	0.079	0.010	825
	Non-Metallic	15	29	Fiber Plastics	0.010	0.157	0.006	0.016	0.0019	231	1650	0.079	0.010	495
			30	Hard Rubber		0.157		0.016		264	990			495
			-	Graphite		0.157		0.016		330	660			495
H.T.A.	Ti based Alloys	10	36	Ti 1	0.010	0.118	0.006	0.011	0.0004	115.5	198	0.079	0.008	148.5
			37	TiAl 6 V4		0.118		0.010		92.4	132			115.5



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

