VNGG 331 & 332 ALU LT 05

Speeds & Feeds

VNGG 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 23, 24	Si < 4 %	60 HB	0.010	0.157	0.005	0.012	0.0023	1320	3960	0.098	0.009	1320
				4% < Si < 8 %	100 HB		0.157	0.004	0.010	0.0019	825	1980			990
	Cooper Alloys	14	26,27,28	CuZn30	100 HB	0.010	0.157	0.004	0.010	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	0.0019	264	990			
			-	Graphite	-		0.157		0.008	0.0019	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	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]		Suggested Starting Parameters		
						min	max	min	max		min	max	D.O.C.	Feed	V_c
NF	Al (<8%Si)	13	21, 22 23, 24	Si < 4 %	60 HB	0.010	0.236	0.007	0.024	0.0023	1320	3960	0.118	0.010	1320
				4% < Si < 8 %	100 HB		0.236		0.020	0.0019	825	1980			990
	Cooper Alloys	14	26,27,28	CuZn30	100 HB	0.010	0.236	0.006	0.016	0.0019	495	2640	0.118	0.010	825
	Non-Metallic	15	29	Fiber Plastics	-	0.010	0.236	0.006	0.016	0.0019	231	1650	0.118	0.010	495
			30	Hard Rubber	-		0.236		0.016	0.0019	264	990			
			-	Graphite	-		0.236		0.016	0.0019	330	660			
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	0.0004	92.4	132		0.007	115.5