

Aluminium	Group No	Material Examples*	Brinell hardness	d.o.c [mm]		feed [mm/tooth]		V _c [m/min]	
				min	max	min	max	min	max
Si < 4%	13	AlMgSi 1	----	0.3	7.0	0.15	0.40	400	1200
4% < Si < 8%	13	AlSi 6 Cu 4	----			0.12	0.35	250	600
Si > 8%	14	AlSi 12	----	Recommended to use SEKT 1204 AFTN - LT-30					

For high Si Aluminium, it is recommended to use SEKT 1204 AFTN. See cutting conditions below.

Si > 8%	14	AlSi 12	----	0.5	7.0	0.20	0.45	200	400
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