

Aluminium	Group No	Material Examples*	Brinell hardness HB	d.o.c [mm]		feed [mm/rev]		A max [mm <sup>2</sup> ]	V <sub>c</sub> [m/min]		Optimal cutting conditions	
				min	max	min	max		min	max	d.o.c	feed
Si < 4%	13	AlMgSi 1	----	0.25	5.0	0.12	0.35	1.5	400	1200	0.5 to 3	0.23
4% < Si < 8%	13	AlSi 6 Cu 4	----			0.10	0.30		1.2	250		
Si > 8%	14	AlSi 12	----	Recommended to use CNMG 120404 NN - LT-10								

**For high Si Aluminium, it is recommended to use CNMG 120404 NN. See cutting conditions below.**

Si > 8%	14	AlSi 12	----	0.50	5.0	0.10	0.30	0.80	200	400	0.5 to 1.2	0.15
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Insert designation    Super Finishing    Finishing    Semi Finishing    Roughing    Interrupted Cut



# CNGG 120408-ALU

Aluminium	Group No	Material Examples*	Brinell hardness HB	d.o.c [mm]		feed [mm/rev]		A max [mm <sup>2</sup> ]	V <sub>c</sub> [m/min]		Optimal cutting conditions	
				min	max	min	max		min	max	d.o.c	feed
Si < 4%	13	AlMgSi 1	----	0.25	5.0	0.12	0.60	2.0	400	1200	0.5 to 3	0.23
4% < Si < 8%	13	AlSi 6 Cu 4	----			0.10	0.50		1.8	250		
Si > 8%	14	AlSi 12	----	Recommended to use CNMP 120408 NN - LT-10								

**For high Si Aluminium, it is recommended to use CNMP 120408 NN. See cutting conditions below.**

Si > 8%	14	AlSi 12	----	0.50	5.0	0.15	0.50	1.50	200	400	1.0 to 3.0	0.25
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Insert designation    Super Finishing    Finishing    Semi Finishing    Roughing    Interrupted Cut

