

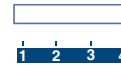
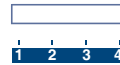
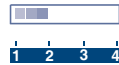
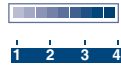
Aluminium	Group No	Material Examples*	Brinell hardness HB	d.o.c [mm]		feed [mm/rev]		A max [mm ²]	V _c [m/min]		Optimal cutting conditions	
				min	max	min	max		min	max	d.o.c	feed
Si < 4%	13	AlMgSi 1	----	0.25	5.0	0.12	0.30	1.5	400	1200	0.5 to 3	0.23
4% < Si < 8%	13	AlSi 6 Cu 4	----			0.10	0.25	1.2	250	600		
Si > 8%	14	AlSi 12	----	Recommended to use LT-10								

For high Si Aluminium, it is recommended to use DNGM 110404 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

DNGG 110404 ALU



DNGG 110408-ALU

Aluminium	Group No	Material Examples*	Brinell hardness HB	d.o.c [mm]		feed [mm/rev]		A max [mm ²]	V _c [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	0.32
4% < Si < 8%	13	AlSi 6 Cu 4	----			0.10	0.45	1.6	250	600		
Si > 8%	14	AlSi 12	----	Recommended to use LT-10								

For high Si Aluminium, it is recommended to use DNGM 110408 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

DNGG 110408 ALU

