

														
	Side Milling							Slotting						
	Side Milling			Fz mm/t				Side Milling			Fz mm/t			
	Vc (m/min)	ap	ae	Ø 1-5	Ø 6-8	Ø 10-12	Ø16-20	Vc (m/min)	ap	ae	Ø 6-8	Ø 10-12	Ø16-20	
Aluminum														
Al <12%Si	500-800	1.5D	0.4xD	0.02-0.07	0.045-0.07	0.07-0.10	0.08-0.15	500-800	1.5D	D	0.040-0.060	0.060-0.10	0.08-0.15	
Al >12%Si	400-450	1.5D	0.4xD	0.02-0.03	0.035-0.06	0.04-0.07	0.06-0.10	400-450	1.5D	D	0.030-0.055	0.030-0.07	0.05-0.10	
Copper Alloyes	350-380	1.5D	0.4xD	0.02-0.04	0.030-0.06	0.03-0.07	0.06-0.10	350-380	1.5D	D	0.025-0.050	0.030-0.07	0.05-0.10	
Non-Metalic	350-500	1.5D	0.4xD	0.02-0.07	0.045-0.07	0.07-0.10	0.08-0.15	350-500	1.5D	D	0.040-0.060	0.060-0.10	0.08-0.15	