

												
	Side Milling						Slotting					
	Side Milling			Fz mm/t			Side Milling			Fz mm/t		
	Vc (m/min)	ap	ae	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	2D	0.4xD	0.045-0.07	0.07-0.10	0.08-0.15	500-800	D	D	0.040-0.060	0.060-0.10	0.08-0.15
Al >12%Si	400-450	2D	0.4xD	0.035-0.06	0.04-0.07	0.06-0.10	400-450	D	D	0.030-0.055	0.030-0.07	0.05-0.10
Copper Alloyes	350-380	2D	0.4xD	0.030-0.06	0.03-0.07	0.06-0.10	350-380	D	D	0.025-0.050	0.030-0.07	0.05-0.10
Non-Metalic	350-500	2D	0.4xD	0.045-0.07	0.07-0.10	0.08-0.15	350-500	D	D	0.040-0.060	0.060-0.10	0.08-0.15