

												
	Side Milling						Slotting					
	Side Milling			Fz mm/t			Side Milling			Fz mm/t		
Aluminum	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
Al <12%Si	500-800	2D	0.4xD	0.03-0.050	0.045-0.055	0.05-0.10	500-800	D	D	0.03-0.050	0.045-0.055	0.05-0.10
Al >12%Si	400-450	2D	0.4xD	0.03-0.045	0.030-0.060	0.05-0.08	400-450	D	D	0.03-0.045	0.030-0.060	0.05-0.08
Copper Alloyes	350-380	2D	0.4xD	0.03-0.045	0.030-0.060	0.05-0.08	350-380	D	D	0.03-0.045	0.030-0.060	0.05-0.08
Non-Metalic	350-500	2D	0.4xD	0.03-0.050	0.045-0.055	0.05-0.10	350-500	D	D	0.03-0.050	0.045-0.055	0.05-0.10