



### Side Milling

### Slotting

#### Side Milling

#### Fz mm/t

#### Side Milling

#### Fz mm/t

	Side Milling					Slotting				
	Vc (m/min)	a <sub>p</sub>	a <sub>e</sub>	Ø 1-3	Ø 4-6	Vc (m/min)	a <sub>p</sub>	a <sub>e</sub>	Ø 1-3	Ø 4-6
<b>Aluminum</b>										
<b>Al &lt; 12%Si</b>	500-800	D	0.4xD	0.03-0.050	0.045-0.055	500-800	D	D	0.015-0.030	0.030-0.060
<b>Al &gt; 12%Si</b>	400-450	D	0.4xD	0.03-0.045	0.030-0.060	400-450	D	D	0.015-0.025	0.025-0.055
<b>Copper Alloys</b>	350-380	D	0.4xD	0.03-0.045	0.030-0.060	350-380	D	D	0.015-0.030	0.030-0.060
<b>Non-Metallic</b>	350-500	D	0.4xD	0.03-0.050	0.045-0.055	350-500	D	D	0.015-0.030	0.045-0.055