

● Recommended Cutting Conditions

Material		HB	SFM	Best grade	Feed(IPT)	
Aluminum wrought alloy		Not cureable	60	900-1600	TH10	.006 -.015
		Cured	100	650-6600	TH10	.004 -.010
Aluminum-cast, alloyed	<=12% Si	Not cureable	75	650-6600	TH10	.006 -.012
		Cured	90	650-6600	TH10	.004 -.010
	>12% Si	High temp.	130	650-3200	TH10	.003 -.006
		Free cutting	110	650-2600	TH10	.003 -.006
Copper alloys	>1% Pb	Brass	90	900-3200	TH10	.004 -.006
		Electrolytic copper	100	900-2600	TH10	.004 -.006
		Duroplastics, fiber plastics	-	300-1600	TH10	.004 -.006
Non-metallic		Hard rubber	-	300-900	TH10	.004 -.006