

# APGT 1003 Alu

## Cutting Conditions

Aluminium	Group No	Material Examples*	Brinell hardness	d.o.c [mm]		feed [mm/tooth]		V <sub>c</sub> [m/min]	
				min	max	min	max	min	max
Si < 4%	13	AlMgSi 1	----	0.3	9.0	0.12	0.20	400	1200
4% < Si < 8%	13	AlSi 6 Cu 4	----			0.10	0.18	250	600
Si > 8%	14	AlSi 12	----	Recommended to use APLX 1003 PDTR - LT-30					

### Cutting conditions for APLX 1003 PDTR for high Si Aluminium

Si > 8%	14	AlSi 12	----	0.5	9.0	0.08	0.20	200	400
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# APGT 1604 Alu

Aluminium	Group No	Material Examples*	Brinell hardness	d.o.c [mm]		feed [mm/tooth]		V <sub>c</sub> [m/min]	
				min	max	min	max	min	max
Si < 4%	13	AlMgSi 1	----	0.5	15.5	0.15	0.32	400	1200
4% < Si < 8%	13	AlSi 6 Cu 4	----			0.12	0.25	250	600
Si > 8%	14	AlSi 12	----	Recommended to use APKT 1604 PDTR - LT-30					

### Cutting conditions for APKT 1604 PDTR for high Si Aluminium

Si > 8%	14	AlSi 12	----	0.5	16.0	0.15	0.25	200	400
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\*For all material types and standards, see pages 240 to 245.



Alu-Line