



OPERATING GUIDELINES

MATERIAL	Grade	Metric		Inch	
		Vc (m/min)	Fz (mm/z)	Vc (SFM)	Fz (in/tooth)
Aluminum Casting Alloys (Si < 12%)	PCD	300-500	0.05 - 0.18	950 - 1650	.002" - .007"
Aluminum Casting Alloys (Si > 12%)	PCD	300-500	0.04 - 0.14	950 - 1650	.0015" - .0055"
Copper, Bronze, Brass Alloys	PCD	300-500	0.03 - 0.08	950 - 1650	.001" - .003"
Magnesium Alloys	PCD	300-500	0.06 - 0.16	950 - 1650	.0025" - .006"
Graphite	PCD	300-500	0.06 - 0.16	950 - 1650	.0025" - .006"

Note: Feed and speed recommendations are starting operating parameters. They are only guidelines from which further optimization should take place. Operating parameters are influenced by many machining variables. These variables may cause for reductions in feeds and speed or dramatic increases. Additionally, DOC and WOC may need to be revised to optimize the tools performance.