



YG TAP ALU

RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN

TC163 TC963 TC169 TC170	TE953	TC622	TE943	TC433	TE443	TY433
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ISO	VDI 3323	Material Description	HB	HRc	Vc (m/min.)							
P	1	Non-alloy steel	125		15-20		15-20					
	2		190	13	15-20		15-20					
	3		250	25	12-18	12-18	12-18	12-18				
N	21	Aluminum-wrought alloy	60		10-15	10-15	10-15	10-15				
	22		100		10-15	10-15	10-15	10-15				
	23	Aluminum-cast, alloyed	75		15-20	15-20	15-20	15-20				
	24		90		15-20	15-20	15-20	15-20				
	25		130			10-15		10-15				
	26	Copper and Copper Alloys (Bronze / Brass)	110						25-35	25-35	35-40	
	27		90		8-12		8-12		8-12	8-12	12-16	
	28		100						15-20		20-25	