

APGT 1604 Alu

Aluminium	Group No	Material Examples*	Brinell hardness	d.o.c [mm]		feed [mm/tooth]		V _c [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					

**For high Si Aluminium, it is recommended to use APKT 1604 PDTR.
See cutting conditions below.**

Si > 8%	14	AlSi 12	----	0.5	16.0	0.15	0.25	200	400
---------	----	---------	------	-----	------	------	------	-----	-----