

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [mm] Feed [mm/rev]				Amax [mm ²]	V _c [m/min]		Suggested Starting Parameters			
					min	max	min	max		min	max	D.O.C	Feed	V _c	
NF	Al (<8%Si)	13	21, 22 23, 24	Si < 4 %	60 HB	0.3	5.0	0.12	0.35	1.50	400	1200	2.5	0.23	400
				4% < Si < 8 %	100 HB		5.0	0.10	0.30	1.20	250	600			300
	Cooper Alloys	14	26,27,28	CuZn30	100 HB	0.3	5.0	0.10	0.30	1.20	150	800	2.5	0.23	250
NF	Non-Metallic	15	29	Fiber Plastics	-	0.3	5.0	0.10	0.20	1.20	70	500	2.0	0.15	150
			30	Hard Rubber	-		5.0		0.20		80	300			
			-	Graphite	-		5.0		0.20		100	200			
H.T.A.	Ti based Alloys	10	36	Ti 1	-	0.3	2.0	0.09	0.16	0.28	35	60	1.5	0.13	45
			37	TiAl 6 V4	-		2.0	0.12	0.20	0.24	28	40			35

