

## RECOMMENDED CUTTING CONDITIONS

	Work Material	Silicon (%)	Grade	Cutting Speed (m/min)	Feed per Tooth (mm/tooth)
N	Aluminium Alloy	≤10	HTi10	700 (400—1000)	0.15 (0.05—0.25)
		≥10	HTi10	400 (200—600)	0.15 (0.05—0.25)

● Revolution ( $\text{min}^{-1}$ ) =  $(1000 \times \text{Cutting Speed}) \div (3.14 \times \phi D_1)$

● Table Feed (mm/min)

= Feed per Tooth x Number of Teeth x Cutter Revolution