

## Recommended Cutting Conditions

### Wet Cutting

(mm)

Work Material	Properties	Grade	vc (m/min)	Depth of Cut		fz (mm/t.)
				ae	ap	
N           Aluminum Alloys	Si < 5%	MD2030 MD220	2500 (2000–3000)	≤ 0.2 DC	≤ 3.0 (0.5–3.0)	0.08 (0.05–0.2)
				≤ 0.5 DC	≤ 2.5 (0.5–2.5)	
				≤ 0.8 DC	≤ 2.0 (0.5–2.0)	
	5% ≤ Si ≤ 10%	MD2030 MD220	2500 (2000–3000)	≤ 0.2 DC	≤ 3.0 (0.5–3.0)	0.08 (0.05–0.2)
				≤ 0.5 DC	≤ 2.5 (0.5–2.5)	
				≤ 0.8 DC	≤ 2.0 (0.5–2.0)	
	10% < Si < 15%	MD220 MD2030	600 (400–800)	≤ 0.2 DC	≤ 3.0 (0.5–3.0)	0.08 (0.05–0.2)
				≤ 0.5 DC	≤ 2.5 (0.5–2.5)	
				≤ 0.8 DC	≤ 2.0 (0.5–2.0)	
	Si ≥ 15%	MD220 MD2030	600 (400–800)	≤ 0.2 DC	≤ 3.0 (0.5–3.0)	0.08 (0.05–0.2)
				≤ 0.5 DC	≤ 2.5 (0.5–2.5)	
				≤ 0.8 DC	≤ 2.0 (0.5–2.0)	

(Note 1) Please adjust the depth of cut **ap** depending on the width of cut **ae**.

(Note 2) When using the long edge insert, please select the conditions depending on depths of cut (**ap**) excluding the length of the gate.

(Note 3) Wet cutting is recommended.