

List 52902 - PHOENIX® PFDC: Inch
List 78351 - PHOENIX® PFDC: Metric

Work Material		Material Symbol	Inserts					
			CK010, XP4610 (Bright and DLC Insert)			DM010 (MCD Insert)		
			Milling Speed Vc (SFM)	Feed Per Tooth fz (in/t)	Depth of Cut Aa (in)	Milling Speed Vc (SFM)	Feed Per Tooth fz (in/t)	Depth of Cut Aa (in)
N	Aluminum Alloys, Aluminum Alloy Casting (~12% Si) 6061, 7075	6061, 7075	4430 (655 - 8,200)	0.006 (0.002 - 0.01)	0.12	11480 (9840-13120)	.002 (.0004-.004)	0.002
	Aluminum Alloy Casting (13%~ Si) AC4C, ADC	AC4C, ADC	655 (330 - 985)	0.006 (0.002 - 0.01)	0.12	11480 (9840-13120)	.002 (.0004-.004)	0.002
	Copper Alloy	C1100	2300 (1310-3280)	.004 (.002 - .008)	0.08	11480 (9840-13120)	.002 (.0004-.004)	0.0008
	Thermoplastic Resin (XP4610 recommended)	MC Nylon • PVC • POM • PTEE (dry)	8860 (4,920 - 13,120)	0.004 (0.002 - 0.006)	0.08	-	-	-
		PP • 6 Nylon (dry)	12470 (11,480 - 13,120)	0.004 (0.002 - 0.006)	0.08	-	-	-
		Acrylic • Transparent PVC (dry)	5580 (3,280 - 8,200)	0.0012 (0.0008 - 0.002)	0.08	11480 (9840-13120)	.0008 (.0004-.002)	0.0008
		Acrylic • Transparent PVC (wet)	6560 (3,280 - 11,480)	0.0012 (0.0008 - 0.002)	0.08	11480 (6560-13120)	.0008 (.0004-.002)	0.0008
	Thermosetting Resin (XP4610 recommended)	Bakelite (dry)	5250 (1,970 - 7,220)	0.004 (0.002 - 0.006)	0.08	-	-	-