

# Machining Guidelines

ALBROMET – Aluminium bronzes and copper alloys

Because of the alloy structure and their relatively high degree of hardness, often appear significant levels of wear on ALBROMET alloys with a hardness of 250 – 400 HB. Service life and product quality can also be significantly improved by targeted selection of tools. Based on our own experiences and those of our customers, we have identified suitable tools for machining our products.

In general, we recommend carbide grade metals, in the range of P 30 – 40 and K 10 – 30.

During threading, the core hole must be designed 0.15 to 0.25 mm larger than normal.

Grinding wheels made of silicon carbide are suitable for surface- and cylindrical grinding. In order to avoid warpage, the aluminium bronzes can be annealed at around 650°C. It is also a good idea to have a pause of around 48 hours between the initial and final machining. Spark erosion is possible with high-conductivity copper alloys. Setting values are available. For machining, we recommend a basic cutting speed of 50 m/min.

In order to make the procurement of the tools easier, we have focused on one supplier.

## Machining tools

Verfahren	Werkzeug	Artikel-Nr.:
Drilling	VHM-drill (DIN 338)	12 22 50
Drilling	VHM-drill (DIN 338)	12 23 01
Thread Drilling	VHM-drill (DIN 13)	13 20 80
Thread Milling	VHM-shaft mill (DIN 13)	13 96 40
Milling	VHM-mill (DIN 6535)	20 32 40
Rough milling	Inserts SEKR1203AFTN	21 39 25
Finish milling	Inserts SEKN1203AF.N	21 39 09
Turning / roughing	Inserts CNMG 120408 VG	25 03 71
Turning / finishing	Inserts CNMG 120404 Wiper	25 01 03
Turning / universal	Inserts CCMT 09T308	26 00 98

*We recommend using VHM Rotring tools.*

*The cutting data are generally indicated on the packaging.*

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**METALL VERBINDET**