

ISO	Material Group	Workpiece Material	Brinell Hardness HB	Rockwell Hardness HRC	Tensile Strength MPa	Recommended Starting Speeds v_c (ft/min)										
						GNT7120			GN9125							
						f_n (inch/rev)			f_n (inch/rev)							
						.004	.008	.016	.004	.008	.016					
N Non-Ferrous	N1	Wrought Aluminum Ex. 1000, 2017, 2025, 5050, 7050	60-90		<520	6900	5400	3600	6900	5400	3600					
	N2	Low-Silicon Aluminum Alloys (Si < 12.2%) Ex. 2024, 6061, 7075	70-100		<350	1640	985	655	1640	985	655					
	N3	High-Silicon Aluminum Alloys (Si > 12.2%)	60-120		200-320	985	655	400	985	655	400					
	N4	Copper and Copper Alloys Ex. C81500	60-200		200-650	1280	1050	885	1280	1050	885					