

C36000 Free Machining Brass

Machining Guidelines



Machinability = 100

Recently amended and revised to reflect a lower maximum lead percentage; C36000 remains the industry standard for general machining and high volume production. The excellent machinability characteristic of C36000 permits full utilization of a screw machines capability. Use maximum speeds & feeds for finish cuts. Light mineral (paraffin) oil or water soluble oil (20/1) should be used as cutting lubricant & coolant. Sulfurized oils will stain parts and should be avoided

	Speed (sfpm)	Feed (ipr)	Back Rake Angle	Clearance Angle
Lathe Turning Tools:	300 - 1,000	0.002 - 0.015	0 - 5	6
Drills (118°):	300 - 1,000	0.003 - 0.020	0	12 - 15
Milling Cutters:	200 - 500	0.015 - 0.030	0 - 10	10 - 15
Form Tools (1/2°):	300 - 1,000	0.001 - 0.003	0 - 5	7 - 12
Taps:	100 - 200 (lineal)		4-Feb	

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