

# RAKE ANGLE VERSUS MATERIAL CHART

Material	Rake Angle
<b>STEEL</b>	
Steel <70g/mm <sup>2</sup>	12-14°
Steel <70-10Kg/mm <sup>2</sup>	8-10°
Deep Drawn Sheetmetal	15-20°
Stainless Resistant Steel	8-10°
<b>CAST IRON</b>	
Cast Steel	12-14°
SG Cast Iron (Long Shavings)	12-14°
SG Cast Iron (Short Shavings)	6-8°
Malleable Iron	8-10°
Gray Cast Iron	3-6°
<b>LIGHT METAL</b>	
Aluminum (Short Chips)	12-14°
Aluminum (Long Chips)	20-25°
Zinc	12-14°
<b>COPPER &amp; COPPER ALLOYS</b>	
Copper	18-25°
Bronze - Soft	12-14°
Bronze - Hard	5-8°
Brass 58	3-6°
Brass 63	12-14°
Titanium	0-4°
<b>PLASTIC</b>	
Bakelite - Hard	3-6°
PVC, Polystyrene - Soft	20-25°

