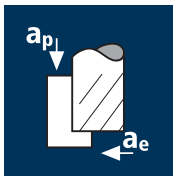


Anwendung

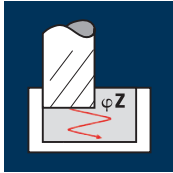


Werkstoff

Al-Knetlegierung
Al-Integralbau



d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	q _Z [°]
6.00	3	500	0.080	9.000	4.800	26525	6365	275.0	20°
8.00	3	500	0.100	12.000	6.400	19895	5970	458.4	20°
10.00	3	500	0.120	15.000	8.000	15915	5730	687.5	20°
12.00	3	500	0.140	18.000	9.600	13265	5570	962.6	20°
16.00	3	500	0.160	24.000	12.800	9945	4775	1466.8	20°
20.00	3	500	0.180	30.000	16.000	7960	4295	2062.6	20°
25.00	3	500	0.200	37.500	20.000	6365	3820	2864.8	20°



Al-Gusslegierung



d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	q _Z [°]
6.00	3	450	0.080	9.000	4.800	23875	5730	247.5	20°
8.00	3	450	0.100	12.000	6.400	17905	5370	412.5	20°
10.00	3	450	0.120	15.000	8.000	14325	5155	618.8	20°
12.00	3	450	0.140	18.000	9.600	11935	5015	866.3	20°
16.00	3	450	0.160	24.000	12.800	8950	4295	1320.1	20°
20.00	3	450	0.180	30.000	16.000	7160	3865	1856.4	20°
25.00	3	450	0.200	37.500	20.000	5730	3440	2578.3	20°

Reinkupfer



d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	q _Z [°]
6.00	3	400	0.072	9.000	4.800	21220	4585	198.0	12°
8.00	3	400	0.090	12.000	6.400	15915	4295	330.0	12°
10.00	3	400	0.108	15.000	8.000	12730	4125	495.0	12°
12.00	3	400	0.126	18.000	9.600	10610	4010	693.0	12°
16.00	3	400	0.144	24.000	12.800	7960	3440	1056.1	12°
20.00	3	400	0.162	30.000	16.000	6365	3095	1485.1	12°
25.00	3	400	0.180	37.500	20.000	5095	2750	2062.6	12°

Anwendung

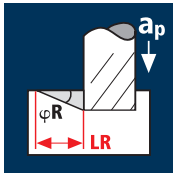


Werkstoff

Al-Knetlegierung
Al-Integralbau



d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	q _R [°]	LR [mm]
6.00	3	450	0.072	9.000	6.000	23875	5155	278.5	25°	19.3
8.00	3	450	0.090	12.000	8.000	17905	4835	464.1	25°	25.7
10.00	3	450	0.108	15.000	10.000	14325	4640	696.1	25°	32.2
12.00	3	450	0.126	18.000	12.000	11935	4510	974.6	25°	38.6
16.00	3	450	0.144	24.000	16.000	8950	3865	1485.1	25°	51.5
20.00	3	450	0.162	30.000	20.000	7160	3480	2088.4	25°	64.3
25.00	3	450	0.180	37.500	25.000	5730	3095	2900.6	25°	80.4



Al-Gusslegierung



d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	q _R [°]	LR [mm]
6.00	3	405	0.072	9.000	6.000	21485	4640	250.6	25°	19.3
8.00	3	405	0.090	12.000	8.000	16115	4350	417.7	25°	25.7
10.00	3	405	0.108	15.000	10.000	12890	4175	626.5	25°	32.2
12.00	3	405	0.126	18.000	12.000	10745	4060	877.1	25°	38.6
16.00	3	405	0.144	24.000	16.000	8055	3480	1336.6	25°	51.5
20.00	3	405	0.162	30.000	20.000	6445	3135	1879.6	25°	64.3
25.00	3	405	0.180	37.500	25.000	5155	2785	2610.5	25°	80.4

Reinkupfer



d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	q _R [°]	LR [mm]
6.00	3	320	0.058	9.000	6.000	16975	2935	158.4	15°	33.6
8.00	3	320	0.072	12.000	8.000	12730	2750	264.0	15°	44.8
10.00	3	320	0.086	15.000	10.000	10185	2640	396.0	15°	56.0
12.00	3	320	0.101	18.000	12.000	8490	2565	554.4	15°	67.2
16.00	3	320	0.115	24.000	16.000	6365	2200	844.9	15°	89.6
20.00	3	320	0.130	30.000	20.000	5095	1980	1188.1	15°	112.0
25.00	3	320	0.144	37.500	25.000	4075	1760	1650.1	15°	140.0



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