

Anwendung

Werkstoff

Al-Knetlegierung
Si < 6%

d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]
6	2	650	0.065	9.0	3.3	34485	4485	133.0
8	2	650	0.090	12.0	4.4	25865	4655	246.0
10	2	650	0.110	15.0	5.5	20690	4550	375.5
12	2	650	0.120	18.0	6.6	17240	4140	492.0
16	2	650	0.135	24.0	8.8	12930	3490	737.0
20	2	650	0.155	30.0	11.0	10345	3205	1057.5

Reinkupfer

6	2	500	0.050	9.0	3.3	26525	2655	79.0
8	2	500	0.070	12.0	4.4	19895	2785	147.0
10	2	500	0.090	15.0	5.5	15915	2865	236.5
12	2	500	0.095	18.0	6.6	13265	2520	299.5
16	2	500	0.105	24.0	8.8	9945	2090	441.5
20	2	500	0.125	30.0	11.0	7960	1990	656.5

Thermoplaste

6	2	1200	0.065	9.0	3.3	60000	7800	231.5
8	2	1200	0.090	12.0	4.4	47750	8595	454.0
10	2	1200	0.110	15.0	5.5	38200	8405	693.5
12	2	1200	0.120	18.0	6.6	31830	7640	907.5
16	2	1200	0.135	24.0	8.8	23875	6445	1361.0
20	2	1200	0.155	30.0	11.0	19100	5920	1953.5

Aluminiumguss
Si 6% - 15%

6	2	450	0.045	9.0	3.3	23875	2150	64.0
8	2	450	0.060	12.0	4.4	17905	2150	113.5
10	2	450	0.075	15.0	5.5	14325	2150	177.5
12	2	450	0.085	18.0	6.6	11935	2030	241.0
16	2	450	0.095	24.0	8.8	8955	1700	359.0
20	2	450	0.110	30.0	11.0	7160	1575	520.0

Anwendung

Werkstoff

Al-Knetlegierung
Si < 6%

d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]
6	2	550	0.045	5.4	6	29180	2625	85.0
8	2	550	0.060	7.2	8	21885	2625	151.0
10	2	550	0.075	9.0	10	17510	2625	236.5
12	2	550	0.085	10.8	12	14590	2480	321.5
16	2	550	0.095	14.4	16	10940	2080	479.0
20	2	550	0.110	18.0	20	8755	1925	693.0

Reinkupfer

6	2	450	0.040	5.4	6	23875	1910	62.0
8	2	450	0.050	7.2	8	17905	1790	103.0
10	2	450	0.060	9.0	10	14325	1720	155.0
12	2	450	0.070	10.8	12	11935	1670	216.5
16	2	450	0.075	14.4	16	8955	1345	310.0
20	2	450	0.090	18.0	20	7160	1290	464.5

Thermoplaste

6	2	1000	0.045	5.4	6	53055	4775	154.5
8	2	1000	0.060	7.2	8	39790	4775	275.0
10	2	1000	0.075	9.0	10	31830	4775	430.0
12	2	1000	0.085	10.8	12	26525	4510	584.5
16	2	1000	0.095	14.4	16	19895	3780	871.0
20	2	1000	0.110	18.0	20	15915	3500	1260.0

Aluminiumguss
Si 6% - 15%

6	2	400	0.035	5.4	6	21220	1485	48.0
8	2	400	0.040	7.2	8	15915	1275	73.5
10	2	400	0.055	9.0	10	12735	1400	126.0
12	2	400	0.060	10.8	12	10610	1275	165.0
16	2	400	0.065	14.4	16	7960	1035	238.5
20	2	400	0.075	18.0	20	6365	955	344.0