

Werkstoff

Werkzeugstahl gehärtet
52 - 56 HRC

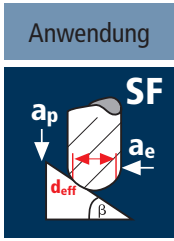
d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	d _{eff} [mm]	n [min ⁻¹]	v _f [mm/min]	β [°]
4	2	700	0.020	0.014	0.022	2.40	60000	2400	30°
5	2	700	0.025	0.016	0.024	2.97	60000	3000	30°
6	2	700	0.030	0.018	0.026	3.55	60000	3600	30°
8	2	700	0.040	0.020	0.030	4.67	47715	3815	30°
10	2	700	0.040	0.022	0.034	5.79	38485	3080	30°
12	2	700	0.050	0.026	0.038	6.94	32105	3210	30°

Werkzeugstahl gehärtet
56 - 60 HRC

4	2	650	0.020	0.014	0.022	2.40	60000	2400	30°
5	2	650	0.025	0.016	0.024	2.97	60000	3000	30°
6	2	650	0.025	0.018	0.026	3.55	58285	2915	30°
8	2	650	0.035	0.020	0.030	4.67	44305	3100	30°
10	2	650	0.035	0.022	0.034	5.79	35735	2500	30°
12	2	650	0.045	0.026	0.038	6.94	29815	2685	30°

Werkzeugstahl gehärtet
> 60 HRC

4	2	600	0.015	0.014	0.022	2.40	60000	1800	30°
5	2	600	0.020	0.016	0.024	2.97	60000	2400	30°
6	2	600	0.025	0.018	0.026	3.55	53800	2690	30°
8	2	600	0.030	0.020	0.030	4.67	40900	2455	30°
10	2	600	0.030	0.022	0.034	5.79	32985	1980	30°
12	2	600	0.040	0.026	0.038	6.94	27520	2200	30°



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d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	d _{eff} [mm]	n [min ⁻¹]	v _f [mm/min]	β [°]
4	2	700	0.020	0.022	0.014	3.72	59900	2395	60°
5	2	700	0.025	0.024	0.016	4.63	48125	2405	60°
6	2	700	0.030	0.026	0.018	5.55	40150	2410	60°
8	2	700	0.040	0.030	0.020	7.37	30235	2420	60°
10	2	700	0.040	0.034	0.022	9.18	24275	1940	60°
12	2	700	0.050	0.038	0.026	11.00	20255	2025	60°

Werkzeugstahl gehärtet
56 - 60 HRC

4	2	650	0.020	0.022	0.014	3.72	55620	2225	60°
5	2	650	0.025	0.024	0.016	4.63	44690	2235	60°
6	2	650	0.025	0.026	0.018	5.55	37280	1865	60°
8	2	650	0.035	0.030	0.020	7.37	28075	1965	60°
10	2	650	0.035	0.034	0.022	9.18	22540	1580	60°
12	2	650	0.045	0.038	0.026	11.00	18810	1695	60°

Werkzeugstahl gehärtet
> 60 HRC

4	2	600	0.015	0.022	0.014	3.72	51340	1540	60°
5	2	600	0.020	0.024	0.016	4.63	41250	1650	60°
6	2	600	0.025	0.026	0.018	5.55	34415	1720	60°
8	2	600	0.030	0.030	0.020	7.37	25915	1555	60°
10	2	600	0.030	0.034	0.022	9.18	20805	1250	60°
12	2	600	0.040	0.038	0.026	11.00	17365	1390	60°