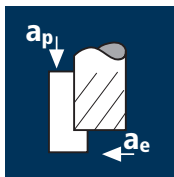


Anwendung



Werkstoff

Stahl
< 850 N/mm²

Stahl
850 - 1100 N/mm²

Gold

Nichtrostender Stahl
[Cr-Ni/1.4301]

| d1 [mm] | z | v _c [m/min] | f _z [mm] | a _p [mm] | a _e [mm] | n [min ⁻¹] | v _f [mm/min] |
|---------|---|------------------------|---------------------|---------------------|---------------------|------------------------|-------------------------|
| 2 | 3 | 105 | 0.005 | 2 | 0.1 | 16710 | 250 |
| 3 | 3 | 105 | 0.010 | 3 | 0.2 | 11140 | 335 |
| 4 | 3 | 105 | 0.015 | 4 | 0.2 | 8355 | 375 |
| 5 | 3 | 105 | 0.015 | 5 | 0.3 | 6685 | 300 |
| 6 | 3 | 105 | 0.020 | 6 | 0.3 | 5570 | 335 |
| 7 | 3 | 105 | 0.025 | 7 | 0.4 | 4775 | 360 |
| 8 | 3 | 105 | 0.025 | 8 | 0.4 | 4180 | 315 |
| 9 | 3 | 105 | 0.030 | 9 | 0.5 | 3715 | 335 |
| 10 | 3 | 105 | 0.035 | 10 | 0.5 | 3340 | 350 |

| | | | | | | | |
|----|---|----|-------|----|-----|-------|-----|
| 2 | 3 | 65 | 0.005 | 2 | 0.1 | 10345 | 155 |
| 3 | 3 | 65 | 0.010 | 3 | 0.2 | 6895 | 205 |
| 4 | 3 | 65 | 0.015 | 4 | 0.2 | 5175 | 235 |
| 5 | 3 | 65 | 0.015 | 5 | 0.3 | 4140 | 185 |
| 6 | 3 | 65 | 0.020 | 6 | 0.3 | 3450 | 205 |
| 7 | 3 | 65 | 0.025 | 7 | 0.4 | 2955 | 220 |
| 8 | 3 | 65 | 0.025 | 8 | 0.4 | 2585 | 195 |
| 9 | 3 | 65 | 0.030 | 9 | 0.5 | 2300 | 205 |
| 10 | 3 | 65 | 0.035 | 10 | 0.5 | 2070 | 215 |

| | | | | | | | |
|----|---|-----|-------|----|-----|-------|-----|
| 2 | 3 | 160 | 0.005 | 2 | 0.1 | 25465 | 380 |
| 3 | 3 | 160 | 0.010 | 3 | 0.2 | 16975 | 510 |
| 4 | 3 | 160 | 0.015 | 4 | 0.2 | 12735 | 575 |
| 5 | 3 | 160 | 0.015 | 5 | 0.3 | 10185 | 460 |
| 6 | 3 | 160 | 0.020 | 6 | 0.3 | 8490 | 510 |
| 7 | 3 | 160 | 0.025 | 7 | 0.4 | 7275 | 545 |
| 8 | 3 | 160 | 0.025 | 8 | 0.4 | 6365 | 475 |
| 9 | 3 | 160 | 0.030 | 9 | 0.5 | 5660 | 510 |
| 10 | 3 | 160 | 0.035 | 10 | 0.5 | 5095 | 535 |

| | | | | | | | |
|----|---|----|-------|----|-----|-------|-----|
| 2 | 3 | 65 | 0.005 | 2 | 0.1 | 10345 | 155 |
| 3 | 3 | 65 | 0.010 | 3 | 0.2 | 6895 | 205 |
| 4 | 3 | 65 | 0.015 | 4 | 0.2 | 5175 | 235 |
| 5 | 3 | 65 | 0.015 | 5 | 0.3 | 4140 | 185 |
| 6 | 3 | 65 | 0.020 | 6 | 0.3 | 3450 | 205 |
| 7 | 3 | 65 | 0.025 | 7 | 0.4 | 2955 | 220 |
| 8 | 3 | 65 | 0.025 | 8 | 0.4 | 2585 | 195 |
| 9 | 3 | 65 | 0.030 | 9 | 0.5 | 2300 | 205 |
| 10 | 3 | 65 | 0.035 | 10 | 0.5 | 2070 | 215 |

Anwendung



Werkstoff

Stahl
< 850 N/mm²

Stahl
850 - 1100 N/mm²

Gold

Nichtrostender Stahl
[Cr-Ni/1.4301]

| 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] |
|---------|---|------------------------|---------------------|---------------------|---------------------|------------------------|-------------------------|--------------------------|
| 2 | 3 | 75 | 0.005 | 0.8 | 2 | 11935 | 180 | 0.3 |
| 3 | 3 | 75 | 0.010 | 1.2 | 3 | 7960 | 240 | 0.9 |
| 4 | 3 | 75 | 0.010 | 1.6 | 4 | 5970 | 180 | 1.2 |
| 5 | 3 | 75 | 0.015 | 2.0 | 5 | 4775 | 215 | 2.2 |
| 6 | 3 | 75 | 0.015 | 2.4 | 6 | 3980 | 180 | 2.6 |
| 7 | 3 | 75 | 0.020 | 2.8 | 7 | 3410 | 205 | 4.0 |
| 8 | 3 | 75 | 0.020 | 3.2 | 8 | 2985 | 180 | 4.6 |
| 9 | 3 | 75 | 0.025 | 3.6 | 9 | 2655 | 200 | 6.5 |
| 10 | 3 | 75 | 0.030 | 4.0 | 10 | 2385 | 215 | 8.6 |

| | | | | | | | | |
|----|---|----|-------|-----|----|------|-----|-----|
| 2 | 3 | 50 | 0.005 | 0.8 | 2 | 7960 | 120 | 0.2 |
| 3 | 3 | 50 | 0.010 | 1.2 | 3 | 5305 | 160 | 0.6 |
| 4 | 3 | 50 | 0.010 | 1.6 | 4 | 3980 | 120 | 0.8 |
| 5 | 3 | 50 | 0.015 | 2.0 | 5 | 3185 | 145 | 1.5 |
| 6 | 3 | 50 | 0.015 | 2.4 | 6 | 2655 | 120 | 1.7 |
| 7 | 3 | 50 | 0.020 | 2.8 | 7 | 2275 | 135 | 2.6 |
| 8 | 3 | 50 | 0.020 | 3.2 | 8 | 1990 | 120 | 3.1 |
| 9 | 3 | 50 | 0.025 | 3.6 | 9 | 1770 | 135 | 4.4 |
| 10 | 3 | 50 | 0.025 | 4.0 | 10 | 1590 | 120 | 4.8 |

| | | | | | | | | |
|----|---|-----|-------|-----|----|-------|-----|------|
| 2 | 3 | 140 | 0.005 | 0.8 | 2 | 22280 | 335 | 0.5 |
| 3 | 3 | 140 | 0.010 | 1.2 | 3 | 14855 | 445 | 1.6 |
| 4 | 3 | 140 | 0.010 | 1.6 | 4 | 11140 | 335 | 2.1 |
| 5 | 3 | 140 | 0.015 | 2.0 | 5 | 8915 | 400 | 4.0 |
| 6 | 3 | 140 | 0.020 | 2.4 | 6 | 7425 | 445 | 6.4 |
| 7 | 3 | 140 | 0.020 | 2.8 | 7 | 6365 | 380 | 7.4 |
| 8 | 3 | 140 | 0.025 | 3.2 | 8 | 5570 | 420 | 10.8 |
| 9 | 3 | 140 | 0.030 | 3.6 | 9 | 4950 | 445 | 14.4 |
| 10 | 3 | 140 | 0.030 | 4.0 | 10 | 4455 | 400 | 16.0 |

| | | | | | | | | |
|----|---|----|-------|-----|----|------|-----|-----|
| 2 | 3 | 50 | 0.005 | 0.8 | 2 | 7960 | 120 | 0.2 |
| 3 | 3 | 50 | 0.010 | 1.2 | 3 | 5305 | 160 | 0.6 |
| 4 | 3 | 50 | 0.010 | 1.6 | 4 | 3980 | 120 | 0.8 |
| 5 | 3 | 50 | 0.015 | 2.0 | 5 | 3185 | 145 | 1.5 |
| 6 | 3 | 50 | 0.015 | 2.4 | 6 | 2655 | 120 | 1.7 |
| 7 | 3 | 50 | 0.020 | 2.8 | 7 | 2275 | 135 | 2.6 |
| 8 | 3 | 50 | 0.020 | 3.2 | 8 | 1990 | 120 | 3.1 |
| 9 | 3 | 50 | 0.025 | 3.6 | 9 | 1770 | 135 | 4.4 |
| 10 | 3 | 50 | 0.025 | 4.0 | 10 | 1590 | 120 | 4.8 |