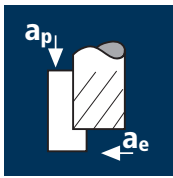


Anwendung



Werkstoff

Stahl
< 850 N/mm²

Stahl
850 - 1100 N/mm²

Gusseisen
GG(G)

Nichtrostender Stahl
[Cr-Ni/1.4301]

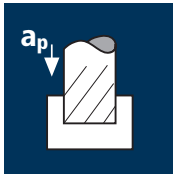
d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]
2	3	105	0.005	5.0	0.1	16710	250
3	3	105	0.010	7.5	0.2	11140	335
4	3	105	0.010	10.0	0.2	8355	250
6	3	105	0.015	15.0	0.3	5570	250
8	3	105	0.020	20.0	0.4	4180	250
10	3	105	0.025	25.0	0.5	3340	250
12	3	105	0.030	30.0	0.6	2785	250
16	3	105	0.040	40.0	0.8	2090	250
20	3	105	0.050	50.0	1.0	1670	250

2	3	75	0.005	5.0	0.1	11935	180
3	3	75	0.010	7.5	0.2	7960	240
4	3	75	0.010	10.0	0.2	5970	180
6	3	75	0.015	15.0	0.3	3980	180
8	3	75	0.020	20.0	0.4	2985	180
10	3	75	0.025	25.0	0.5	2385	180
12	3	75	0.030	30.0	0.6	1990	180
16	3	75	0.040	40.0	0.8	1490	180
20	3	75	0.050	50.0	1.0	1195	180

2	3	150	0.005	5.0	0.1	23875	360
3	3	150	0.010	7.5	0.2	15915	475
4	3	150	0.010	10.0	0.2	11935	360
6	3	150	0.015	15.0	0.3	7960	360
8	3	150	0.020	20.0	0.4	5970	360
10	3	150	0.025	25.0	0.5	4775	360
12	3	150	0.030	30.0	0.6	3980	360
16	3	150	0.040	40.0	0.8	2985	360
20	3	150	0.050	50.0	1.0	2385	360

2	3	50	0.005	5.0	0.1	7960	120
3	3	50	0.010	7.5	0.2	5305	160
4	3	50	0.010	10.0	0.2	3980	120
6	3	50	0.015	15.0	0.3	2655	120
8	3	50	0.020	20.0	0.4	1990	120
10	3	50	0.025	25.0	0.5	1590	120
12	3	50	0.030	30.0	0.6	1325	120
16	3	50	0.040	40.0	0.8	995	120
20	3	50	0.050	50.0	1.0	795	120

Anwendung



Werkstoff

Stahl
< 850 N/mm²

Stahl
850 - 1100 N/mm²

Gusseisen
GG(G)

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	70	0.005	0.4	2	11140	165
3	3	70	0.005	0.6	3	7425	110
4	3	70	0.010	0.8	4	5570	165
6	3	70	0.010	1.2	6	3715	110
8	3	70	0.015	1.6	8	2785	125
10	3	70	0.020	2.0	10	2230	135
12	3	70	0.025	2.4	12	1855	140
16	3	70	0.030	3.2	16	1395	125
20	3	70	0.040	4.0	20	1115	135

2	3	60	0.005	0.4	2	9550	145
3	3	60	0.005	0.6	3	6365	95
4	3	60	0.005	0.8	4	4775	70
6	3	60	0.010	1.2	6	3185	95
8	3	60	0.015	1.6	8	2385	105
10	3	60	0.020	2.0	10	1910	115
12	3	60	0.020	2.4	12	1590	95
16	3	60	0.030	3.2	16	1195	110
20	3	60	0.040	4.0	20	955	115

2	3	105	0.005	0.4	2	16710	250
3	3	105	0.005	0.6	3	11140	165
4	3	105	0.010	0.8	4	8355	250
6	3	105	0.015	1.2	6	5570	250
8	3	105	0.020	1.6	8	4180	250
10	3	105	0.020	2.0	10	3340	200
12	3	105	0.025	2.4	12	2785	210
16	3	105	0.035	3.2	16	2090	220
20	3	105	0.040	4.0	20	1670	200

2	3	35	0.005	0.4	2	5570	85
3	3	35	0.005	0.6	3	3715	55
4	3	35	0.005	0.8	4	2785	40
6	3	35	0.010	1.2	6	1855	55
8	3	35	0.015	1.6	8	1395	65
10	3	35	0.020	2.0	10	1115	65
12	3	35	0.020	2.4	12	930	55
16	3	35	0.030	3.2	16	695	65
20	3	35	0.040	4.0	20	555	65