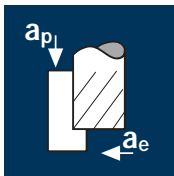


Anwendung

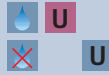


Werkstoff

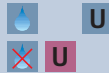
Stahl
< 850 N/mm²



Stahl
850 - 1100 N/mm²



Stahl
1100 - 1300 N/mm²



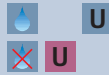
Nichtrostender Stahl
[Cr-Ni/1.4301]



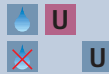
d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]
3	4	170	0.010	4.5	0.3	18040	720
4	4	170	0.015	6.0	0.4	13530	810
5	4	170	0.015	7.5	0.5	10825	650
6	4	170	0.020	9.0	0.6	9020	720
8	4	170	0.025	12.0	0.8	6765	675
10	4	170	0.035	15.0	1.0	5410	755
12	4	170	0.040	18.0	1.2	4510	720
16	4	170	0.055	24.0	1.6	3380	745
20	4	170	0.065	30.0	2.0	2705	705
3	4	110	0.010	4.5	0.3	11670	465
4	4	110	0.015	6.0	0.4	8755	525
5	4	110	0.015	7.5	0.5	7005	420
6	4	110	0.020	9.0	0.6	5835	465
8	4	110	0.025	12.0	0.8	4375	440
10	4	110	0.035	15.0	1.0	3500	490
12	4	110	0.040	18.0	1.2	2920	465
16	4	110	0.055	24.0	1.6	2190	480
20	4	110	0.065	30.0	2.0	1750	455
3	4	80	0.010	4.5	0.3	8490	340
4	4	80	0.015	6.0	0.4	6365	380
5	4	80	0.015	7.5	0.5	5095	305
6	4	80	0.020	9.0	0.6	4245	340
8	4	80	0.025	12.0	0.8	3185	320
10	4	80	0.035	15.0	1.0	2545	355
12	4	80	0.040	18.0	1.2	2120	340
16	4	80	0.055	24.0	1.6	1590	350
20	4	80	0.065	30.0	2.0	1275	330
3	4	70	0.010	4.5	0.3	7425	295
4	4	70	0.015	6.0	0.4	5570	335
5	4	70	0.015	7.5	0.5	4455	265
6	4	70	0.020	9.0	0.6	3715	295
8	4	70	0.025	12.0	0.8	2785	280
10	4	70	0.035	15.0	1.0	2230	310
12	4	70	0.040	18.0	1.2	1855	295
16	4	70	0.055	24.0	1.6	1395	305
20	4	70	0.065	30.0	2.0	1115	290

Werkstoff

Gusseisen
GG(G)



Reinkupfer



Titanlegierungen
bis 300 HB
[Ti5Al2.5Sn]



Hitzebeständiger Stahl
[17-4 PH]



d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]
3	4	130	0.010	4.5	0.3	13795	550
4	4	130	0.015	6.0	0.4	10345	620
5	4	130	0.015	7.5	0.5	8275	495
6	4	130	0.020	9.0	0.6	6895	550
8	4	130	0.025	12.0	0.8	5175	520
10	4	130	0.035	15.0	1.0	4140	580
12	4	130	0.040	18.0	1.2	3450	550
16	4	130	0.055	24.0	1.6	2585	570
20	4	130	0.065	30.0	2.0	2070	540
3	4	230	0.010	4.5	0.3	24405	975
4	4	230	0.015	6.0	0.4	18305	1100
5	4	230	0.015	7.5	0.5	14645	880
6	4	230	0.020	9.0	0.6	12200	975
8	4	230	0.025	12.0	0.8	9150	915
10	4	230	0.035	15.0	1.0	7320	1025
12	4	230	0.040	18.0	1.2	6100	975
16	4	230	0.055	24.0	1.6	4575	1005
20	4	230	0.065	30.0	2.0	3660	950
3	4	80	0.010	4.5	0.3	8490	340
4	4	80	0.015	6.0	0.4	6365	380
5	4	80	0.015	7.5	0.5	5095	305
6	4	80	0.020	9.0	0.6	4245	340
8	4	80	0.025	12.0	0.8	3185	320
10	4	80	0.035	15.0	1.0	2545	355
12	4	80	0.040	18.0	1.2	2120	340
16	4	80	0.055	24.0	1.6	1590	350
20	4	80	0.065	30.0	2.0	1275	330
3	4	40	0.010	4.5	0.3	4245	170
4	4	40	0.015	6.0	0.4	3185	190
5	4	40	0.015	7.5	0.5	2545	155
6	4	40	0.020	9.0	0.6	2120	170
8	4	40	0.025	12.0	0.8	1590	160
10	4	40	0.035	15.0	1.0	1275	180
12	4	40	0.040	18.0	1.2	1060	170
16	4	40	0.055	24.0	1.6	795	175
20	4	40	0.065	30.0	2.0	635	165