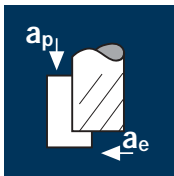


Anwendung

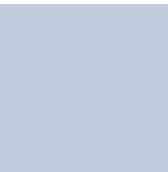


Werkstoff

Stahl
< 850 N/mm²

Stahl
850 - 1100 N/mm²

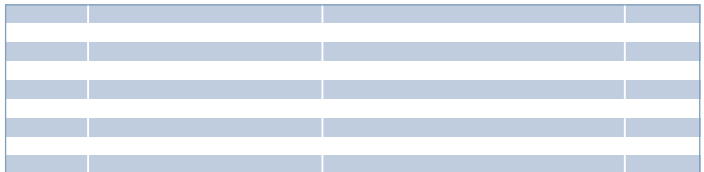
Gusseisen
GG(G)



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	4	120	0.020	9	1.2	6365	510	5.5
8	4	120	0.025	12	1.6	4775	480	9.0
10	4	120	0.035	15	2.0	3820	535	16.0
12	4	120	0.040	18	2.4	3185	510	22.0
16	4	120	0.055	24	3.2	2385	525	40.5
20	4	120	0.065	30	4.0	1910	495	59.5

6	4	80	0.015	9	1.2	4245	255	3.0
8	4	80	0.025	12	1.6	3185	320	6.0
10	4	80	0.030	15	2.0	2545	305	9.0
12	4	80	0.035	18	2.4	2120	295	12.5
16	4	80	0.045	24	3.2	1590	285	22.0
20	4	80	0.055	30	4.0	1275	280	33.5

6	4	160	0.020	9	1.2	8490	680	7.5
8	4	160	0.025	12	1.6	6365	635	12.0
10	4	160	0.035	15	2.0	5095	715	21.5
12	4	160	0.040	18	2.4	4245	680	29.5
16	4	160	0.055	24	3.2	3185	700	54.0
20	4	160	0.065	30	4.0	2545	660	79.0



Anwendung

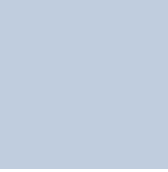


Werkstoff

Stahl
< 850 N/mm²

Stahl
850 - 1100 N/mm²

Gusseisen
GG(G)



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	4	100	0.015	2.4	6	5305	320	4.5
8	4	100	0.025	3.2	8	3980	400	10.0
10	4	100	0.030	4.0	10	3185	380	15.0
12	4	100	0.035	4.8	12	2655	370	21.5
16	4	100	0.045	6.4	16	1990	360	37.0
20	4	100	0.055	8.0	20	1590	350	56.0

6	4	70	0.015	2.4	6	3715	225	3.0
8	4	70	0.020	3.2	8	2785	225	6.0
10	4	70	0.025	4.0	10	2230	225	9.0
12	4	70	0.030	4.8	12	1855	225	13.0
16	4	70	0.040	6.4	16	1395	225	23.0
20	4	70	0.055	8.0	20	1115	245	39.0

6	4	120	0.015	2.4	6	6365	380	5.5
8	4	120	0.025	3.2	8	4775	480	12.5
10	4	120	0.030	4.0	10	3820	460	18.5
12	4	120	0.035	4.8	12	3185	445	25.5
16	4	120	0.045	6.4	16	2385	430	44.0
20	4	120	0.055	8.0	20	1910	420	67.0

