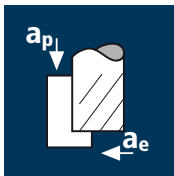


Anwendung



Werkstoff

Stahl
< 850 N/mm²

Stahl
850 - 1100 N/mm²

Stahl
1100 - 1300 N/mm²

Kaltarbeitsstahl
(12% Cr)
hoch legiert
[1.2379]

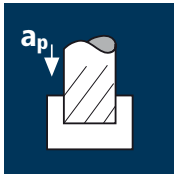
d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]
6	4	180	0.025	9	3.6	9550	955	31.0
8	4	180	0.030	12	4.8	7160	860	49.5
10	4	180	0.050	15	6.0	5730	1145	103.0
12	4	180	0.055	18	7.2	4775	1050	136.0
16	4	180	0.055	24	9.6	3580	790	182.0
16	6	180	0.050	24	9.6	3580	1075	247.5
20	4	180	0.060	30	12.0	2865	690	248.5
20	6	180	0.055	30	12.0	2865	945	340.0

6	4	150	0.025	9	3.6	7960	795	26.0
8	4	150	0.030	12	4.8	5970	715	41.0
10	4	150	0.050	15	6.0	4775	955	86.0
12	4	150	0.055	18	7.2	3980	875	113.5
16	4	150	0.055	24	9.6	2985	655	151.0
16	6	150	0.050	24	9.6	2985	895	206.0
20	4	150	0.060	30	12.0	2385	570	205.0
20	6	150	0.055	30	12.0	2385	785	282.5

6	4	120	0.025	9	3.6	6365	635	20.5
8	4	120	0.030	12	4.8	4775	575	33.0
10	4	120	0.050	15	6.0	3820	765	69.0
12	4	120	0.055	18	7.2	3185	700	90.5
16	4	120	0.055	24	9.6	2385	525	121.0
16	6	120	0.050	24	9.6	2385	715	164.5
20	4	120	0.060	30	12.0	1910	460	165.5
20	6	120	0.055	30	12.0	1910	630	227.0

6	4	80	0.025	9	3.6	4245	425	14.0
8	4	80	0.030	12	4.8	3185	380	22.0
10	4	80	0.050	15	6.0	2545	510	46.0
12	4	80	0.055	18	7.2	2120	465	60.5
16	4	80	0.055	24	9.6	1590	350	80.5
16	6	80	0.050	24	9.6	1590	475	109.5
20	4	80	0.060	30	12.0	1275	305	110.0
20	6	80	0.055	30	12.0	1275	420	151.0

Anwendung



Werkstoff

Stahl
< 850 N/mm²

Stahl
850 - 1100 N/mm²

Stahl
1100 - 1300 N/mm²

Kaltarbeitsstahl
(12% Cr)
hoch legiert
[1.2379]

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	150	0.025	9	6	7960	795	43.0
8	4	150	0.030	12	8	5970	715	68.5
10	4	150	0.050	15	10	4775	955	143.5
12	4	150	0.055	18	12	3980	875	189.0
16	4	150	0.055	24	16	2985	655	251.5
20	4	150	0.060	30	20	2385	570	342.0

6	4	100	0.020	9	6	5305	425	23.0
8	4	100	0.025	12	8	3980	400	38.5
10	4	100	0.030	15	10	3185	380	57.0
12	4	100	0.040	18	12	2655	425	92.0
16	4	100	0.050	24	16	1990	400	153.5
20	4	100	0.055	30	20	1590	350	210.0

6	4	80	0.020	9	6	4245	340	18.5
8	4	80	0.025	12	8	3185	320	30.5
10	4	80	0.030	15	10	2545	305	46.0
12	4	80	0.040	18	12	2120	340	73.5
16	4	80	0.050	24	16	1590	320	123.0
20	4	80	0.055	30	20	1275	280	168.0

6	4	60	0.020	9	6	3185	255	14.0
8	4	60	0.025	12	8	2385	240	23.0
10	4	60	0.030	15	10	1910	230	34.5
12	4	60	0.040	18	12	1590	255	55.0
16	4	60	0.050	24	16	1195	240	92.0
20	4	60	0.055	30	20	955	210	126.0