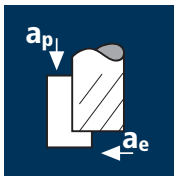


Anwendung



Werkstoff

Al-Knetlegierung
Si < 6%



| 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 | 3 | 600 | 0.065 | 12 | 1.8 | 31830 | 6205 | 134.0 |
| 8 | 3 | 600 | 0.090 | 16 | 2.4 | 23875 | 6445 | 247.5 |
| 10 | 3 | 600 | 0.110 | 20 | 3.0 | 19100 | 6305 | 378.5 |
| 12 | 3 | 600 | 0.135 | 24 | 3.6 | 15915 | 6445 | 557.0 |
| 16 | 3 | 600 | 0.180 | 32 | 4.8 | 11935 | 6445 | 990.0 |
| 20 | 3 | 600 | 0.220 | 40 | 6.0 | 9550 | 6305 | 1513.0 |
| | | | | | | | | |
| | | | | | | | | |

Reinkupfer



| | | | | | | | | |
|----|---|-----|-------|----|-----|-------|------|--------|
| 6 | 3 | 400 | 0.065 | 12 | 1.8 | 21220 | 4140 | 89.5 |
| 8 | 3 | 400 | 0.090 | 16 | 2.4 | 15915 | 4295 | 165.0 |
| 10 | 3 | 400 | 0.110 | 20 | 3.0 | 12735 | 4205 | 252.5 |
| 12 | 3 | 400 | 0.135 | 24 | 3.6 | 10610 | 4295 | 371.0 |
| 16 | 3 | 400 | 0.180 | 32 | 4.8 | 7960 | 4300 | 660.5 |
| 20 | 3 | 400 | 0.220 | 40 | 6.0 | 6365 | 4200 | 1008.0 |
| | | | | | | | | |
| | | | | | | | | |

Thermoplaste



| | | | | | | | | |
|----|---|-----|-------|----|-----|-------|------|--------|
| 6 | 3 | 800 | 0.065 | 12 | 1.8 | 42445 | 8275 | 178.5 |
| 8 | 3 | 800 | 0.090 | 16 | 2.4 | 31830 | 8595 | 330.0 |
| 10 | 3 | 800 | 0.110 | 20 | 3.0 | 25465 | 8405 | 504.5 |
| 12 | 3 | 800 | 0.135 | 24 | 3.6 | 21220 | 8595 | 742.5 |
| 16 | 3 | 800 | 0.180 | 32 | 4.8 | 15915 | 8595 | 1320.0 |
| 20 | 3 | 800 | 0.220 | 40 | 6.0 | 12735 | 8405 | 2017.0 |
| | | | | | | | | |
| | | | | | | | | |

Anwendung



Werkstoff

Al-Knetlegierung
Si < 6%



| 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 | 3 | 500 | 0.060 | 4.2 | 6 | 26525 | 4775 | 120.5 |
| 8 | 3 | 500 | 0.080 | 5.6 | 8 | 19895 | 4775 | 214.0 |
| 10 | 3 | 500 | 0.100 | 7.0 | 10 | 15915 | 4775 | 334.5 |
| 12 | 3 | 500 | 0.120 | 8.4 | 12 | 13265 | 4775 | 481.5 |
| 16 | 3 | 500 | 0.160 | 11.2 | 16 | 9945 | 4775 | 855.5 |
| 20 | 3 | 500 | 0.200 | 14.0 | 20 | 7960 | 4775 | 1337.0 |
| | | | | | | | | |
| | | | | | | | | |

Reinkupfer



| | | | | | | | | |
|----|---|-----|-------|------|----|-------|------|-------|
| 6 | 3 | 270 | 0.060 | 4.2 | 6 | 14325 | 2580 | 65.0 |
| 8 | 3 | 270 | 0.080 | 5.6 | 8 | 10745 | 2580 | 115.5 |
| 10 | 3 | 270 | 0.100 | 7.0 | 10 | 8595 | 2580 | 180.5 |
| 12 | 3 | 270 | 0.120 | 8.4 | 12 | 7160 | 2580 | 260.0 |
| 16 | 3 | 270 | 0.160 | 11.2 | 16 | 5370 | 2580 | 462.5 |
| 20 | 3 | 270 | 0.200 | 14.0 | 20 | 4295 | 2575 | 721.0 |
| | | | | | | | | |
| | | | | | | | | |

Thermoplaste



| | | | | | | | | |
|----|---|-----|-------|------|----|-------|------|--------|
| 6 | 3 | 800 | 0.060 | 4.2 | 6 | 42445 | 7640 | 192.5 |
| 8 | 3 | 800 | 0.080 | 5.6 | 8 | 31830 | 7640 | 342.5 |
| 10 | 3 | 800 | 0.100 | 7.0 | 10 | 25465 | 7640 | 535.0 |
| 12 | 3 | 800 | 0.120 | 8.4 | 12 | 21220 | 7640 | 770.0 |
| 16 | 3 | 800 | 0.160 | 11.2 | 16 | 15915 | 7640 | 1369.0 |
| 20 | 3 | 800 | 0.200 | 14.0 | 20 | 12735 | 7640 | 2139.0 |
| | | | | | | | | |
| | | | | | | | | |