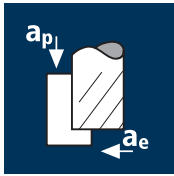


Anwendung



Werkstoff

Stahl
< 850 N/mm²



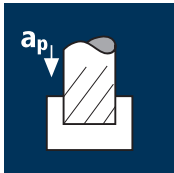
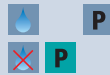
Stahl
850 - 1100 N/mm²



Inox normal
[Cr-Ni/1.4301]
[Cr-Ni-Mo/1.4571]



Gusseisen
GG(G)



Stahl
< 850 N/mm²



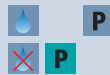
Stahl
850 - 1100 N/mm²



Inox normal
[Cr-Ni/1.4301]
[Cr-Ni-Mo/1.4571]



Gusseisen
GG(G)



d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]
3.00	3	165	0.010	4.500	1.800	17505	525	4.3
4.00	3	165	0.015	6.000	2.400	13130	590	8.5
5.00	3	165	0.015	7.500	3.000	10505	475	10.6
6.00	3	165	0.020	9.000	3.600	8755	525	17.0
8.00	3	165	0.025	12.000	4.800	6565	490	28.4
10.00	3	165	0.030	15.000	6.000	5250	475	42.5
12.00	3	165	0.040	18.000	7.200	4375	525	68.1
16.00	3	165	0.050	24.000	8.400	3285	490	99.3
20.00	3	165	0.065	30.000	10.500	2625	510	161.3
3.00	3	110	0.010	4.500	1.800	11670	350	2.8
4.00	3	110	0.015	6.000	2.400	8755	395	5.7
5.00	3	110	0.015	7.500	3.000	7005	315	7.1
6.00	3	110	0.020	9.000	3.600	5835	350	11.3
8.00	3	110	0.025	12.000	4.800	4375	330	18.9
10.00	3	110	0.030	15.000	6.000	3500	315	28.4
12.00	3	110	0.040	18.000	7.200	2920	350	45.4
16.00	3	110	0.050	24.000	8.400	2190	330	66.2
20.00	3	110	0.065	30.000	10.500	1750	340	107.5
3.00	3	80	0.005	4.500	1.800	8490	125	1.0
4.00	3	80	0.010	6.000	2.400	6365	190	2.8
5.00	3	80	0.010	7.500	3.000	5095	155	3.4
6.00	3	80	0.015	9.000	3.600	4245	190	6.2
8.00	3	80	0.020	12.000	4.800	3185	190	11.0
10.00	3	80	0.025	15.000	6.000	2545	190	17.2
12.00	3	80	0.030	18.000	7.200	2120	190	24.8
16.00	3	80	0.040	24.000	8.400	1590	190	38.5
20.00	3	80	0.045	30.000	10.500	1275	170	54.1
3.00	3	130	0.010	4.500	1.800	13795	415	3.4
4.00	3	130	0.015	6.000	2.400	10345	465	6.7
5.00	3	130	0.015	7.500	3.000	8275	370	8.4
6.00	3	130	0.020	9.000	3.600	6895	415	13.4
8.00	3	130	0.025	12.000	4.800	5175	390	22.3
10.00	3	130	0.030	15.000	6.000	4140	370	33.5
12.00	3	130	0.040	18.000	7.200	3450	415	53.6
16.00	3	130	0.050	24.000	8.400	2585	390	78.2
20.00	3	130	0.065	30.000	10.500	2070	405	127.1
3.00	3	130	0.010	2.000	3.000	13795	415	2.5
4.00	3	130	0.015	3.100	4.000	10345	465	5.8
5.00	3	130	0.015	4.400	5.000	8275	370	8.2
6.00	3	130	0.020	7.800	6.000	6895	415	19.4
8.00	3	130	0.025	10.400	8.000	5175	390	32.3
10.00	3	130	0.025	13.000	10.000	4140	310	40.3
12.00	3	130	0.035	15.600	12.000	3450	360	67.8
16.00	3	130	0.045	17.600	16.000	2585	350	98.3
20.00	3	130	0.060	22.000	20.000	2070	370	163.9
3.00	3	85	0.010	2.000	3.000	9020	270	1.6
4.00	3	85	0.015	3.100	4.000	6765	305	3.8
5.00	3	85	0.015	4.400	5.000	5410	245	5.4
6.00	3	85	0.020	7.800	6.000	4510	270	12.7
8.00	3	85	0.025	10.400	8.000	3380	255	21.1
10.00	3	85	0.025	13.000	10.000	2705	205	26.4
12.00	3	85	0.035	15.600	12.000	2255	235	44.3
16.00	3	85	0.045	17.600	16.000	1690	230	64.3
20.00	3	85	0.060	22.000	20.000	1355	245	107.1
3.00	3	65	0.005	2.000	3.000	6895	105	0.6
4.00	3	65	0.010	3.100	4.000	5175	155	1.9
5.00	3	65	0.010	4.400	5.000	4140	125	2.7
6.00	3	65	0.015	7.800	6.000	3450	155	7.3
8.00	3	65	0.020	10.400	8.000	2585	155	12.9
10.00	3	65	0.025	13.000	10.000	2070	155	20.2
12.00	3	65	0.025	15.600	12.000	1725	130	24.2
16.00	3	65	0.035	17.600	16.000	1295	135	38.2
20.00	3	65	0.040	22.000	20.000	1035	125	54.6
3.00	3	110	0.010	2.000	3.000	11670	350	2.1
4.00	3	110	0.015	3.100	4.000	8755	395	4.9
5.00	3	110	0.015	4.400	5.000	7005	315	6.9
6.00	3	110	0.020	7.800	6.000	5835	350	16.4
8.00	3	110	0.025	10.400	8.000	4375	330	27.3
10.00	3	110	0.025	13.000	10.000	3500	265	34.1
12.00	3	110	0.035	15.600	12.000	2920	305	57.4
16.00	3	110	0.045	17.600	16.000	2190	295	83.2
20.00	3	110	0.060	22.000	20.000	1750	315	138.7