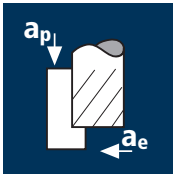


Anwendung

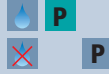


Werkstoff

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]
4	4	160	0.015	6.0	1.0	12735	765
6	4	160	0.020	9.0	1.5	8490	680
8	4	160	0.025	12.0	2.0	6365	635
10	4	160	0.035	15.0	2.5	5095	715
12	4	160	0.040	18.0	3.0	4245	680
14	4	160	0.045	21.0	3.5	3640	655
16	4	160	0.055	24.0	4.0	3185	700
18	4	160	0.060	27.0	4.5	2830	680
20	4	160	0.065	30.0	5.0	2545	660

4	4	100	0.015	6.0	1.0	7960	480
6	4	100	0.020	9.0	1.5	5305	425
8	4	100	0.025	12.0	2.0	3980	400
10	4	100	0.035	15.0	2.5	3185	445
12	4	100	0.040	18.0	3.0	2655	425
14	4	100	0.045	21.0	3.5	2275	410
16	4	100	0.055	24.0	4.0	1990	440
18	4	100	0.060	27.0	4.5	1770	425
20	4	100	0.065	30.0	5.0	1590	415

4	4	75	0.015	6.0	0.4	5970	360
6	4	75	0.020	9.0	0.6	3980	320
8	4	75	0.025	12.0	0.8	2985	300
10	4	75	0.035	15.0	1.0	2385	335
12	4	75	0.040	18.0	1.2	1990	320
14	4	75	0.045	21.0	1.4	1705	305
16	4	75	0.055	24.0	1.6	1490	330
18	4	75	0.060	27.0	1.8	1325	320
20	4	75	0.065	30.0	2.0	1195	310

4	4	90	0.015	6.0	1.0	7160	430
6	4	90	0.020	9.0	1.5	4775	380
8	4	90	0.025	12.0	2.0	3580	360
10	4	90	0.035	15.0	2.5	2865	400
12	4	90	0.040	18.0	3.0	2385	380
14	4	90	0.045	21.0	3.5	2045	370
16	4	90	0.055	24.0	4.0	1790	395
18	4	90	0.060	27.0	4.5	1590	380
20	4	90	0.065	30.0	5.0	1430	370

Werkstoff

Gusseisen
GG(G)



Reinkupfer



Titanlegierungen
bis 300 HB
[Ti5Al2.5Sn]



Hitzebeständiger Stahl
Duplex Stahl
[1.4462]
[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]
4	4	120	0.015	6.0	1.0	9550	575
6	4	120	0.020	9.0	1.5	6365	510
8	4	120	0.025	12.0	2.0	4775	480
10	4	120	0.035	15.0	2.5	3820	535
12	4	120	0.040	18.0	3.0	3185	510
14	4	120	0.045	21.0	3.5	2730	490
16	4	120	0.055	24.0	4.0	2385	525
18	4	120	0.060	27.0	4.5	2120	510
20	4	120	0.065	30.0	5.0	1910	495

4	4	230	0.015	6.0	1.0	18305	1100
6	4	230	0.020	9.0	1.5	12200	975
8	4	230	0.025	12.0	2.0	9150	915
10	4	230	0.035	15.0	2.5	7320	1025
12	4	230	0.040	18.0	3.0	6100	975
14	4	230	0.045	21.0	3.5	5230	940
16	4	230	0.055	24.0	4.0	4575	1005
18	4	230	0.060	27.0	4.5	4065	975
20	4	230	0.065	30.0	5.0	3660	950

4	4	95	0.015	6.0	1.0	7560	455
6	4	95	0.020	9.0	1.5	5040	405
8	4	95	0.025	12.0	2.0	3780	380
10	4	95	0.035	15.0	2.5	3025	425
12	4	95	0.040	18.0	3.0	2520	405
14	4	95	0.045	21.0	3.5	2160	390
16	4	95	0.055	24.0	4.0	1890	415
18	4	95	0.060	27.0	4.5	1680	405
20	4	95	0.065	30.0	5.0	1510	395

4	4	50	0.015	6.0	1.0	3980	240
6	4	50	0.020	9.0	1.5	2655	210
8	4	50	0.025	12.0	2.0	1990	200
10	4	50	0.035	15.0	2.5	1590	225
12	4	50	0.040	18.0	3.0	1325	210
14	4	50	0.045	21.0	3.5	1135	205
16	4	50	0.055	24.0	4.0	995	220
18	4	50	0.060	27.0	4.5	885	210
20	4	50	0.065	30.0	5.0	795	205