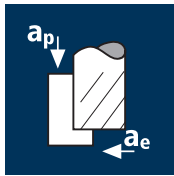


Anwendung



Werkstoff

Stahl
500 - 850 N/mm²

d ₁ [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]
3.00	4	115	0.018	3.750	1.200	12200	878	4.0
4.00	4	115	0.027	5.000	1.600	9150	988	7.9
5.00	4	115	0.033	6.250	2.000	7320	966	12.1
6.00	4	115	0.034	9.000	2.400	6100	830	17.9
8.00	4	115	0.046	12.000	3.200	4575	842	32.3
10.00	4	115	0.058	15.000	4.000	3660	849	50.9
12.00	4	115	0.065	18.000	4.800	3050	793	68.5
16.00	4	115	0.077	24.000	6.400	2290	705	108.3
20.00	4	115	0.089	30.000	8.000	1830	652	156.4

Stahl
850 - 1100 N/mm²

3.00	4	105	0.017	3.750	1.200	11140	758	3.4
4.00	4	105	0.023	5.000	1.600	8355	769	6.1
5.00	4	105	0.029	6.250	2.000	6685	776	9.7
6.00	4	105	0.030	9.000	2.400	5570	668	14.4
8.00	4	105	0.040	12.000	3.200	4180	669	25.7
10.00	4	105	0.050	15.000	4.000	3340	668	40.1
12.00	4	105	0.059	18.000	4.800	2785	657	56.8
16.00	4	105	0.071	24.000	6.400	2090	594	91.2
20.00	4	105	0.081	30.000	8.000	1670	541	129.9

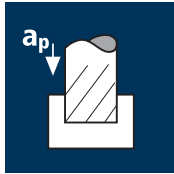
Inox normal
[Cr-Ni/1.4301]
[Cr-Ni-Mo/1.4571]

3.00	4	70	0.011	3.750	1.200	7425	327	1.5
4.00	4	70	0.014	5.000	1.600	5570	312	2.5
5.00	4	70	0.018	6.250	2.000	4455	321	4.0
6.00	4	70	0.021	9.000	2.400	3715	312	6.7
8.00	4	70	0.028	12.000	3.200	2785	312	12.0
10.00	4	70	0.034	15.000	4.000	2230	303	18.2
12.00	4	70	0.041	18.000	4.800	1855	304	26.3
16.00	4	70	0.046	24.000	6.400	1395	257	39.4
20.00	4	70	0.057	30.000	8.000	1115	254	61.0

Gusseisen
GG(G)

3.00	4	130	0.017	3.750	1.200	13795	938	4.2
4.00	4	130	0.025	5.000	1.600	10345	1035	8.3
5.00	4	130	0.030	6.250	2.000	8275	993	12.4
6.00	4	130	0.032	9.000	2.400	6895	883	19.1
8.00	4	130	0.043	12.000	3.200	5175	890	34.2
10.00	4	130	0.054	15.000	4.000	4140	894	53.7
12.00	4	130	0.064	18.000	4.800	3450	883	76.3
16.00	4	130	0.077	24.000	6.400	2585	796	122.3
20.00	4	130	0.089	30.000	8.000	2070	737	176.9

Anwendung



Werkstoff

Stahl
500 - 850 N/mm²

d ₁ [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]	Q [mm ³ /min]
3.00	4	92	0.008	2.250	3.000	9760	312	2.1
4.00	4	92	0.012	4.000	4.000	7320	351	5.6
5.00	4	92	0.015	5.000	5.000	5855	351	8.8
6.00	4	92	0.020	7.500	6.000	4880	390	17.6
8.00	4	92	0.028	10.000	8.000	3660	410	32.8
10.00	4	92	0.035	12.500	10.000	2930	410	51.3
12.00	4	92	0.039	15.000	12.000	2440	381	68.5
16.00	4	92	0.046	20.000	16.000	1830	337	107.7
20.00	4	92	0.053	25.000	20.000	1465	311	155.3

Stahl
850 - 1100 N/mm²

3.00	4	84	0.008	2.250	3.000	8915	285	1.9
4.00	4	84	0.010	4.000	4.000	6685	267	4.3
5.00	4	84	0.013	5.000	5.000	5350	278	7.0
6.00	4	84	0.018	7.500	6.000	4455	321	14.4
8.00	4	84	0.024	10.000	8.000	3340	321	25.6
10.00	4	84	0.030	12.500	10.000	2675	321	40.1
12.00	4	84	0.035	15.000	12.000	2230	312	56.2
16.00	4	84	0.043	20.000	16.000	1670	287	91.9
20.00	4	84	0.049	25.000	20.000	1335	262	130.9

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

3.00	4	56	0.005	2.250	3.000	5940	119	0.8
4.00	4	56	0.006	4.000	4.000	4455	107	1.7
5.00	4	56	0.008	5.000	5.000	3565	114	2.9
6.00	4	56	0.013	7.500	6.000	2970	154	6.9
8.00	4	56	0.017	10.000	8.000	2230	152	12.1
10.00	4	56	0.020	12.500	10.000	1785	143	17.9
12.00	4	56	0.025	15.000	12.000	1485	149	26.7
16.00	4	56	0.028	20.000	16.000	1115	125	40.0
20.00	4	56	0.034	25.000	20.000	890	121	60.5

Gusseisen
GG(G)

3.00	4	104	0.008	2.250	3.000	11035	353	2.8
4.00	4	104	0.011	4.000	4.000	8275	364	5.4
5.00	4	104	0.014	5.000	5.000	6620	371	9.3
6.00	4	104	0.019	7.500	6.000	5515	419	18.9
8.00	4	104	0.026	10.000	8.000	4140	431	34.4
10.00	4	104	0.032	12.500	10.000	3310	424	53.0
12.00	4	104	0.038	15.000	12.000	2760	420	75.5
16.00	4	104	0.046	20.000	16.000	2070	381	121.9
20.00	4	104	0.053	25.000	20.000	1655	351	175.5