

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	550	0.085	9.0	1.5	29180	7440	100.5
8	3	550	0.105	12.0	2.0	21885	6895	165.5
10	3	550	0.135	15.0	2.5	17510	7090	266.0
12	3	550	0.160	18.0	3.0	14590	7005	378.5
16	3	550	0.170	24.0	4.0	10940	5580	535.5
20	3	550	0.200	30.0	5.0	8755	5255	788.5

Reinkupfer

6	3	400	0.070	9.0	1.5	21220	4455	60.0
8	3	400	0.085	12.0	2.0	15915	4060	97.5
10	3	400	0.110	15.0	2.5	12735	4205	157.5
12	3	400	0.130	18.0	3.0	10610	4140	223.5
16	3	400	0.135	24.0	4.0	7960	3225	309.5
20	3	400	0.160	30.0	5.0	6365	3055	458.5

Thermoplaste

6	3	1000	0.085	9.0	1.5	53055	13530	182.5
8	3	1000	0.105	12.0	2.0	39790	12535	301.0
10	3	1000	0.135	15.0	2.5	31830	12890	483.5
12	3	1000	0.160	18.0	3.0	26525	12730	687.5
16	3	1000	0.170	24.0	4.0	19895	10145	974.0
20	3	1000	0.200	30.0	5.0	15915	9550	1432.5

Aluminiumguss
Si 6% - 15%

6	3	350	0.060	9.0	1.5	18570	3345	45.0
8	3	350	0.075	12.0	2.0	13925	3135	75.0
10	3	350	0.095	15.0	2.5	11140	3175	119.0
12	3	350	0.110	18.0	3.0	9285	3065	165.5
16	3	350	0.120	24.0	4.0	6965	2505	240.5
20	3	350	0.140	30.0	5.0	5570	2340	351.0

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	450	0.060	2.1	6	23875	4300	54.0
8	3	450	0.075	2.8	8	17905	4030	90.5
10	3	450	0.095	3.5	10	14325	4085	143.0
12	3	450	0.110	4.2	12	11935	3940	198.5
16	3	450	0.120	5.6	16	8955	3225	289.0
20	3	450	0.140	7.0	20	7160	3005	420.5

Reinkupfer

6	3	350	0.050	2.1	6	18570	2785	35.0
8	3	350	0.060	2.8	8	13925	2505	56.0
10	3	350	0.075	3.5	10	11140	2505	87.5
12	3	350	0.090	4.2	12	9285	2505	126.5
16	3	350	0.095	5.6	16	6965	1985	178.0
20	3	350	0.110	7.0	20	5570	1840	257.5

Thermoplaste

6	3	800	0.060	2.1	6	42445	7640	96.5
8	3	800	0.075	2.8	8	31830	7160	160.5
10	3	800	0.095	3.5	10	25465	7260	254.0
12	3	800	0.110	4.2	12	21220	7005	353.0
16	3	800	0.120	5.6	16	15915	5730	513.5
20	3	800	0.140	7.0	20	12735	5350	749.0

Aluminiumguss
Si 6% - 15%

6	3	300	0.040	2.1	6	15915	1910	24.0
8	3	300	0.055	2.8	8	11935	1970	44.0
10	3	300	0.065	3.5	10	9550	1860	65.0
12	3	300	0.075	4.2	12	7960	1790	90.0
16	3	300	0.085	5.6	16	5970	1520	136.0
20	3	300	0.100	7.0	20	4775	1435	201.0