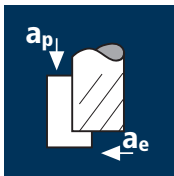


Anwendung

Werkstoff



CFK

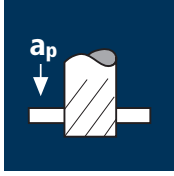
d1 [mm]	v _c [m/min]	f [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]
4	160	0.090	8.0	1.6	12735	1145
5	160	0.125	10.0	2.0	10185	1275
6	160	0.170	12.0	2.4	8490	1445
8	160	0.255	16.0	3.2	6365	1625
10	160	0.345	20.0	4.0	5095	1760

GFK

4	100	0.090	8.0	1.6	7960	715
5	100	0.125	10.0	2.0	6365	795
6	100	0.170	12.0	2.4	5305	900
8	100	0.255	16.0	3.2	3980	1015
10	100	0.345	20.0	4.0	3185	1100

Anwendung

Werkstoff

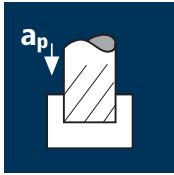


CFK

d1 [mm]	v _c [m/min]	f [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]
4	100	0.065	4.0	4	7960	515
5	100	0.090	5.0	5	6365	575
6	100	0.120	6.0	6	5305	635
8	100	0.180	8.0	8	3980	715
10	100	0.240	10.0	10	3185	765

GFK

4	60	0.065	4.0	4	4775	310
5	60	0.090	5.0	5	3820	345
6	60	0.120	6.0	6	3185	380
8	60	0.180	8.0	8	2385	430
10	60	0.240	10.0	10	1910	460



CFK

4	100	0.030	2.0	4	7960	240
5	100	0.045	2.5	5	6365	285
6	100	0.060	3.0	6	5305	320
8	100	0.090	4.0	8	3980	360
10	100	0.120	5.0	10	3185	380

GFK

4	60	0.030	2.0	4	4775	145
5	60	0.045	2.5	5	3820	170
6	60	0.060	3.0	6	3185	190
8	60	0.090	4.0	8	2385	215
10	60	0.120	5.0	10	1910	230