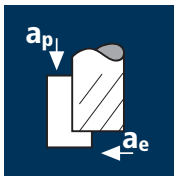


Anwendung



Werkstoff

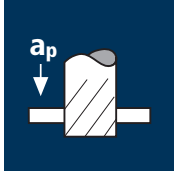
CFK

d1 [mm]	v _c [m/min]	f [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]
4	160	0.100	8.0	1.6	12735	1275
5	160	0.140	10.0	2.0	10185	1425
6	160	0.190	12.0	2.4	8490	1615
8	160	0.285	16.0	3.2	6365	1815
10	160	0.385	20.0	4.0	5095	1960

GFK

4	100	0.100	8.0	1.6	7960	795
5	100	0.140	10.0	2.0	6365	890
6	100	0.190	12.0	2.4	5305	1010
8	100	0.285	16.0	3.2	3980	1135
10	100	0.385	20.0	4.0	3185	1225

Anwendung



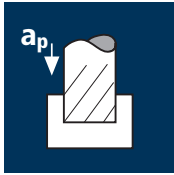
Werkstoff

CFK

d1 [mm]	v _c [m/min]	f [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]
4	100	0.070	4.0	4	7960	555
5	100	0.100	5.0	5	6365	635
6	100	0.135	6.0	6	5305	715
8	100	0.200	8.0	8	3980	795
10	100	0.270	10.0	10	3185	860

GFK

4	60	0.070	4.0	4	4775	335
5	60	0.100	5.0	5	3820	380
6	60	0.135	6.0	6	3185	430
8	60	0.200	8.0	8	2385	475
10	60	0.270	10.0	10	1910	515



CFK

4	100	0.035	2.0	4	7960	280
5	100	0.050	2.5	5	6365	320
6	100	0.065	3.0	6	5305	345
8	100	0.100	4.0	8	3980	400
10	100	0.135	5.0	10	3185	430

GFK

4	60	0.035	2.0	4	4775	165
5	60	0.050	2.5	5	3820	190
6	60	0.065	3.0	6	3185	205
8	60	0.100	4.0	8	2385	240
10	60	0.135	5.0	10	1910	260