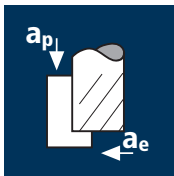


Anwendung



Werkstoff

CFK

| d1 [mm] | z | v _c [m/min] | f _z [mm] | a _p [mm] | a _e [mm] | n [min ⁻¹] | v _f [mm/min] |
|---------|---|------------------------|---------------------|---------------------|---------------------|------------------------|-------------------------|
| 4 | 8 | 200 | 0.025 | 7.2 | 1.6 | 15915 | 3185 |
| 5 | 8 | 200 | 0.030 | 9.0 | 2.0 | 12735 | 3055 |
| 6 | 8 | 200 | 0.040 | 10.8 | 2.4 | 10610 | 3395 |
| 8 | 8 | 200 | 0.045 | 14.4 | 3.2 | 7960 | 2865 |
| 10 | 8 | 200 | 0.050 | 18.0 | 4.0 | 6365 | 2545 |
| 12 | 8 | 200 | 0.060 | 21.6 | 4.8 | 5305 | 2545 |

GFK

| | | | | | | | |
|----|---|-----|-------|------|-----|-------|------|
| 4 | 8 | 150 | 0.030 | 7.2 | 1.6 | 11935 | 2865 |
| 5 | 8 | 150 | 0.035 | 9.0 | 2.0 | 9550 | 2675 |
| 6 | 8 | 150 | 0.040 | 10.8 | 2.4 | 7960 | 2545 |
| 8 | 8 | 150 | 0.050 | 14.4 | 3.2 | 5970 | 2390 |
| 10 | 8 | 150 | 0.055 | 18.0 | 4.0 | 4775 | 2100 |
| 12 | 8 | 150 | 0.065 | 21.6 | 4.8 | 3980 | 2070 |

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Anwendung



Werkstoff

CFK

| d1 [mm] | z | v _c [m/min] | f _z [mm] | a _p [mm] | a _e [mm] | n [min ⁻¹] | v _f [mm/min] |
|---------|---|------------------------|---------------------|---------------------|---------------------|------------------------|-------------------------|
| 4 | 8 | 150 | 0.020 | 3.2 | 4 | 11935 | 1910 |
| 5 | 8 | 150 | 0.025 | 4.0 | 5 | 9550 | 1910 |
| 6 | 8 | 150 | 0.030 | 4.8 | 6 | 7960 | 1910 |
| 8 | 8 | 150 | 0.035 | 6.4 | 8 | 5970 | 1670 |
| 10 | 8 | 150 | 0.040 | 8.0 | 10 | 4775 | 1530 |
| 12 | 8 | 150 | 0.050 | 9.6 | 12 | 3980 | 1590 |

GFK

| | | | | | | | |
|----|---|-----|-------|-----|----|------|------|
| 4 | 8 | 100 | 0.025 | 3.2 | 4 | 7960 | 1590 |
| 5 | 8 | 100 | 0.030 | 4.0 | 5 | 6365 | 1530 |
| 6 | 8 | 100 | 0.030 | 4.8 | 6 | 5305 | 1275 |
| 8 | 8 | 100 | 0.040 | 6.4 | 8 | 3980 | 1275 |
| 10 | 8 | 100 | 0.045 | 8.0 | 10 | 3185 | 1145 |
| 12 | 8 | 100 | 0.050 | 9.6 | 12 | 2655 | 1060 |

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