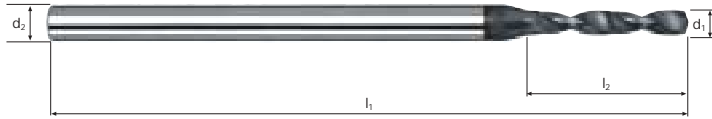
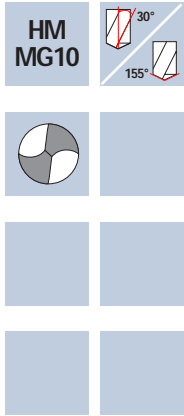


Mikrobohrer Microdrill NX

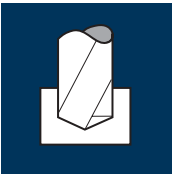
5xd



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|----------|-------------|--------------|--|--|--|--|----------------|--|-----------------|
| Rm < 850 | Rm 850-1100 | Rm 1100-1300 | | | | | Inox Stainless | | GG(G) Aluminium |
|----------|-------------|--------------|--|--|--|--|----------------|--|-----------------|

| Beispiel: Bestell-Nr. B57014 .0020 | | | | | DURO-SD | |
|---|-------|-------|----|-----|---------------|--|
| | | | | | B57014 | |
| Ø Code | d1 m7 | d2 h6 | l1 | l2 | | |
| .0020 | 0.20 | 3 | 42 | 1.3 | ● | |
| .0025 | 0.25 | 3 | 42 | 1.6 | ● | |
| .0030 | 0.30 | 3 | 42 | 2.0 | ● | |
| .0035 | 0.35 | 3 | 42 | 2.3 | ● | |
| .0040 | 0.40 | 3 | 42 | 2.6 | ● | |
| .0045 | 0.45 | 3 | 42 | 2.9 | ● | |
| .0050 | 0.50 | 3 | 42 | 3.3 | ● | |
| .0055 | 0.55 | 3 | 42 | 3.6 | ● | |
| .0060 | 0.60 | 3 | 42 | 3.9 | ● | |
| .0065 | 0.65 | 3 | 42 | 4.2 | ● | |
| .0070 | 0.70 | 3 | 42 | 4.6 | ● | |
| .0075 | 0.75 | 3 | 42 | 4.9 | ● | |
| .0080 | 0.80 | 3 | 42 | 5.2 | ● | |
| .0085 | 0.85 | 3 | 42 | 5.5 | ● | |
| .0087 | 0.87 | 3 | 42 | 5.7 | ● | |
| .0090 | 0.90 | 3 | 42 | 5.9 | ● | |
| .0095 | 0.95 | 3 | 42 | 6.2 | ● | |
| .0100 | 1.00 | 3 | 42 | 6.5 | ● | |
| .0105 | 1.05 | 3 | 42 | 6.8 | ● | |
| .0107 | 1.07 | 3 | 42 | 7.0 | ● | |
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Anwendung



Werkstoff

Stahl
< 500 N/mm²

| d1 [mm] | v _c [m/min] | f [mm] | L _{max} [mm] | n [min ⁻¹] | v _f [mm/min] | Q [cm ³ /min] | T [sek] |
|---------|------------------------|--------|-----------------------|------------------------|-------------------------|--------------------------|---------|
| 0.20 | 100 | 0.004 | 1.0 | 60000 | 240 | 0.0 | 0.3 |
| 0.30 | 100 | 0.006 | 1.6 | 60000 | 360 | 0.0 | 0.3 |
| 0.40 | 100 | 0.008 | 2.0 | 60000 | 480 | 0.0 | 0.3 |
| 0.50 | 100 | 0.010 | 2.6 | 60000 | 600 | 0.0 | 0.3 |
| 0.60 | 100 | 0.012 | 3.0 | 53050 | 635 | 0.0 | 0.3 |
| 0.70 | 100 | 0.014 | 3.5 | 45475 | 635 | 0.0 | 0.3 |
| 0.80 | 100 | 0.016 | 4.0 | 39790 | 635 | 0.5 | 0.4 |
| 0.90 | 100 | 0.018 | 4.6 | 35370 | 635 | 0.5 | 0.4 |
| 1.00 | 100 | 0.020 | 5.0 | 31830 | 635 | 0.5 | 0.5 |

Stahl
500 - 850 N/mm²

| d1 [mm] | v _c [m/min] | f [mm] | L _{max} [mm] | n [min ⁻¹] | v _f [mm/min] | Q [cm ³ /min] | T [sek] |
|---------|------------------------|--------|-----------------------|------------------------|-------------------------|--------------------------|---------|
| 0.20 | 80 | 0.004 | 1.0 | 60000 | 240 | 0.0 | 0.3 |
| 0.30 | 80 | 0.007 | 1.6 | 60000 | 420 | 0.0 | 0.2 |
| 0.40 | 80 | 0.009 | 2.0 | 60000 | 540 | 0.0 | 0.2 |
| 0.50 | 80 | 0.011 | 2.6 | 50930 | 560 | 0.0 | 0.3 |
| 0.60 | 80 | 0.013 | 3.0 | 42440 | 550 | 0.0 | 0.3 |
| 0.70 | 80 | 0.016 | 3.5 | 36380 | 580 | 0.0 | 0.4 |
| 0.80 | 80 | 0.018 | 4.0 | 31830 | 575 | 0.5 | 0.4 |
| 0.90 | 80 | 0.020 | 4.6 | 28295 | 565 | 0.5 | 0.5 |
| 1.00 | 80 | 0.022 | 5.0 | 25465 | 560 | 0.5 | 0.5 |

Stahl
850 - 1100 N/mm²

| d1 [mm] | v _c [m/min] | f [mm] | L _{max} [mm] | n [min ⁻¹] | v _f [mm/min] | Q [cm ³ /min] | T [sek] |
|---------|------------------------|--------|-----------------------|------------------------|-------------------------|--------------------------|---------|
| 0.20 | 40 | 0.003 | 1.0 | 60000 | 180 | 0.0 | 0.3 |
| 0.30 | 40 | 0.005 | 1.6 | 42440 | 210 | 0.0 | 0.5 |
| 0.40 | 40 | 0.006 | 2.0 | 31830 | 190 | 0.0 | 0.6 |
| 0.50 | 40 | 0.008 | 2.6 | 25465 | 205 | 0.0 | 0.8 |
| 0.60 | 40 | 0.009 | 3.0 | 21220 | 190 | 0.0 | 0.9 |
| 0.70 | 40 | 0.011 | 3.5 | 18190 | 200 | 0.0 | 1.1 |
| 0.80 | 40 | 0.012 | 4.0 | 15915 | 190 | 0.0 | 1.3 |
| 0.90 | 40 | 0.014 | 4.6 | 14145 | 200 | 0.0 | 1.4 |
| 1.00 | 40 | 0.015 | 5.0 | 12730 | 190 | 0.0 | 1.6 |

Stahl
1100 - 1300 N/mm²

| d1 [mm] | v _c [m/min] | f [mm] | L _{max} [mm] | n [min ⁻¹] | v _f [mm/min] | Q [cm ³ /min] | T [sek] |
|---------|------------------------|--------|-----------------------|------------------------|-------------------------|--------------------------|---------|
| 0.20 | 50 | 0.004 | 1.0 | 60000 | 240 | 0.0 | 0.3 |
| 0.30 | 50 | 0.005 | 1.6 | 53050 | 265 | 0.0 | 0.4 |
| 0.40 | 50 | 0.007 | 2.0 | 39790 | 280 | 0.0 | 0.4 |
| 0.50 | 50 | 0.009 | 2.6 | 31830 | 285 | 0.0 | 0.5 |
| 0.60 | 50 | 0.011 | 3.0 | 26525 | 290 | 0.0 | 0.6 |
| 0.70 | 50 | 0.013 | 3.5 | 22735 | 295 | 0.0 | 0.7 |
| 0.80 | 50 | 0.015 | 4.0 | 19895 | 300 | 0.0 | 0.8 |
| 0.90 | 50 | 0.016 | 4.6 | 17685 | 285 | 0.0 | 1.0 |
| 1.00 | 50 | 0.018 | 5.0 | 15915 | 285 | 0.0 | 1.1 |

Werkstoff

Gusseisen
GG(G)

| d1 [mm] | v _c [m/min] | f [mm] | L _{max} [mm] | n [min ⁻¹] | v _f [mm/min] | Q [cm ³ /min] | T [sek] |
|---------|------------------------|--------|-----------------------|------------------------|-------------------------|--------------------------|---------|
| 0.20 | 130 | 0.004 | 1.0 | 60000 | 240 | 0.0 | 0.3 |
| 0.30 | 130 | 0.007 | 1.6 | 60000 | 420 | 0.0 | 0.2 |
| 0.40 | 130 | 0.009 | 2.0 | 60000 | 540 | 0.0 | 0.2 |
| 0.50 | 130 | 0.011 | 2.6 | 60000 | 660 | 0.0 | 0.2 |
| 0.60 | 130 | 0.013 | 3.0 | 60000 | 780 | 0.0 | 0.2 |
| 0.70 | 130 | 0.016 | 3.5 | 59115 | 945 | 0.5 | 0.2 |
| 0.80 | 130 | 0.018 | 4.0 | 51725 | 930 | 0.5 | 0.3 |
| 0.90 | 130 | 0.020 | 4.6 | 45980 | 920 | 0.5 | 0.3 |
| 1.00 | 130 | 0.022 | 5.0 | 41380 | 910 | 0.5 | 0.3 |

Al-Knetlegierung
Si < 6%

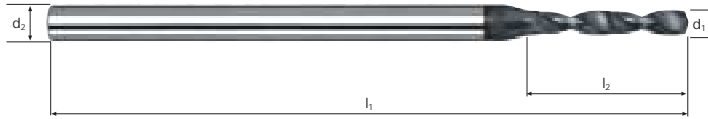
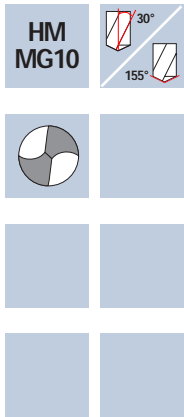
| d1 [mm] | v _c [m/min] | f [mm] | L _{max} [mm] | n [min ⁻¹] | v _f [mm/min] | Q [cm ³ /min] | T [sek] |
|---------|------------------------|--------|-----------------------|------------------------|-------------------------|--------------------------|---------|
| 0.20 | 160 | 0.004 | 1.0 | 60000 | 240 | 0.0 | 0.3 |
| 0.30 | 160 | 0.007 | 1.6 | 60000 | 420 | 0.0 | 0.2 |
| 0.40 | 160 | 0.009 | 2.0 | 60000 | 540 | 0.0 | 0.2 |
| 0.50 | 160 | 0.011 | 2.6 | 60000 | 660 | 0.0 | 0.2 |
| 0.60 | 160 | 0.013 | 3.0 | 60000 | 780 | 0.0 | 0.2 |
| 0.70 | 160 | 0.016 | 3.5 | 60000 | 960 | 0.5 | 0.2 |
| 0.80 | 160 | 0.018 | 4.0 | 60000 | 1080 | 0.5 | 0.2 |
| 0.90 | 160 | 0.020 | 4.6 | 56590 | 1130 | 0.5 | 0.2 |
| 1.00 | 160 | 0.022 | 5.0 | 50930 | 1120 | 1.0 | 0.3 |

| d1 [mm] | v _c [m/min] | f [mm] | L _{max} [mm] | n [min ⁻¹] | v _f [mm/min] | Q [cm ³ /min] | T [sek] |
|---------|------------------------|--------|-----------------------|------------------------|-------------------------|--------------------------|---------|
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| d1 [mm] | v _c [m/min] | f [mm] | L _{max} [mm] | n [min ⁻¹] | v _f [mm/min] | Q [cm ³ /min] | T [sek] |
|---------|------------------------|--------|-----------------------|------------------------|-------------------------|--------------------------|---------|
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Mikrobohrer Microdrill NX

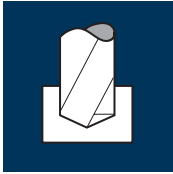
5xd



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|-------------|----------------|-----------------|--|--|--|--|-------------------|--|--------------------|
| Rm < 850 | Rm 850-1100 | Rm 1100-1300 | | | | | Inox Stainless | | GG(G) Aluminium |
|-------------|----------------|-----------------|--|--|--|--|-------------------|--|--------------------|

| Beispiel: Bestell-Nr. | | | | | DURO-SD | |
|--------------------------|----------|----------|----|------|---------|--|
| | | | | | B57014 | |
| | | | | | | |
| Ø Code | d1 m7 | d2 h6 | l1 | l2 | | |
| .0110 | 1.10 | 3 | 42 | 7.2 | ● | |
| .0115 | 1.15 | 3 | 42 | 7.5 | ● | |
| .0120 | 1.20 | 3 | 42 | 7.8 | ● | |
| .0125 | 1.25 | 3 | 42 | 8.1 | ● | |
| .0130 | 1.30 | 3 | 42 | 8.5 | ● | |
| .0135 | 1.35 | 3 | 42 | 8.8 | ● | |
| .0140 | 1.40 | 3 | 42 | 9.1 | ● | |
| .0142 | 1.42 | 3 | 42 | 9.2 | ● | |
| .0145 | 1.45 | 3 | 42 | 9.4 | ● | |
| .0150 | 1.50 | 3 | 42 | 9.8 | ● | |
| .0155 | 1.55 | 3 | 42 | 10.1 | ● | |
| .0160 | 1.60 | 3 | 42 | 10.4 | ● | |
| .0162 | 1.62 | 3 | 42 | 10.5 | ● | |
| .0165 | 1.65 | 3 | 42 | 10.7 | ● | |
| .0170 | 1.70 | 3 | 42 | 11.1 | ● | |
| .0175 | 1.75 | 3 | 42 | 11.4 | ● | |
| .0180 | 1.80 | 3 | 42 | 11.7 | ● | |
| .0185 | 1.85 | 3 | 50 | 12.0 | ● | |
| .0190 | 1.90 | 3 | 50 | 12.4 | ● | |
| .0195 | 1.95 | 3 | 50 | 12.7 | ● | |
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Anwendung



Werkstoff

Stahl
< 500 N/mm²

| d1 [mm] | v _c [m/min] | f [mm] | L _{max} [mm] | n [min ⁻¹] | v _f [mm/min] | Q [cm ³ /min] | T [sek] |
|---------|------------------------|--------|-----------------------|------------------------|-------------------------|--------------------------|---------|
| 1.10 | 100 | 0.022 | 5.5 | 28935 | 635 | 0.5 | 0.5 |
| 1.20 | 100 | 0.024 | 6.0 | 26525 | 635 | 0.5 | 0.6 |
| 1.30 | 100 | 0.026 | 6.6 | 24485 | 635 | 1.0 | 0.6 |
| 1.40 | 100 | 0.028 | 7.0 | 22735 | 635 | 1.0 | 0.7 |
| 1.50 | 100 | 0.030 | 7.6 | 21220 | 635 | 1.0 | 0.7 |
| 1.60 | 100 | 0.032 | 8.0 | 19895 | 635 | 1.5 | 0.8 |
| 1.70 | 100 | 0.034 | 8.6 | 18725 | 635 | 1.5 | 0.8 |
| 1.80 | 100 | 0.036 | 9.0 | 17685 | 635 | 1.5 | 0.9 |
| 1.90 | 100 | 0.038 | 9.6 | 16755 | 635 | 2.0 | 0.9 |

Stahl
500 - 850 N/mm²

| d1 [mm] | v _c [m/min] | f [mm] | L _{max} [mm] | n [min ⁻¹] | v _f [mm/min] | Q [cm ³ /min] | T [sek] |
|---------|------------------------|--------|-----------------------|------------------------|-------------------------|--------------------------|---------|
| 1.10 | 80 | 0.024 | 5.5 | 23150 | 555 | 0.5 | 0.6 |
| 1.20 | 80 | 0.027 | 6.0 | 21220 | 575 | 0.5 | 0.6 |
| 1.30 | 80 | 0.029 | 6.6 | 19590 | 570 | 1.0 | 0.7 |
| 1.40 | 80 | 0.031 | 7.0 | 18190 | 565 | 1.0 | 0.7 |
| 1.50 | 80 | 0.033 | 7.6 | 16975 | 560 | 1.0 | 0.8 |
| 1.60 | 80 | 0.036 | 8.0 | 15915 | 575 | 1.0 | 0.8 |
| 1.70 | 80 | 0.038 | 8.6 | 14980 | 570 | 1.5 | 0.9 |
| 1.80 | 80 | 0.040 | 9.0 | 14145 | 565 | 1.5 | 1.0 |
| 1.90 | 80 | 0.042 | 9.6 | 13405 | 565 | 1.5 | 1.0 |

Stahl
850 - 1100 N/mm²

| d1 [mm] | v _c [m/min] | f [mm] | L _{max} [mm] | n [min ⁻¹] | v _f [mm/min] | Q [cm ³ /min] | T [sek] |
|---------|------------------------|--------|-----------------------|------------------------|-------------------------|--------------------------|---------|
| 1.10 | 40 | 0.017 | 5.5 | 11575 | 195 | 0.0 | 1.7 |
| 1.20 | 40 | 0.018 | 6.0 | 10610 | 190 | 0.0 | 1.9 |
| 1.30 | 40 | 0.020 | 6.6 | 9795 | 195 | 0.5 | 2.0 |
| 1.40 | 40 | 0.022 | 7.0 | 9095 | 200 | 0.5 | 2.1 |
| 1.50 | 40 | 0.023 | 7.6 | 8490 | 195 | 0.5 | 2.3 |
| 1.60 | 40 | 0.025 | 8.0 | 7960 | 200 | 0.5 | 2.4 |
| 1.70 | 40 | 0.026 | 8.6 | 7490 | 195 | 0.5 | 2.6 |
| 1.80 | 40 | 0.028 | 9.0 | 7075 | 200 | 0.5 | 2.7 |
| 1.90 | 40 | 0.029 | 9.6 | 6700 | 195 | 0.5 | 3.0 |

Nichtrostender Stahl
[Cr-Ni/1.4301]

| d1 [mm] | v _c [m/min] | f [mm] | L _{max} [mm] | n [min ⁻¹] | v _f [mm/min] | Q [cm ³ /min] | T [sek] |
|---------|------------------------|--------|-----------------------|------------------------|-------------------------|--------------------------|---------|
| 1.10 | 30 | 0.017 | 5.5 | 8680 | 150 | 0.0 | 2.2 |
| 1.20 | 30 | 0.018 | 6.0 | 7960 | 145 | 0.0 | 2.5 |
| 1.30 | 30 | 0.020 | 6.6 | 7345 | 145 | 0.0 | 2.7 |
| 1.40 | 30 | 0.022 | 7.0 | 6820 | 150 | 0.0 | 2.8 |
| 1.50 | 30 | 0.023 | 7.6 | 6365 | 145 | 0.5 | 3.1 |
| 1.60 | 30 | 0.025 | 8.0 | 5970 | 150 | 0.5 | 3.2 |
| 1.70 | 30 | 0.026 | 8.6 | 5615 | 145 | 0.5 | 3.6 |
| 1.80 | 30 | 0.028 | 9.0 | 5305 | 150 | 0.5 | 3.6 |
| 1.90 | 30 | 0.029 | 9.6 | 5025 | 145 | 0.5 | 4.0 |

Werkstoff

Gusseisen
GG(G)

| d1 [mm] | v _c [m/min] | f [mm] | L _{max} [mm] | n [min ⁻¹] | v _f [mm/min] | Q [cm ³ /min] | T [sek] |
|---------|------------------------|--------|-----------------------|------------------------|-------------------------|--------------------------|---------|
| 1.10 | 130 | 0.024 | 5.5 | 37620 | 905 | 1.0 | 0.4 |
| 1.20 | 130 | 0.027 | 6.0 | 34485 | 930 | 1.0 | 0.4 |
| 1.30 | 130 | 0.029 | 6.6 | 31830 | 925 | 1.0 | 0.4 |
| 1.40 | 130 | 0.031 | 7.0 | 29555 | 915 | 1.5 | 0.5 |
| 1.50 | 130 | 0.033 | 7.6 | 27585 | 910 | 1.5 | 0.5 |
| 1.60 | 130 | 0.036 | 8.0 | 25865 | 930 | 2.0 | 0.5 |
| 1.70 | 130 | 0.038 | 8.6 | 24340 | 925 | 2.0 | 0.6 |
| 1.80 | 130 | 0.040 | 9.0 | 22990 | 920 | 2.5 | 0.6 |
| 1.90 | 130 | 0.042 | 9.6 | 21780 | 915 | 2.5 | 0.6 |

Al-Knetlegierung
Si < 6%

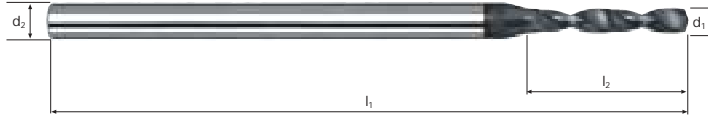
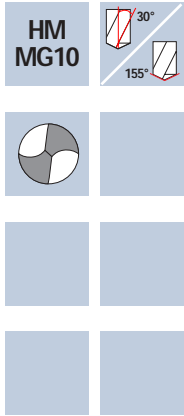
| d1 [mm] | v _c [m/min] | f [mm] | L _{max} [mm] | n [min ⁻¹] | v _f [mm/min] | Q [cm ³ /min] | T [sek] |
|---------|------------------------|--------|-----------------------|------------------------|-------------------------|--------------------------|---------|
| 1.10 | 160 | 0.024 | 5.5 | 46300 | 1110 | 1.0 | 0.3 |
| 1.20 | 160 | 0.027 | 6.0 | 42440 | 1145 | 1.5 | 0.3 |
| 1.30 | 160 | 0.029 | 6.6 | 39175 | 1135 | 1.5 | 0.3 |
| 1.40 | 160 | 0.031 | 7.0 | 36380 | 1130 | 1.5 | 0.4 |
| 1.50 | 160 | 0.033 | 7.6 | 33955 | 1120 | 2.0 | 0.4 |
| 1.60 | 160 | 0.036 | 8.0 | 31830 | 1145 | 2.5 | 0.4 |
| 1.70 | 160 | 0.038 | 8.6 | 29960 | 1140 | 2.5 | 0.5 |
| 1.80 | 160 | 0.040 | 9.0 | 28295 | 1130 | 3.0 | 0.5 |
| 1.90 | 160 | 0.042 | 9.6 | 26805 | 1125 | 3.0 | 0.5 |

| d1 [mm] | v _c [m/min] | f [mm] | L _{max} [mm] | n [min ⁻¹] | v _f [mm/min] | Q [cm ³ /min] | T [sek] |
|---------|------------------------|--------|-----------------------|------------------------|-------------------------|--------------------------|---------|
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| d1 [mm] | v _c [m/min] | f [mm] | L _{max} [mm] | n [min ⁻¹] | v _f [mm/min] | Q [cm ³ /min] | T [sek] |
|---------|------------------------|--------|-----------------------|------------------------|-------------------------|--------------------------|---------|
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Mikrobohrer Microdrill NX

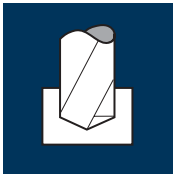
5xd



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|-------------|----------------|-----------------|--|--|--|--|-------------------|--|--------------------|
| Rm < 850 | Rm 850-1100 | Rm 1100-1300 | | | | | Inox Stainless | | GG(G) Aluminium |
|-------------|----------------|-----------------|--|--|--|--|-------------------|--|--------------------|

| Beispiel: Bestell-Nr. | | | | | DURO-SD | |
|--------------------------|----------|----------|----|------|---------|--|
| | | | | | B57014 | |
| Ø Code | d1 m7 | d2 h6 | l1 | l2 | | |
| .0200 | 2.00 | 3 | 50 | 13.0 | ● | |
| .0205 | 2.05 | 3 | 50 | 13.3 | ● | |
| .0210 | 2.10 | 3 | 50 | 13.7 | ● | |
| .0215 | 2.15 | 3 | 50 | 14.0 | ● | |
| .0220 | 2.20 | 3 | 50 | 14.3 | ● | |
| .0225 | 2.25 | 3 | 50 | 14.6 | ● | |
| .0230 | 2.30 | 3 | 50 | 15.0 | ● | |
| .0235 | 2.35 | 3 | 50 | 15.3 | ● | |
| .0240 | 2.40 | 3 | 50 | 15.6 | ● | |
| .0245 | 2.45 | 3 | 50 | 15.9 | ● | |
| .0250 | 2.50 | 3 | 50 | 16.3 | ● | |
| .0255 | 2.55 | 3 | 50 | 16.6 | ● | |
| .0260 | 2.60 | 3 | 50 | 16.9 | ● | |
| .0265 | 2.65 | 3 | 50 | 17.2 | ● | |
| .0270 | 2.70 | 3 | 50 | 17.6 | ● | |
| .0275 | 2.75 | 3 | 50 | 17.9 | ● | |
| .0280 | 2.80 | 3 | 50 | 18.2 | ● | |
| .0285 | 2.85 | 3 | 50 | 18.5 | ● | |
| .0290 | 2.90 | 3 | 50 | 18.9 | ● | |
| .0295 | 2.95 | 3 | 50 | 19.2 | ● | |
| | | | | | | |
| | | | | | | |

Anwendung



Werkstoff

Stahl
< 500 N/mm²

| d1 [mm] | v _c [m/min] | f [mm] | L _{max} [mm] | n [min ⁻¹] | v _f [mm/min] | Q [cm ³ /min] | T [sek] |
|---------|------------------------|--------|-----------------------|------------------------|-------------------------|--------------------------|---------|
| 2.00 | 100 | 0.040 | 10.0 | 15915 | 635 | 2.0 | 0.9 |
| 2.10 | 100 | 0.042 | 10.5 | 15160 | 635 | 2.0 | 1.0 |
| 2.20 | 100 | 0.044 | 11.0 | 14470 | 635 | 2.5 | 1.0 |
| 2.35 | 100 | 0.047 | 11.8 | 13545 | 635 | 3.0 | 1.1 |
| 2.50 | 100 | 0.050 | 12.6 | 12730 | 635 | 3.0 | 1.2 |
| 2.60 | 100 | 0.052 | 13.0 | 12245 | 635 | 3.5 | 1.2 |
| 2.75 | 100 | 0.055 | 13.8 | 11575 | 635 | 4.0 | 1.3 |
| 2.85 | 100 | 0.057 | 14.2 | 11170 | 635 | 4.0 | 1.3 |
| 2.95 | 100 | 0.059 | 14.8 | 10790 | 635 | 4.5 | 1.4 |

Stahl
500 - 850 N/mm²

| | | | | | | | |
|------|----|-------|------|-------|-----|-----|-----|
| 2.00 | 80 | 0.044 | 10.0 | 12730 | 560 | 2.0 | 1.1 |
| 2.10 | 80 | 0.047 | 10.5 | 12125 | 570 | 2.0 | 1.1 |
| 2.20 | 80 | 0.049 | 11.0 | 11575 | 565 | 2.0 | 1.2 |
| 2.35 | 80 | 0.052 | 11.8 | 10835 | 565 | 2.5 | 1.3 |
| 2.50 | 80 | 0.056 | 12.6 | 10185 | 570 | 3.0 | 1.3 |
| 2.60 | 80 | 0.058 | 13.0 | 9795 | 570 | 3.0 | 1.4 |
| 2.75 | 80 | 0.061 | 13.8 | 9260 | 565 | 3.5 | 1.5 |
| 2.85 | 80 | 0.063 | 14.2 | 8935 | 565 | 3.5 | 1.5 |
| 2.95 | 80 | 0.066 | 14.8 | 8630 | 570 | 4.0 | 1.6 |

Stahl
850 - 1100 N/mm²

| | | | | | | | |
|------|----|-------|------|------|-----|-----|-----|
| 2.00 | 40 | 0.031 | 10.0 | 6365 | 195 | 0.5 | 3.1 |
| 2.10 | 40 | 0.032 | 10.5 | 6065 | 195 | 0.5 | 3.2 |
| 2.20 | 40 | 0.034 | 11.0 | 5785 | 195 | 0.5 | 3.4 |
| 2.35 | 40 | 0.036 | 11.8 | 5420 | 195 | 1.0 | 3.6 |
| 2.50 | 40 | 0.038 | 12.6 | 5095 | 195 | 1.0 | 3.9 |
| 2.60 | 40 | 0.040 | 13.0 | 4895 | 195 | 1.0 | 4.0 |
| 2.75 | 40 | 0.042 | 13.8 | 4630 | 195 | 1.0 | 4.2 |
| 2.85 | 40 | 0.044 | 14.2 | 4470 | 195 | 1.0 | 4.4 |
| 2.95 | 40 | 0.045 | 14.8 | 4315 | 195 | 1.5 | 4.6 |

Nichtrostender Stahl
[Cr-Ni/1.4301]

| | | | | | | | |
|------|----|-------|------|------|-----|-----|-----|
| 2.00 | 30 | 0.031 | 10.0 | 4775 | 150 | 0.5 | 4.0 |
| 2.10 | 30 | 0.032 | 10.5 | 4545 | 145 | 0.5 | 4.3 |
| 2.20 | 30 | 0.034 | 11.0 | 4340 | 150 | 0.5 | 4.4 |
| 2.35 | 30 | 0.036 | 11.8 | 4065 | 145 | 0.5 | 4.9 |
| 2.50 | 30 | 0.038 | 12.6 | 3820 | 145 | 0.5 | 5.2 |
| 2.60 | 30 | 0.040 | 13.0 | 3675 | 145 | 1.0 | 5.4 |
| 2.75 | 30 | 0.042 | 13.8 | 3470 | 145 | 1.0 | 5.7 |
| 2.85 | 30 | 0.044 | 14.2 | 3350 | 145 | 1.0 | 5.9 |
| 2.95 | 30 | 0.045 | 14.8 | 3235 | 145 | 1.0 | 6.1 |

Werkstoff

Gusseisen
GG(G)

| d1 [mm] | v _c [m/min] | f [mm] | L _{max} [mm] | n [min ⁻¹] | v _f [mm/min] | Q [cm ³ /min] | T [sek] |
|---------|------------------------|--------|-----------------------|------------------------|-------------------------|--------------------------|---------|
| 2.00 | 130 | 0.044 | 10.0 | 20690 | 910 | 3.0 | 0.7 |
| 2.10 | 130 | 0.047 | 10.5 | 19705 | 925 | 3.0 | 0.7 |
| 2.20 | 130 | 0.049 | 11.0 | 18810 | 920 | 3.5 | 0.7 |
| 2.35 | 130 | 0.052 | 11.8 | 17610 | 915 | 4.0 | 0.8 |
| 2.50 | 130 | 0.056 | 12.6 | 16550 | 925 | 4.5 | 0.8 |
| 2.60 | 130 | 0.058 | 13.0 | 15915 | 925 | 5.0 | 0.8 |
| 2.75 | 130 | 0.061 | 13.8 | 15045 | 920 | 5.5 | 0.9 |
| 2.85 | 130 | 0.063 | 14.2 | 14520 | 915 | 6.0 | 0.9 |
| 2.95 | 130 | 0.066 | 14.8 | 14025 | 925 | 6.5 | 1.0 |

Al-Knetlegierung
Si < 6%

| | | | | | | | |
|------|-----|-------|------|-------|------|-----|-----|
| 2.00 | 160 | 0.044 | 10.0 | 25465 | 1120 | 3.5 | 0.5 |
| 2.10 | 160 | 0.047 | 10.5 | 24250 | 1140 | 4.0 | 0.6 |
| 2.20 | 160 | 0.049 | 11.0 | 23150 | 1135 | 4.5 | 0.6 |
| 2.35 | 160 | 0.052 | 11.8 | 21670 | 1125 | 5.0 | 0.6 |
| 2.50 | 160 | 0.056 | 12.6 | 20370 | 1140 | 5.5 | 0.7 |
| 2.60 | 160 | 0.058 | 13.0 | 19590 | 1135 | 6.0 | 0.7 |
| 2.75 | 160 | 0.061 | 13.8 | 18520 | 1130 | 6.5 | 0.7 |
| 2.85 | 160 | 0.063 | 14.2 | 17870 | 1125 | 7.0 | 0.8 |
| 2.95 | 160 | 0.066 | 14.8 | 17265 | 1140 | 8.0 | 0.8 |

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