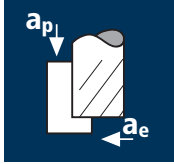
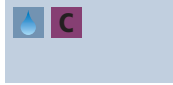


Anwendung



Werkstoff

Al-Knetlegierung
Si < 6%



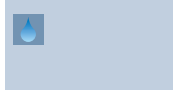
d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]
6	3	345	0.055	9	2.4	18305	3020	65.0
8	3	345	0.070	12	3.2	13730	2885	111.0
10	3	345	0.090	15	4.0	10980	2965	178.0
12	3	345	0.125	18	4.8	9150	3430	296.5
16	3	345	0.170	24	6.4	6865	3500	537.5
20	3	345	0.210	30	8.0	5490	3460	830.5
25	3	345	0.265	38	10.0	4395	3495	1310.5

Reinkupfer



6	3	147	0.055	9	2.4	7800	1285	28.0
8	3	147	0.070	12	3.2	5850	1230	47.0
10	3	147	0.090	15	4.0	4680	1265	76.0
12	3	147	0.125	18	4.8	3900	1465	126.5
16	3	147	0.170	24	6.4	2925	1490	229.0
20	3	147	0.210	30	8.0	2340	1475	354.0
25	3	147	0.265	38	10.0	1870	1485	557.0

Thermoplaste




6	3	360	0.055	9	2.4	19100	3150	68.0
8	3	360	0.070	12	3.2	14325	3010	115.5
10	3	360	0.090	15	4.0	11460	3095	185.5
12	3	360	0.125	18	4.8	9550	3580	309.5
16	3	360	0.170	24	6.4	7160	3650	560.5
20	3	360	0.210	30	8.0	5730	3610	866.5
25	3	360	0.265	38	10.0	4585	3645	1367.0

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	315	0.045	6	6	16710	2255	81.0
8	3	315	0.055	8	8	12535	2070	132.5
10	3	315	0.070	10	10	10025	2105	210.5
12	3	315	0.100	12	12	8355	2505	360.5
16	3	315	0.135	16	16	6265	2535	649.0
20	3	315	0.170	20	20	5015	2560	1024.0
25	3	315	0.210	25	25	4010	2525	1578.0

Reinkupfer



6	3	136	0.045	6	6	7215	975	35.0
8	3	136	0.055	8	8	5410	895	57.5
10	3	136	0.070	10	10	4330	910	91.0
12	3	136	0.100	12	12	3610	1085	156.0
16	3	136	0.135	16	16	2705	1095	280.5
20	3	136	0.170	20	20	2165	1105	442.0
25	3	136	0.210	25	25	1730	1090	681.5

Thermoplaste



6	3	335	0.045	6	6	17775	2400	86.5
8	3	335	0.055	8	8	13330	2200	141.0
10	3	335	0.070	10	10	10665	2240	224.0
12	3	335	0.100	12	12	8885	2665	384.0
16	3	335	0.135	16	16	6665	2700	691.0
20	3	335	0.170	20	20	5330	2720	1088.0
25	3	335	0.210	25	25	4265	2685	1678.0