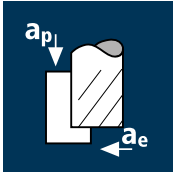


Anwendung



Werkstoff

Stahl
< 850 N/mm²



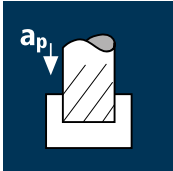
Stahl
850 - 1100 N/mm²



Kaltarbeitsstahl
(12% Cr)
hoch legiert
[1.2379]



Nichtrostender Stahl
[Cr-Ni/1.4301]



Stahl
< 850 N/mm²



Stahl
850 - 1100 N/mm²



Kaltarbeitsstahl
(12% Cr)
hoch legiert
[1.2379]



Nichtrostender Stahl
[Cr-Ni/1.4301]



d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]
6.00	4	180	0.040	10.800	1.200	9550	1530	19.8
8.00	4	180	0.050	14.400	1.600	7160	1430	33.0
10.00	4	180	0.065	18.000	2.000	5730	1490	53.6
12.00	4	180	0.075	21.600	2.400	4775	1430	74.3
16.00	4	180	0.085	28.800	3.200	3580	1220	112.2
20.00	4	180	0.105	36.000	4.000	2865	1205	173.3

6.00	4	140	0.040	10.800	1.200	7425	1190	15.4
8.00	4	140	0.050	14.400	1.600	5570	1115	25.7
10.00	4	140	0.065	18.000	2.000	4455	1160	41.7
12.00	4	140	0.075	21.600	2.400	3715	1115	57.8
16.00	4	140	0.085	28.800	3.200	2785	945	87.3
20.00	4	140	0.105	36.000	4.000	2230	935	134.8

6.00	4	70	0.035	10.800	1.200	3715	520	6.7
8.00	4	70	0.045	14.400	1.600	2785	500	11.6
10.00	4	70	0.060	18.000	2.000	2230	535	19.3
12.00	4	70	0.070	21.600	2.400	1855	520	27.0
16.00	4	70	0.080	28.800	3.200	1395	445	41.1
20.00	4	70	0.100	36.000	4.000	1115	445	64.2

6.00	4	85	0.025	10.800	1.200	4510	450	5.8
8.00	4	85	0.030	14.400	1.600	3380	405	9.4
10.00	4	85	0.040	18.000	2.000	2705	435	15.6
12.00	4	85	0.050	21.600	2.400	2255	450	23.4
16.00	4	85	0.055	28.800	3.200	1690	370	34.3
20.00	4	85	0.070	36.000	4.000	1355	380	54.5

6.00	4	145	0.020	8.100	6.000	7690	615	29.9
8.00	4	145	0.025	10.800	8.000	5770	575	49.8
10.00	4	145	0.035	13.500	10.000	4615	645	87.2
12.00	4	145	0.040	16.200	12.000	3845	615	119.6
16.00	4	145	0.050	19.200	16.000	2885	575	177.2
20.00	4	145	0.060	24.000	20.000	2310	555	265.9

6.00	4	105	0.020	8.100	6.000	5570	445	21.7
8.00	4	105	0.025	10.800	8.000	4180	420	36.1
10.00	4	105	0.035	13.500	10.000	3340	470	63.2
12.00	4	105	0.040	16.200	12.000	2785	445	86.6
16.00	4	105	0.050	19.200	16.000	2090	420	128.3
20.00	4	105	0.060	24.000	20.000	1670	400	192.5

6.00	4	55	0.020	8.100	6.000	2920	235	11.3
8.00	4	55	0.025	10.800	8.000	2190	220	18.9
10.00	4	55	0.030	13.500	10.000	1750	210	28.4
12.00	4	55	0.035	16.200	12.000	1460	205	39.7
16.00	4	55	0.045	19.200	16.000	1095	195	60.5
20.00	4	55	0.055	24.000	20.000	875	195	92.4

6.00	4	65	0.015	8.100	6.000	3450	205	10.1
8.00	4	65	0.020	10.800	8.000	2585	205	17.9
10.00	4	65	0.025	13.500	10.000	2070	205	27.9
12.00	4	65	0.030	16.200	12.000	1725	205	40.2
16.00	4	65	0.035	19.200	16.000	1295	180	55.6
20.00	4	65	0.045	24.000	20.000	1035	185	89.4