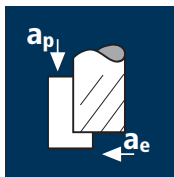




## Anwendung



## Werkstoff

Stahl  
< 850 N/mm<sup>2</sup>

Stahl  
850 - 1100 N/mm<sup>2</sup>

Nichtrostender Stahl  
[Cr-Ni/1.4301]

Gusseisen  
GG(G)

d1 [mm]	z	v <sub>c</sub> [m/min]	f <sub>z</sub> [mm]	a <sub>p</sub> [mm]	a <sub>e</sub> [mm]	n [min <sup>-1</sup> ]	v <sub>f</sub> [mm/min]	Q [cm <sup>3</sup> /min]
3	3	165	0.010	4.5	1.8	17510	525	4.5
4	3	165	0.015	6.0	2.4	13130	590	8.5
5	3	165	0.015	7.5	3.0	10505	475	10.5
6	3	165	0.020	9.0	3.6	8755	525	17.0
8	3	165	0.025	12.0	4.8	6565	490	28.0
10	3	165	0.030	15.0	6.0	5250	475	43.0
12	3	165	0.040	18.0	7.2	4375	525	68.0
16	3	165	0.050	24.0	8.4	3285	495	100.0
20	3	165	0.065	30.0	10.5	2625	510	160.5

3	3	110	0.010	4.5	1.8	11670	350	3.0
4	3	110	0.015	6.0	2.4	8755	395	5.5
5	3	110	0.015	7.5	3.0	7005	315	7.0
6	3	110	0.020	9.0	3.6	5835	350	11.5
8	3	110	0.025	12.0	4.8	4375	330	19.0
10	3	110	0.030	15.0	6.0	3500	315	28.5
12	3	110	0.040	18.0	7.2	2920	350	45.5
16	3	110	0.050	24.0	8.4	2190	330	66.5
20	3	110	0.065	30.0	10.5	1750	340	107.0

3	3	80	0.005	4.5	1.8	8490	125	1.0
4	3	80	0.010	6.0	2.4	6365	190	2.5
5	3	80	0.010	7.5	3.0	5095	155	3.5
6	3	80	0.015	9.0	3.6	4245	190	6.0
8	3	80	0.020	12.0	4.8	3185	190	11.0
10	3	80	0.025	15.0	6.0	2545	190	17.0
12	3	80	0.030	18.0	7.2	2120	190	24.5
16	3	80	0.040	24.0	8.4	1590	190	38.5
20	3	80	0.045	30.0	10.5	1275	170	53.5

3	3	130	0.010	4.5	1.8	13795	415	3.5
4	3	130	0.015	6.0	2.4	10345	465	6.5
5	3	130	0.015	7.5	3.0	8275	370	8.5
6	3	130	0.020	9.0	3.6	6895	415	13.5
8	3	130	0.025	12.0	4.8	5175	390	22.5
10	3	130	0.030	15.0	6.0	4140	375	34.0
12	3	130	0.040	18.0	7.2	3450	415	54.0
16	3	130	0.050	24.0	8.4	2585	390	78.5
20	3	130	0.065	30.0	10.5	2070	405	127.5

## Anwendung



## Werkstoff

Stahl  
< 850 N/mm<sup>2</sup>

Stahl  
850 - 1100 N/mm<sup>2</sup>

Nichtrostender Stahl  
[Cr-Ni/1.4301]

Gusseisen  
GG(G)

d1 [mm]	z	v <sub>c</sub> [m/min]	f <sub>z</sub> [mm]	a <sub>p</sub> [mm]	a <sub>e</sub> [mm]	n [min <sup>-1</sup> ]	v <sub>f</sub> [mm/min]	Q [cm <sup>3</sup> /min]
3	3	130	0.010	3.9	3	13795	415	5.0
4	3	130	0.015	5.2	4	10345	465	9.5
5	3	130	0.015	6.5	5	8275	370	12.0
6	3	130	0.020	7.8	6	6895	415	19.5
8	3	130	0.025	10.4	8	5175	390	32.5
10	3	130	0.025	13.0	10	4140	310	40.5
12	3	130	0.035	15.6	12	3450	360	67.5
16	3	130	0.045	17.6	16	2585	350	98.5
20	3	130	0.060	22.0	20	2070	375	165.0

3	3	85	0.010	3.9	3	9020	270	3.0
4	3	85	0.015	5.2	4	6765	305	6.5
5	3	85	0.015	6.5	5	5410	245	8.0
6	3	85	0.020	7.8	6	4510	270	12.5
8	3	85	0.025	10.4	8	3380	255	21.0
10	3	85	0.025	13.0	10	2705	205	26.5
12	3	85	0.035	15.6	12	2255	235	44.0
16	3	85	0.045	17.6	16	1690	230	65.0
20	3	85	0.060	22.0	20	1355	245	108.0

3	3	65	0.005	3.9	3	6895	105	1.0
4	3	65	0.010	5.2	4	5175	155	3.0
5	3	65	0.010	6.5	5	4140	125	4.0
6	3	65	0.015	7.8	6	3450	155	7.5
8	3	65	0.020	10.4	8	2585	155	13.0
10	3	65	0.025	13.0	10	2070	155	20.0
12	3	65	0.025	15.6	12	1725	130	24.5
16	3	65	0.035	17.6	16	1295	135	38.0
20	3	65	0.040	22.0	20	1035	125	55.0

3	3	110	0.010	3.9	3	11670	350	4.0
4	3	110	0.015	5.2	4	8755	395	8.0
5	3	110	0.015	6.5	5	7005	315	10.0
6	3	110	0.020	7.8	6	5835	350	16.5
8	3	110	0.025	10.4	8	4375	330	27.5
10	3	110	0.025	13.0	10	3500	265	34.5
12	3	110	0.035	15.6	12	2920	305	57.0
16	3	110	0.045	17.6	16	2190	295	83.0
20	3	110	0.060	22.0	20	1750	315	138.5