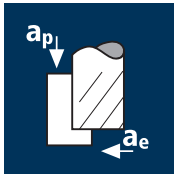




## Anwendung



## Werkstoff

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



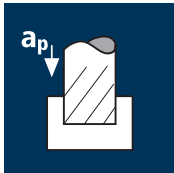
Stahl  
850 - 1100 N/mm<sup>2</sup>



Titanlegierungen ausg.  
> 300 HB  
[Ti6Al4V]



Inox normal  
[Cr-Ni/1.4301]  
[Cr-Ni-Mo/1.4571]



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



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



Titanlegierungen ausg.  
> 300 HB  
[Ti6Al4V]



Inox normal  
[Cr-Ni/1.4301]  
[Cr-Ni-Mo/1.4571]



d1 [mm]	z	v <sub>c</sub> [m/min]	f <sub>s</sub> [mm]	a <sub>p</sub> [mm]	a <sub>e</sub> [mm]	n [min <sup>-1</sup> ]	v <sub>r</sub> [mm/min]	Q [cm <sup>3</sup> /min]
6.00	4	180	0.035	7.200	1.800	9550	1335	17.3
8.00	4	180	0.045	9.600	2.400	7160	1290	29.7
10.00	4	180	0.060	12.000	3.000	5730	1375	49.5
12.00	4	180	0.070	14.400	3.600	4775	1335	69.3
16.00	4	180	0.075	19.200	4.800	3580	1075	99.0
20.00	4	180	0.080	24.000	6.000	2865	915	132.0

6.00	4	130	0.035	7.200	1.800	6895	965	12.5
8.00	4	130	0.045	9.600	2.400	5175	930	21.5
10.00	4	130	0.060	12.000	3.000	4140	995	35.8
12.00	4	130	0.070	14.400	3.600	3450	965	50.1
16.00	4	130	0.075	19.200	4.800	2585	775	71.5
20.00	4	130	0.080	24.000	6.000	2070	660	95.3

6.00	4	45	0.025	7.200	1.800	2385	240	3.1
8.00	4	45	0.035	9.600	2.400	1790	250	5.8
10.00	4	45	0.045	12.000	3.000	1430	260	9.3
12.00	4	45	0.055	14.400	3.600	1195	265	13.6
16.00	4	45	0.060	19.200	4.800	895	215	19.8
20.00	4	45	0.065	24.000	6.000	715	185	26.8

6.00	4	60	0.025	7.200	1.800	3185	320	4.1
8.00	4	60	0.035	9.600	2.400	2385	335	7.7
10.00	4	60	0.045	12.000	3.000	1910	345	12.4
12.00	4	60	0.055	14.400	3.600	1590	350	18.2
16.00	4	60	0.060	19.200	4.800	1195	285	26.4
20.00	4	60	0.065	24.000	6.000	955	250	35.8

6.00	4	150	0.030	3.600	6.000	7960	955	20.6
8.00	4	150	0.040	4.800	8.000	5970	955	36.7
10.00	4	150	0.050	6.000	10.000	4775	955	57.3
12.00	4	150	0.055	7.200	12.000	3980	875	75.6
16.00	4	150	0.055	9.600	16.000	2985	655	100.8
20.00	4	150	0.060	12.000	20.000	2385	575	137.5

6.00	4	80	0.030	3.600	6.000	4245	510	11.0
8.00	4	80	0.040	4.800	8.000	3185	510	19.6
10.00	4	80	0.050	6.000	10.000	2545	510	30.6
12.00	4	80	0.055	7.200	12.000	2120	465	40.3
16.00	4	80	0.055	9.600	16.000	1590	350	53.8
20.00	4	80	0.060	12.000	20.000	1275	305	73.3

6.00	4	35	0.025	3.600	6.000	1855	185	4.0
8.00	4	35	0.030	4.800	8.000	1395	165	6.4
10.00	4	35	0.040	6.000	10.000	1115	180	10.7
12.00	4	35	0.045	7.200	12.000	930	165	14.4
16.00	4	35	0.045	9.600	16.000	695	125	19.3
20.00	4	35	0.050	12.000	20.000	555	110	26.7

6.00	4	50	0.025	3.600	6.000	2655	265	5.7
8.00	4	50	0.030	4.800	8.000	1990	240	9.2
10.00	4	50	0.040	6.000	10.000	1590	255	15.3
12.00	4	50	0.045	7.200	12.000	1325	240	20.6
16.00	4	50	0.045	9.600	16.000	995	180	27.5
20.00	4	50	0.050	12.000	20.000	795	160	38.2