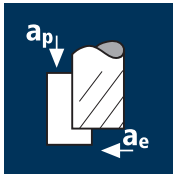


Application



Material

Wrought aluminium
Construction aluminium



Unalloyed copper



Thermoplastics



Cast aluminium



Wrought aluminium
Construction aluminium



Unalloyed copper



Thermoplastics



Cast aluminium



| d_1 [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] |
|---------------|-----|------------------|---------------|---------------|---------------|-----------------------------|-------------------|-------------------------------|
| 3.00 | 3 | 396 | 0.056 | 4.500 | 1.350 | 42015 | 6996 | 42.5 |
| 4.00 | 3 | 500 | 0.074 | 6.000 | 1.800 | 39790 | 8833 | 95.4 |
| 5.00 | 3 | 500 | 0.093 | 7.500 | 2.250 | 31830 | 8833 | 149.1 |
| 6.00 | 3 | 500 | 0.111 | 9.000 | 2.700 | 26525 | 8833 | 214.6 |
| 8.00 | 3 | 500 | 0.148 | 12.000 | 3.600 | 19895 | 8833 | 381.6 |
| 10.00 | 3 | 500 | 0.185 | 15.000 | 4.500 | 15915 | 8833 | 596.2 |
| 12.00 | 3 | 500 | 0.222 | 18.000 | 5.400 | 13265 | 8835 | 858.7 |
| 16.00 | 3 | 500 | 0.237 | 24.000 | 7.200 | 9945 | 7065 | 1220.8 |
| 20.00 | 3 | 500 | 0.278 | 30.000 | 9.000 | 7960 | 6627 | 1789.2 |
| 3.00 | 3 | 375 | 0.041 | 4.500 | 1.350 | 39790 | 4942 | 30.0 |
| 4.00 | 3 | 375 | 0.055 | 6.000 | 1.800 | 29840 | 4942 | 53.4 |
| 5.00 | 3 | 375 | 0.069 | 7.500 | 2.250 | 23875 | 4942 | 83.4 |
| 6.00 | 3 | 375 | 0.083 | 9.000 | 2.700 | 19895 | 4942 | 120.1 |
| 8.00 | 3 | 375 | 0.110 | 12.000 | 3.600 | 14920 | 4942 | 213.5 |
| 10.00 | 3 | 375 | 0.138 | 15.000 | 4.500 | 11935 | 4941 | 333.5 |
| 12.00 | 3 | 375 | 0.166 | 18.000 | 5.400 | 9945 | 4941 | 480.2 |
| 16.00 | 3 | 375 | 0.177 | 24.000 | 7.200 | 7460 | 3953 | 683.1 |
| 20.00 | 3 | 375 | 0.207 | 30.000 | 9.000 | 5970 | 3707 | 1001.0 |
| 3.00 | 3 | 396 | 0.067 | 4.500 | 1.350 | 42015 | 8395 | 51.0 |
| 4.00 | 3 | 500 | 0.089 | 6.000 | 1.800 | 39790 | 10600 | 114.5 |
| 5.00 | 3 | 500 | 0.111 | 7.500 | 2.250 | 31830 | 10599 | 178.9 |
| 6.00 | 3 | 500 | 0.133 | 9.000 | 2.700 | 26525 | 10599 | 257.6 |
| 8.00 | 3 | 500 | 0.178 | 12.000 | 3.600 | 19895 | 10600 | 457.9 |
| 10.00 | 3 | 500 | 0.222 | 15.000 | 4.500 | 15915 | 10599 | 715.5 |
| 12.00 | 3 | 500 | 0.266 | 18.000 | 5.400 | 13265 | 10601 | 1030.5 |
| 16.00 | 3 | 500 | 0.284 | 24.000 | 7.200 | 9945 | 8478 | 1465.0 |
| 20.00 | 3 | 500 | 0.333 | 30.000 | 9.000 | 7960 | 7952 | 2147.0 |
| 3.00 | 3 | 396 | 0.044 | 4.500 | 1.350 | 42015 | 5596 | 34.0 |
| 4.00 | 3 | 400 | 0.059 | 6.000 | 1.800 | 31830 | 5653 | 61.1 |
| 5.00 | 3 | 400 | 0.074 | 7.500 | 2.250 | 25465 | 5653 | 95.4 |
| 6.00 | 3 | 400 | 0.089 | 9.000 | 2.700 | 21220 | 5653 | 137.4 |
| 8.00 | 3 | 400 | 0.118 | 12.000 | 3.600 | 15915 | 5653 | 244.2 |
| 10.00 | 3 | 400 | 0.148 | 15.000 | 4.500 | 12730 | 5652 | 381.5 |
| 12.00 | 3 | 400 | 0.178 | 18.000 | 5.400 | 10610 | 5653 | 549.5 |
| 16.00 | 3 | 400 | 0.189 | 24.000 | 7.200 | 7960 | 4524 | 781.7 |
| 20.00 | 3 | 400 | 0.222 | 30.000 | 9.000 | 6365 | 4239 | 1144.6 |
| 3.00 | 3 | 395 | 0.032 | 4.500 | 3.000 | 41910 | 4012 | 54.2 |
| 4.00 | 3 | 400 | 0.043 | 6.000 | 4.000 | 31830 | 4063 | 97.5 |
| 5.00 | 3 | 400 | 0.053 | 7.500 | 5.000 | 25465 | 4063 | 152.4 |
| 6.00 | 3 | 400 | 0.064 | 9.000 | 6.000 | 21220 | 4063 | 219.4 |
| 8.00 | 3 | 400 | 0.085 | 12.000 | 8.000 | 15915 | 4063 | 390.1 |
| 10.00 | 3 | 400 | 0.106 | 15.000 | 10.000 | 12730 | 4063 | 609.4 |
| 12.00 | 3 | 400 | 0.128 | 18.000 | 12.000 | 10610 | 4063 | 877.6 |
| 16.00 | 3 | 400 | 0.136 | 24.000 | 16.000 | 7960 | 3252 | 1248.6 |
| 20.00 | 3 | 400 | 0.160 | 30.000 | 20.000 | 6365 | 3047 | 1828.1 |
| 3.00 | 3 | 300 | 0.024 | 4.500 | 3.000 | 31830 | 2273 | 30.7 |
| 4.00 | 3 | 300 | 0.032 | 6.000 | 4.000 | 23875 | 2273 | 54.6 |
| 5.00 | 3 | 300 | 0.040 | 7.500 | 5.000 | 19100 | 2273 | 85.3 |
| 6.00 | 3 | 300 | 0.048 | 9.000 | 6.000 | 15915 | 2273 | 122.7 |
| 8.00 | 3 | 300 | 0.063 | 12.000 | 8.000 | 11935 | 2273 | 218.2 |
| 10.00 | 3 | 300 | 0.079 | 15.000 | 10.000 | 9550 | 2273 | 341.0 |
| 12.00 | 3 | 300 | 0.095 | 18.000 | 12.000 | 7960 | 2274 | 491.2 |
| 16.00 | 3 | 300 | 0.102 | 24.000 | 16.000 | 5970 | 1819 | 698.5 |
| 20.00 | 3 | 300 | 0.119 | 30.000 | 20.000 | 4775 | 1705 | 1023.0 |
| 3.00 | 3 | 400 | 0.038 | 4.500 | 3.000 | 42440 | 4876 | 65.8 |
| 4.00 | 3 | 400 | 0.051 | 6.000 | 4.000 | 31830 | 4876 | 117.0 |
| 5.00 | 3 | 400 | 0.064 | 7.500 | 5.000 | 25465 | 4876 | 182.8 |
| 6.00 | 3 | 400 | 0.077 | 9.000 | 6.000 | 21220 | 4876 | 263.3 |
| 8.00 | 3 | 400 | 0.102 | 12.000 | 8.000 | 15915 | 4876 | 468.1 |
| 10.00 | 3 | 400 | 0.128 | 15.000 | 10.000 | 12730 | 4875 | 731.3 |
| 12.00 | 3 | 400 | 0.153 | 18.000 | 12.000 | 10610 | 4876 | 1053.2 |
| 16.00 | 3 | 400 | 0.163 | 24.000 | 16.000 | 7960 | 3902 | 1498.3 |
| 20.00 | 3 | 400 | 0.191 | 30.000 | 20.000 | 6365 | 3656 | 2193.7 |
| 3.00 | 3 | 320 | 0.026 | 4.500 | 3.000 | 33955 | 2601 | 35.1 |
| 4.00 | 3 | 320 | 0.034 | 6.000 | 4.000 | 25465 | 2601 | 62.4 |
| 5.00 | 3 | 320 | 0.043 | 7.500 | 5.000 | 20370 | 2600 | 97.5 |
| 6.00 | 3 | 320 | 0.051 | 9.000 | 6.000 | 16975 | 2600 | 140.4 |
| 8.00 | 3 | 320 | 0.068 | 12.000 | 8.000 | 12730 | 2600 | 249.6 |
| 10.00 | 3 | 320 | 0.085 | 15.000 | 10.000 | 10185 | 2600 | 390.0 |
| 12.00 | 3 | 320 | 0.102 | 18.000 | 12.000 | 8490 | 2601 | 561.8 |
| 16.00 | 3 | 320 | 0.109 | 24.000 | 16.000 | 6365 | 2080 | 798.7 |
| 20.00 | 3 | 320 | 0.128 | 30.000 | 20.000 | 5095 | 1951 | 1170.7 |