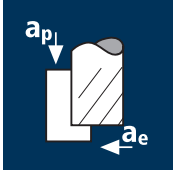




## Application



## Material

Wrought aluminium  
Construction aluminium



| d1<br>[mm] | z | v <sub>c</sub><br>[m/min] | f <sub>s</sub><br>[mm] | a <sub>p</sub><br>[mm] | a <sub>e</sub><br>[mm] | n<br>[min <sup>-1</sup> ] | v <sub>r</sub><br>[mm/min] | Q<br>[cm <sup>3</sup> /min] |
|------------|---|---------------------------|------------------------|------------------------|------------------------|---------------------------|----------------------------|-----------------------------|
| 6.00       | 2 | 650                       | 0.065                  | 9.000                  | 3.300                  | 34485                     | 4485                       | 133.1                       |
| 8.00       | 2 | 650                       | 0.090                  | 12.000                 | 4.400                  | 25865                     | 4655                       | 245.8                       |
| 10.00      | 2 | 650                       | 0.110                  | 15.000                 | 5.500                  | 20690                     | 4550                       | 375.5                       |
| 12.00      | 2 | 650                       | 0.120                  | 18.000                 | 6.600                  | 17240                     | 4140                       | 491.6                       |
| 16.00      | 2 | 650                       | 0.135                  | 24.000                 | 8.800                  | 12930                     | 3490                       | 737.4                       |
| 20.00      | 2 | 650                       | 0.155                  | 30.000                 | 11.000                 | 10345                     | 3205                       | 1058.3                      |

Unalloyed copper



|       |   |     |       |        |        |       |      |       |
|-------|---|-----|-------|--------|--------|-------|------|-------|
| 6.00  | 2 | 500 | 0.050 | 9.000  | 3.300  | 26525 | 2655 | 78.8  |
| 8.00  | 2 | 500 | 0.070 | 12.000 | 4.400  | 19895 | 2785 | 147.1 |
| 10.00 | 2 | 500 | 0.090 | 15.000 | 5.500  | 15915 | 2865 | 236.3 |
| 12.00 | 2 | 500 | 0.095 | 18.000 | 6.600  | 13265 | 2520 | 299.4 |
| 16.00 | 2 | 500 | 0.105 | 24.000 | 8.800  | 9945  | 2090 | 441.2 |
| 20.00 | 2 | 500 | 0.125 | 30.000 | 11.000 | 7960  | 1990 | 656.5 |

Thermoplastics



|       |   |      |       |        |        |       |      |        |
|-------|---|------|-------|--------|--------|-------|------|--------|
| 6.00  | 2 | 792  | 0.065 | 9.000  | 3.300  | 42015 | 5460 | 162.2  |
| 8.00  | 2 | 1056 | 0.090 | 12.000 | 4.400  | 42015 | 7565 | 399.3  |
| 10.00 | 2 | 1200 | 0.110 | 15.000 | 5.500  | 38195 | 8405 | 693.3  |
| 12.00 | 2 | 1200 | 0.120 | 18.000 | 6.600  | 31830 | 7640 | 907.6  |
| 16.00 | 2 | 1200 | 0.135 | 24.000 | 8.800  | 23875 | 6445 | 1361.3 |
| 20.00 | 2 | 1200 | 0.155 | 30.000 | 11.000 | 19100 | 5920 | 1953.8 |

Cast aluminium



|       |   |     |       |        |        |       |      |       |
|-------|---|-----|-------|--------|--------|-------|------|-------|
| 6.00  | 2 | 520 | 0.065 | 9.000  | 3.300  | 27585 | 3585 | 106.5 |
| 8.00  | 2 | 520 | 0.090 | 12.000 | 4.400  | 20690 | 3725 | 196.6 |
| 10.00 | 2 | 520 | 0.110 | 15.000 | 5.500  | 16550 | 3640 | 300.4 |
| 12.00 | 2 | 520 | 0.120 | 18.000 | 6.600  | 13795 | 3310 | 393.3 |
| 16.00 | 2 | 520 | 0.135 | 24.000 | 8.800  | 10345 | 2795 | 589.9 |
| 20.00 | 2 | 520 | 0.155 | 30.000 | 11.000 | 8275  | 2565 | 846.6 |



Wrought aluminium  
Construction aluminium



|       |   |     |       |        |        |       |      |       |
|-------|---|-----|-------|--------|--------|-------|------|-------|
| 6.00  | 2 | 550 | 0.045 | 5.400  | 6.000  | 29180 | 2625 | 85.1  |
| 8.00  | 2 | 550 | 0.060 | 7.200  | 8.000  | 21885 | 2625 | 151.3 |
| 10.00 | 2 | 550 | 0.075 | 9.000  | 10.000 | 17505 | 2625 | 236.3 |
| 12.00 | 2 | 550 | 0.085 | 10.800 | 12.000 | 14590 | 2480 | 321.4 |
| 16.00 | 2 | 550 | 0.095 | 14.400 | 16.000 | 10940 | 2080 | 479.0 |
| 20.00 | 2 | 550 | 0.110 | 18.000 | 20.000 | 8755  | 1925 | 693.3 |

Unalloyed copper



|       |   |     |       |        |        |       |      |       |
|-------|---|-----|-------|--------|--------|-------|------|-------|
| 6.00  | 2 | 450 | 0.040 | 5.400  | 6.000  | 23875 | 1910 | 61.9  |
| 8.00  | 2 | 450 | 0.050 | 7.200  | 8.000  | 17905 | 1790 | 103.1 |
| 10.00 | 2 | 450 | 0.060 | 9.000  | 10.000 | 14325 | 1720 | 154.7 |
| 12.00 | 2 | 450 | 0.070 | 10.800 | 12.000 | 11935 | 1670 | 216.6 |
| 16.00 | 2 | 450 | 0.075 | 14.400 | 16.000 | 8950  | 1345 | 309.4 |
| 20.00 | 2 | 450 | 0.090 | 18.000 | 20.000 | 7160  | 1290 | 464.1 |

Thermoplastics



|       |   |      |       |        |        |       |      |        |
|-------|---|------|-------|--------|--------|-------|------|--------|
| 6.00  | 2 | 792  | 0.045 | 5.400  | 6.000  | 42015 | 3780 | 122.5  |
| 8.00  | 2 | 1000 | 0.060 | 7.200  | 8.000  | 39790 | 4775 | 275.0  |
| 10.00 | 2 | 1000 | 0.075 | 9.000  | 10.000 | 31830 | 4775 | 429.7  |
| 12.00 | 2 | 1000 | 0.085 | 10.800 | 12.000 | 26525 | 4510 | 584.4  |
| 16.00 | 2 | 1000 | 0.095 | 14.400 | 16.000 | 19895 | 3780 | 870.9  |
| 20.00 | 2 | 1000 | 0.110 | 18.000 | 20.000 | 15915 | 3500 | 1260.5 |

Cast aluminium



|       |   |     |       |        |        |       |      |       |
|-------|---|-----|-------|--------|--------|-------|------|-------|
| 6.00  | 2 | 440 | 0.045 | 5.400  | 6.000  | 23345 | 2100 | 68.1  |
| 8.00  | 2 | 440 | 0.060 | 7.200  | 8.000  | 17505 | 2100 | 121.0 |
| 10.00 | 2 | 440 | 0.075 | 9.000  | 10.000 | 14005 | 2100 | 189.1 |
| 12.00 | 2 | 440 | 0.085 | 10.800 | 12.000 | 11670 | 1985 | 257.1 |
| 16.00 | 2 | 440 | 0.095 | 14.400 | 16.000 | 8755  | 1665 | 383.2 |
| 20.00 | 2 | 440 | 0.110 | 18.000 | 20.000 | 7005  | 1540 | 554.6 |