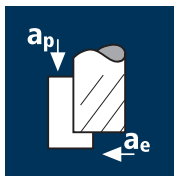


Application



Material

Wrought aluminium
Construction aluminium



| 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 | 3 | 600 | 0.065 | 12.000 | 1.800 | 31830 | 6205 | 134.1 |
| 8.00 | 3 | 600 | 0.090 | 16.000 | 2.400 | 23875 | 6445 | 247.5 |
| 10.00 | 3 | 600 | 0.110 | 20.000 | 3.000 | 19100 | 6305 | 378.2 |
| 12.00 | 3 | 600 | 0.135 | 24.000 | 3.600 | 15915 | 6445 | 556.9 |
| 16.00 | 3 | 600 | 0.180 | 32.000 | 4.800 | 11935 | 6445 | 990.1 |
| 20.00 | 3 | 600 | 0.220 | 40.000 | 6.000 | 9550 | 6305 | 1512.6 |

Unalloyed copper



| | | | | | | | | |
|-------|---|-----|-------|--------|-------|-------|------|--------|
| 6.00 | 3 | 400 | 0.065 | 12.000 | 1.800 | 21220 | 4140 | 89.4 |
| 8.00 | 3 | 400 | 0.090 | 16.000 | 2.400 | 15915 | 4295 | 165.0 |
| 10.00 | 3 | 400 | 0.110 | 20.000 | 3.000 | 12730 | 4200 | 252.1 |
| 12.00 | 3 | 400 | 0.135 | 24.000 | 3.600 | 10610 | 4295 | 371.3 |
| 16.00 | 3 | 400 | 0.180 | 32.000 | 4.800 | 7960 | 4295 | 660.0 |
| 20.00 | 3 | 400 | 0.220 | 40.000 | 6.000 | 6365 | 4200 | 1008.4 |

Thermoplastics



| | | | | | | | | |
|-------|---|-----|-------|--------|-------|-------|------|--------|
| 6.00 | 3 | 650 | 0.065 | 12.000 | 1.800 | 34485 | 6725 | 145.2 |
| 8.00 | 3 | 650 | 0.090 | 16.000 | 2.400 | 25865 | 6985 | 268.1 |
| 10.00 | 3 | 650 | 0.110 | 20.000 | 3.000 | 20690 | 6830 | 409.7 |
| 12.00 | 3 | 650 | 0.135 | 24.000 | 3.600 | 17240 | 6985 | 603.3 |
| 16.00 | 3 | 650 | 0.180 | 32.000 | 4.800 | 12930 | 6985 | 1072.6 |
| 20.00 | 3 | 650 | 0.220 | 40.000 | 6.000 | 10345 | 6830 | 1638.7 |



Wrought aluminium
Construction aluminium



| | | | | | | | | |
|-------|---|-----|-------|--------|--------|-------|------|--------|
| 6.00 | 3 | 500 | 0.060 | 4.200 | 6.000 | 26525 | 4775 | 120.3 |
| 8.00 | 3 | 500 | 0.080 | 5.600 | 8.000 | 19895 | 4775 | 213.9 |
| 10.00 | 3 | 500 | 0.100 | 7.000 | 10.000 | 15915 | 4775 | 334.2 |
| 12.00 | 3 | 500 | 0.120 | 8.400 | 12.000 | 13265 | 4775 | 481.3 |
| 16.00 | 3 | 500 | 0.160 | 11.200 | 16.000 | 9945 | 4775 | 855.6 |
| 20.00 | 3 | 500 | 0.200 | 14.000 | 20.000 | 7960 | 4775 | 1336.9 |

Unalloyed copper



| | | | | | | | | |
|-------|---|-----|-------|--------|--------|-------|------|-------|
| 6.00 | 3 | 270 | 0.060 | 4.200 | 6.000 | 14325 | 2580 | 65.0 |
| 8.00 | 3 | 270 | 0.080 | 5.600 | 8.000 | 10745 | 2580 | 115.5 |
| 10.00 | 3 | 270 | 0.100 | 7.000 | 10.000 | 8595 | 2580 | 180.5 |
| 12.00 | 3 | 270 | 0.120 | 8.400 | 12.000 | 7160 | 2580 | 259.9 |
| 16.00 | 3 | 270 | 0.160 | 11.200 | 16.000 | 5370 | 2580 | 462.0 |
| 20.00 | 3 | 270 | 0.200 | 14.000 | 20.000 | 4295 | 2580 | 721.9 |

Thermoplastics



| | | | | | | | | |
|-------|---|-----|-------|--------|--------|-------|------|--------|
| 6.00 | 3 | 650 | 0.060 | 4.200 | 6.000 | 34485 | 6205 | 156.4 |
| 8.00 | 3 | 650 | 0.080 | 5.600 | 8.000 | 25865 | 6205 | 278.1 |
| 10.00 | 3 | 650 | 0.100 | 7.000 | 10.000 | 20690 | 6205 | 434.5 |
| 12.00 | 3 | 650 | 0.120 | 8.400 | 12.000 | 17240 | 6205 | 625.7 |
| 16.00 | 3 | 650 | 0.160 | 11.200 | 16.000 | 12930 | 6205 | 1112.3 |
| 20.00 | 3 | 650 | 0.200 | 14.000 | 20.000 | 10345 | 6205 | 1738.0 |