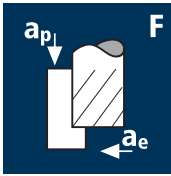


Application



Material

Wrought aluminium
Construction aluminium



Unalloyed copper



Thermoplastics



Cast aluminium



d1 [mm]	z	f _z [mm]	a _p [mm]	a _e [mm]	n=10000 min ⁻¹ vf [mm/min]	n=15000 min ⁻¹ vf [mm/min]	n=20000 min ⁻¹ vf [mm/min]	n=30000 min ⁻¹ vf [mm/min]
6.00	6	0.020	18.000	0.100	1200	1800	2400	3600
8.00	6	0.020	24.000	0.100	1200	1800	2400	3600
10.00	6	0.025	30.000	0.150	1500	2250	3000	4500
12.00	6	0.025	36.000	0.200	1500	2250	3000	4500
16.00	6	0.030	48.000	0.250	1800	2700	3600	5400
20.00	6	0.030	60.000	0.300	1800	2700	3600	5400
6.00	6	0.020	18.000	0.100	1200	1800	2400	3600
8.00	6	0.020	24.000	0.100	1200	1800	2400	3600
10.00	6	0.025	30.000	0.150	1500	2250	3000	4500
12.00	6	0.025	36.000	0.200	1500	2250	3000	4500
16.00	6	0.030	48.000	0.250	1800	2700	3600	5400
20.00	6	0.030	60.000	0.300	1800	2700	3600	5400
6.00	6	0.020	18.000	0.100	1200	1800	2400	3600
8.00	6	0.020	24.000	0.100	1200	1800	2400	3600
10.00	6	0.025	30.000	0.150	1500	2250	3000	4500
12.00	6	0.025	36.000	0.200	1500	2250	3000	4500
16.00	6	0.030	48.000	0.250	1800	2700	3600	5400
20.00	6	0.030	60.000	0.300	1800	2700	3600	5400