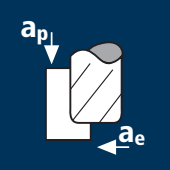




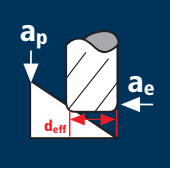






Application	Material	d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]
	Wrought aluminium alloys Si < 6% 	6	3	450	0.085	5.4	2.1	23875	6090	69.0
		8	3	450	0.110	7.2	2.8	17905	5910	119.0
		10	3	450	0.140	9.0	3.5	14325	6015	189.5
		12	3	450	0.155	10.8	4.2	11935	5550	251.5
		16	3	450	0.170	14.4	5.6	8950	4565	368.0
		20	3	450	0.185	18.0	7.0	7160	3975	501.0
		25	3	450	0.205	22.5	8.8	5730	3525	698.0
Unalloyed copper 	6	3	350	0.070	5.4	2.1	18570	3900	44.0	
	8	3	350	0.090	7.2	2.8	13925	3760	76.0	
	10	3	350	0.110	9.0	3.5	11140	3675	116.0	
	12	3	350	0.125	10.8	4.2	9285	3480	158.0	
	16	3	350	0.135	14.4	5.6	6965	2820	227.5	
	20	3	350	0.150	18.0	7.0	5570	2505	315.5	
	25	3	350	0.165	22.5	8.8	4455	2205	434.0	
Thermoplastics 	6	3	800	0.085	5.4	2.1	42440	10820	122.5	
	8	3	800	0.110	7.2	2.8	31830	10505	212.0	
	10	3	800	0.140	9.0	3.5	25465	10695	337.0	
	12	3	800	0.155	10.8	4.2	21220	9865	447.5	
	16	3	800	0.170	14.4	5.6	15915	8115	654.5	
	20	3	800	0.185	18.0	7.0	12730	7065	890.0	
	25	3	800	0.205	22.5	8.8	10185	6265	1233.5	
Cast aluminium Si 6% - 15% 	6	3	300	0.060	5.4	2.1	15915	2865	32.5	
	8	3	300	0.075	7.2	2.8	11935	2685	54.0	
	10	3	300	0.100	9.0	3.5	9550	2865	90.0	
	12	3	300	0.110	10.8	4.2	7960	2625	119.0	
	16	3	300	0.120	14.4	5.6	5970	2150	173.5	
	20	3	300	0.130	18.0	7.0	4775	1860	234.5	
	25	3	300	0.145	22.5	8.8	3820	1660	327.0	

Application	Material	d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	d _{eff} [mm]	n [min ⁻¹]	v _f [mm/min]	β [°]
	Wrought aluminium alloys Si < 6% 	6	3	600	0.110	0.40	0.40	5.98	31940	10540	45°
		8	3	600	0.145	0.45	0.45	7.96	23995	10440	45°
		10	3	600	0.180	0.50	0.50	10.00	19100	10315	45°
		12	3	600	0.195	0.60	0.60	11.97	15955	9335	45°
		16	3	600	0.220	0.75	0.75	15.98	11950	7885	45°
		20	3	600	0.240	1.00	1.00	19.86	9615	6925	45°
		25	3	600	0.265	1.50	1.50	24.65	7750	6160	45°
Unalloyed copper 	6	3	450	0.090	0.40	0.40	5.98	23955	6470	45°	
	8	3	450	0.115	0.45	0.45	7.96	17995	6210	45°	
	10	3	450	0.145	0.50	0.50	10.00	14325	6230	45°	
	12	3	450	0.155	0.60	0.60	11.97	11965	5565	45°	
	16	3	450	0.175	0.75	0.75	15.98	8965	4705	45°	
	20	3	450	0.190	1.00	1.00	19.86	7215	4115	45°	
	25	3	450	0.210	1.50	1.50	24.65	5810	3660	45°	
Thermoplastics 	6	3	1000	0.110	0.40	0.40	5.98	53230	17565	45°	
	8	3	1000	0.145	0.45	0.45	7.96	39990	17395	45°	
	10	3	1000	0.180	0.50	0.50	10.00	31830	17190	45°	
	12	3	1000	0.195	0.60	0.60	11.97	26595	15560	45°	
	16	3	1000	0.220	0.75	0.75	15.98	19920	13145	45°	
	20	3	1000	0.240	1.00	1.00	19.86	16030	11540	45°	
	25	3	1000	0.265	1.50	1.50	24.65	12915	10265	45°	
Cast aluminium Si 6% - 15% 	6	3	400	0.075	0.40	0.40	5.98	21290	4790	45°	
	8	3	400	0.100	0.45	0.45	7.96	15995	4800	45°	
	10	3	400	0.125	0.50	0.50	10.00	12735	4775	45°	
	12	3	400	0.135	0.60	0.60	11.97	10635	4305	45°	
	16	3	400	0.155	0.75	0.75	15.98	7970	3705	45°	
	20	3	400	0.170	1.00	1.00	19.86	6410	3270	45°	
	25	3	400	0.185	1.50	1.50	24.65	5165	2865	45°	