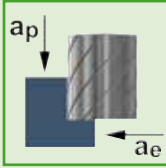
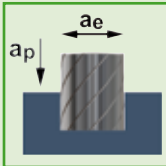


Schnittdatenempfehlung VHM 207 MK10

Parameters recommendation, Paramètres conseillés, Parametri di taglio indicativi



Material	D [mm]	V _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	V _f [mm/min]	Q [cm ³ /min]
Aluminium langspanend <i>Alu long chipping</i> <i>Alu copeaux longs</i> <i>Alluminio truciolo lungo</i>	3	500 (460-560)	0,040 (0,030-0,050)	5,0	1,2	53.050	4.245	25,5
	4	500 (460-560)	0,050 (0,040-0,060)	6,0	1,6	39.790	3.980	38,2
	5	500 (460-560)	0,065 (0,055-0,075)	8,0	2,0	31.830	4.140	66,2
	6	500 (460-560)	0,075 (0,065-0,085)	8,0	2,4	26.530	3.980	76,4
	8	500 (460-560)	0,100 (0,090-0,110)	14,0	3,2	19.890	3.980	178,3
	10	500 (460-560)	0,125 (0,100-0,150)	18,0	4,0	15.920	3.980	286,6
	12	500 (460-560)	0,150 (0,140-0,160)	22,0	4,8	13.260	3.980	420,3
	14	500 (460-560)	0,160 (0,140-0,180)	26,0	5,6	11.370	3.640	530,0
16	500 (460-560)	0,180 (0,160-0,200)	32,0	6,4	9.950	3.580	733,2	
Alu kurzspanend >6% Si <i>Alu short chipping</i> <i>Alu copeaux courts</i> <i>Alluminio truciolo corto</i>	3	480 (400-520)	0,040 (0,030-0,050)	5,0	1,2	50.930	4.075	24,5
	4	480 (400-520)	0,050 (0,040-0,060)	6,0	1,6	38.200	3.820	36,7
	5	480 (400-520)	0,065 (0,055-0,075)	8,0	2,0	30.560	3.975	63,6
	6	480 (400-520)	0,075 (0,065-0,085)	8,0	2,4	25.460	3.820	73,3
	8	480 (400-520)	0,100 (0,090-0,110)	14,0	3,2	19.100	3.820	171,1
	10	480 (400-520)	0,125 (0,100-0,150)	18,0	4,0	15.280	3.820	275,0
	12	480 (400-520)	0,150 (0,140-0,160)	22,0	4,8	12.730	3.820	403,4
	14	480 (460-560)	0,160 (0,140-0,180)	26,0	5,6	10.910	3.490	508,1
16	480 (460-560)	0,180 (0,160-0,200)	32,0	6,4	9.550	3.440	704,5	
Alu Guss >10% Si <i>Cast aluminium</i> <i>Fonte Alu</i> <i>Alluminio fuso</i>	3	250 (200-300)	0,040 (0,030-0,050)	5,0	1,2	26.530	2.120	12,7
	4	250 (200-300)	0,050 (0,040-0,060)	6,0	1,6	19.890	1.990	19,1
	5	250 (200-300)	0,065 (0,055-0,075)	8,0	2,0	15.920	2.070	33,1
	6	250 (200-300)	0,075 (0,065-0,085)	8,0	2,4	13.260	1.990	38,2
	8	250 (200-300)	0,100 (0,090-0,110)	14,0	3,2	9.950	1.990	89,2
	10	250 (200-300)	0,125 (0,100-0,150)	18,0	4,0	7.960	1.990	143,3
	12	250 (200-300)	0,150 (0,140-0,160)	22,0	4,8	6.630	1.990	210,1
	14	250 (200-300)	0,160 (0,140-0,180)	26,0	5,6	5.680	1.820	265,0
16	250 (200-300)	0,180 (0,160-0,200)	32,0	6,4	4.970	1.790	366,6	
CuZn Legierungen <i>CuZn alloys</i> <i>Alliage CuZn</i> <i>Leghe CuZn</i>	3	270 (230-300)	0,040 (0,030-0,050)	5,0	1,2	28.650	2.290	13,7
	4	270 (230-300)	0,050 (0,040-0,060)	6,0	1,6	21.490	2.150	20,6
	5	270 (230-300)	0,065 (0,055-0,075)	8,0	2,0	17.190	2.235	35,8
	6	270 (230-300)	0,075 (0,065-0,085)	8,0	2,4	14.320	2.150	41,3
	8	270 (230-300)	0,100 (0,090-0,110)	14,0	3,2	10.740	2.150	96,3
	10	270 (230-300)	0,125 (0,100-0,150)	18,0	4,0	8.590	2.150	154,8
	12	270 (230-300)	0,150 (0,140-0,160)	22,0	4,8	7.160	2.150	227,0
	14	270 (230-300)	0,160 (0,140-0,180)	26,0	5,6	6.140	1.965	286,1
16	270 (230-300)	0,180 (0,160-0,200)	32,0	6,4	5.370	1.935	396,3	
Thermoplaste <i>Thermoplastics</i> <i>Thermoplastique</i> <i>Termoplastica</i>	3	1.200 (1.100-1.300)	0,040 (0,030-0,050)	5,0	1,2	127.320	10.185	61,1
	4	1.200 (1.100-1.300)	0,050 (0,040-0,060)	6,0	1,6	95.490	9.550	91,7
	5	1.200 (1.100-1.300)	0,065 (0,055-0,075)	8,0	2,0	76.390	9.930	158,9
	6	1.200 (1.100-1.300)	0,075 (0,065-0,085)	8,0	2,4	63.660	9.550	183,4
	8	1.200 (1.100-1.300)	0,100 (0,090-0,110)	14,0	3,2	47.750	9.550	427,8
	10	1.200 (1.100-1.300)	0,125 (0,100-0,150)	18,0	4,0	38.200	9.550	687,6
	12	1.200 (1.100-1.300)	0,150 (0,140-0,160)	22,0	4,8	31.830	9.550	1.008,5
	14	1.200 (1.100-1.300)	0,160 (0,140-0,180)	26,0	5,6	27.280	8.730	1.271,1
16	1.200 (1.100-1.300)	0,180 (0,160-0,200)	32,0	6,4	23.870	8.595	1.760,3	



Material	D [mm]	V _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	V _f [mm/min]	Q [cm ³ /min]
Aluminium langspanend <i>Alu long chipping</i> <i>Alu copeaux longs</i> <i>Alluminio truciolo lungo</i>	3	500 (460-560)	0,015 (0,010-0,030)	1,5	3,0	53.050	1.590	7,2
	4	500 (460-560)	0,020 (0,010-0,050)	2,0	4,0	39.790	1.590	12,7
	5	500 (460-560)	0,035 (0,020-0,050)	2,5	5,0	31.830	2.230	27,9
	6	500 (460-560)	0,050 (0,030-0,060)	3,0	6,0	26.530	2.655	47,8
	8	500 (460-560)	0,060 (0,040-0,070)	4,0	8,0	19.890	2.385	76,3
	10	500 (460-560)	0,080 (0,060-0,100)	5,0	10,0	15.920	2.545	127,3
	12	500 (460-560)	0,100 (0,080-0,120)	6,0	12,0	13.260	2.650	190,8
	14	500 (460-560)	0,120 (0,100-0,140)	7,0	14,0	11.370	2.730	267,5
16	500 (460-560)	0,140 (0,120-0,160)	8,0	16,0	9.950	2.785	356,5	
Alu kurzspanend >6% Si <i>Alu short chipping</i> <i>Alu copeaux courts</i> <i>Alluminio truciolo corto</i>	3	480 (400-520)	0,040 (0,010-0,030)	1,5	3,0	50.930	4.075	18,3
	4	480 (400-520)	0,050 (0,010-0,050)	2,0	4,0	38.200	3.820	30,6
	5	480 (400-520)	0,065 (0,020-0,050)	2,5	5,0	30.560	3.975	49,7
	6	480 (400-520)	0,075 (0,030-0,060)	3,0	6,0	25.460	3.820	68,8
	8	480 (400-520)	0,100 (0,040-0,070)	4,0	8,0	19.100	3.820	122,2
	10	480 (400-520)	0,125 (0,060-0,100)	5,0	10,0	15.280	3.820	191,0
	12	480 (400-520)	0,150 (0,080-0,120)	6,0	12,0	12.730	3.820	275,0
	14	480 (460-560)	0,160 (0,100-0,140)	7,0	14,0	10.910	3.490	342,0
16	480 (460-560)	0,180 (0,120-0,160)	8,0	16,0	9.550	3.440	440,3	
Alu Guss >10% Si <i>Cast aluminium</i> <i>Fonte Alu</i> <i>Alluminio fuso</i>	3	250 (200-300)	0,040 (0,010-0,030)	1,5	3,0	26.530	2.120	9,5
	4	250 (200-300)	0,050 (0,010-0,050)	2,0	4,0	19.890	1.990	15,9
	5	250 (200-300)	0,065 (0,020-0,050)	2,5	5,0	15.920	2.070	25,9
	6	250 (200-300)	0,075 (0,030-0,060)	3,0	6,0	13.260	1.990	35,8
	8	250 (200-300)	0,100 (0,040-0,070)	4,0	8,0	9.950	1.990	63,7
	10	250 (200-300)	0,125 (0,060-0,100)	5,0	10,0	7.960	1.990	99,5
	12	250 (200-300)	0,150 (0,080-0,120)	6,0	12,0	6.630	1.990	143,3
	14	250 (200-300)	0,160 (0,100-0,140)	7,0	14,0	5.680	1.820	178,4
16	250 (200-300)	0,180 (0,120-0,160)	8,0	16,0	4.970	1.790	229,1	
CuZn Legierungen <i>CuZn alloys</i> <i>Alliage CuZn</i> <i>Leghe CuZn</i>	3	270 (230-300)	0,040 (0,010-0,030)	1,5	3,0	28.650	2.290	10,3
	4	270 (230-300)	0,050 (0,010-0,050)	2,0	4,0	21.490	2.150	17,2
	5	270 (230-300)	0,065 (0,020-0,050)	2,5	5,0	17.190	2.235	27,9
	6	270 (230-300)	0,075 (0,030-0,060)	3,0	6,0	14.320	2.150	38,7
	8	270 (230-300)	0,100 (0,040-0,070)	4,0	8,0	10.740	2.150	68,8
	10	270 (230-300)	0,125 (0,060-0,100)	5,0	10,0	8.590	2.150	107,5
	12	270 (230-300)	0,150 (0,080-0,120)	6,0	12,0	7.160	2.150	154,8
	14	270 (230-300)	0,160 (0,100-0,140)	7,0	14,0	6.140	1.965	192,6
16	270 (230-300)	0,180 (0,120-0,160)	8,0	16,0	5.370	1.935	247,7	
Thermoplaste <i>Thermoplastics</i> <i>Thermoplastique</i> <i>Termoplastica</i>	3	1.200 (1.100-1.300)	0,040 (0,010-0,030)	1,5	3,0	127.320	10.185	45,8
	4	1.200 (1.100-1.300)	0,050 (0,010-0,050)	2,0	4,0	95.490	9.550	76,4
	5	1.200 (1.100-1.300)	0,065 (0,020-0,050)	2,5	5,0	76.390	9.930	124,1
	6	1.200 (1.100-1.300)	0,075 (0,030-0,060)	3,0	6,0	63.660	9.550	171,9
	8	1.200 (1.100-1.300)	0,100 (0,040-0,070)	4,0	8,0	47.750	9.550	305,6
	10	1.200 (1.100-1.300)	0,125 (0,060-0,100)	5,0	10,0	38.200	9.550	477,5
	12	1.200 (1.100-1.300)	0,150 (0,080-0,120)	6,0	12,0	31.830	9.550	687,6
	14	1.200 (1.100-1.300)	0,160 (0,100-0,140)	7,0	14,0	27.280	8.730	855,5
16	1.200 (1.100-1.300)	0,180 (0,120-0,160)	8,0	16,0	23.870	8.595	1.100,2	