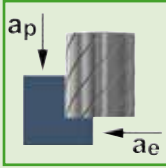
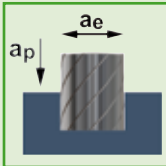


Schnittdatenempfehlung VHM 209 MK10

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)	0,055 (0,030-0,070)	5,0	1,2	53.050	5.835	37,8
	4	500 (460-560)	0,055 (0,030-0,070)	7,0	1,6	39.790	4.375	50,4
	5	500 (460-560)	0,090 (0,070-0,110)	9,0	2,0	31.830	5.730	103,1
	6	500 (460-560)	0,090 (0,070-0,120)	11,0	2,4	26.530	4.775	123,8
	8	500 (460-560)	0,090 (0,070-0,130)	14,0	3,2	19.890	3.580	165,0
	10	500 (460-560)	0,110 (0,090-0,130)	18,0	4,0	15.920	3.500	252,0
	12	500 (460-560)	0,110 (0,090-0,130)	22,0	4,8	13.260	2.915	302,2
	16	500 (460-560)	0,145 (0,120-0,160)	29,0	6,4	9.950	2.885	531,8
Alu kurzspanend >6% Si <i>Alu short chipping</i> <i>Alu copeaux courts</i> <i>Alluminio truciolo corto</i>	3	480 (400-520)	0,055 (0,030-0,070)	5,0	1,2	50.930	5.600	36,3
	4	480 (400-520)	0,055 (0,030-0,070)	7,0	1,6	38.200	4.200	48,4
	5	480 (400-520)	0,090 (0,070-0,110)	9,0	2,0	30.560	5.500	99,0
	6	480 (400-520)	0,090 (0,070-0,120)	11,0	2,4	25.460	4.585	118,8
	8	480 (400-520)	0,090 (0,070-0,130)	14,0	3,2	19.100	3.440	158,5
	10	480 (400-520)	0,110 (0,090-0,130)	18,0	4,0	15.280	3.360	241,9
	12	480 (400-520)	0,110 (0,090-0,130)	22,0	4,8	12.730	2.800	290,3
	16	480 (460-560)	0,145 (0,120-0,160)	29,0	6,4	9.550	2.770	510,6
Alu Guss >10% Si <i>Cast aluminium</i> <i>Fonte Alu</i> <i>Alluminio fuso</i>	3	250 (200-300)	0,055 (0,030-0,070)	5,0	1,2	26.530	2.920	18,9
	4	250 (200-300)	0,055 (0,030-0,070)	7,0	1,6	19.890	2.190	25,2
	5	250 (200-300)	0,090 (0,070-0,110)	9,0	2,0	15.920	2.865	51,6
	6	250 (200-300)	0,090 (0,070-0,120)	11,0	2,4	13.260	2.385	61,8
	8	250 (200-300)	0,090 (0,070-0,130)	14,0	3,2	9.950	1.790	82,5
	10	250 (200-300)	0,110 (0,090-0,130)	18,0	4,0	7.960	1.750	126,0
	12	250 (200-300)	0,110 (0,090-0,130)	22,0	4,8	6.630	1.460	151,4
	16	250 (200-300)	0,145 (0,120-0,160)	29,0	6,4	4.970	1.440	265,4
CuZn Legierungen <i>CuZn alloys</i> <i>Alliage CuZn</i> <i>Leghe CuZn</i>	3	270 (230-300)	0,055 (0,030-0,070)	5,0	1,2	28.650	3.150	20,4
	4	270 (230-300)	0,055 (0,030-0,070)	7,0	1,6	21.490	2.365	27,2
	5	270 (230-300)	0,090 (0,070-0,110)	9,0	2,0	17.190	3.095	55,7
	6	270 (230-300)	0,090 (0,070-0,120)	11,0	2,4	14.320	2.580	66,9
	8	270 (230-300)	0,090 (0,070-0,130)	14,0	3,2	10.740	1.935	89,2
	10	270 (230-300)	0,110 (0,090-0,130)	18,0	4,0	8.590	1.890	136,1
	12	270 (230-300)	0,110 (0,090-0,130)	22,0	4,8	7.160	1.575	163,3
	16	270 (230-300)	0,145 (0,120-0,160)	29,0	6,4	5.370	1.555	286,6
Thermoplaste <i>Thermoplastics</i> <i>Thermoplastique</i> <i>Termoplastica</i>	3	1.200 (1.100-1.300)	0,055 (0,030-0,070)	5,0	1,2	127.320	14.005	90,8
	4	1.200 (1.100-1.300)	0,055 (0,030-0,070)	7,0	1,6	95.490	10.505	121,0
	5	1.200 (1.100-1.300)	0,090 (0,070-0,110)	9,0	2,0	76.390	13.750	247,5
	6	1.200 (1.100-1.300)	0,090 (0,070-0,120)	11,0	2,4	63.660	11.460	297,0
	8	1.200 (1.100-1.300)	0,090 (0,070-0,130)	14,0	3,2	47.750	8.595	396,1
	10	1.200 (1.100-1.300)	0,110 (0,090-0,130)	18,0	4,0	38.200	8.405	605,2
	12	1.200 (1.100-1.300)	0,110 (0,090-0,130)	22,0	4,8	31.830	7.005	726,3
	16	1.200 (1.100-1.300)	0,145 (0,120-0,160)	29,0	6,4	23.870	6.920	1.275,5
20	1.200 (1.100-1.300)	0,190 (0,170-0,210)	36,0	8,0	19.100	7.260	2.090,9	



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)	0,035 (0,020-0,050)	3,0	3,0	53.050	3.715	33,4
	4	500 (460-560)	0,035 (0,020-0,050)	4,0	4,0	39.790	2.785	44,6
	5	500 (460-560)	0,060 (0,045-0,075)	5,0	5,0	31.830	3.820	95,5
	6	500 (460-560)	0,060 (0,045-0,075)	6,0	6,0	26.530	3.185	114,7
	8	500 (460-560)	0,060 (0,045-0,075)	8,0	8,0	19.890	2.385	152,6
	10	500 (460-560)	0,070 (0,055-0,085)	10,0	10,0	15.920	2.230	223,0
	12	500 (460-560)	0,070 (0,055-0,085)	12,0	12,0	13.260	1.855	267,1
	16	500 (460-560)	0,090 (0,075-0,110)	16,0	16,0	9.950	1.790	458,2
Alu kurzspanend >6% Si <i>Alu short chipping</i> <i>Alu copeaux courts</i> <i>Alluminio truciolo corto</i>	3	480 (400-520)	0,035 (0,020-0,050)	3,0	3,0	50.930	3.565	32,1
	4	480 (400-520)	0,035 (0,020-0,050)	4,0	4,0	38.200	2.675	42,8
	5	480 (400-520)	0,060 (0,045-0,075)	5,0	5,0	30.560	3.665	91,6
	6	480 (400-520)	0,060 (0,045-0,075)	6,0	6,0	25.460	3.055	110,0
	8	480 (400-520)	0,060 (0,045-0,075)	8,0	8,0	19.100	2.290	146,6
	10	480 (400-520)	0,070 (0,055-0,085)	10,0	10,0	15.280	2.140	214,0
	12	480 (400-520)	0,070 (0,055-0,085)	12,0	12,0	12.730	1.780	256,3
	16	500 (460-560)	0,090 (0,075-0,110)	16,0	16,0	9.950	1.790	458,2
Alu Guss >10% Si <i>Cast aluminium</i> <i>Fonte Alu</i> <i>Alluminio fuso</i>	3	250 (200-300)	0,035 (0,020-0,050)	3,0	3,0	26.530	1.855	16,7
	4	250 (200-300)	0,035 (0,020-0,050)	4,0	4,0	19.890	1.390	22,2
	5	250 (200-300)	0,060 (0,045-0,075)	5,0	5,0	15.920	1.910	47,8
	6	250 (200-300)	0,060 (0,045-0,075)	6,0	6,0	13.260	1.590	57,2
	8	250 (200-300)	0,060 (0,045-0,075)	8,0	8,0	9.950	1.195	76,5
	10	250 (200-300)	0,070 (0,055-0,085)	10,0	10,0	7.960	1.115	111,5
	12	250 (200-300)	0,070 (0,055-0,085)	12,0	12,0	6.630	930	133,9
	16	250 (200-300)	0,090 (0,075-0,110)	16,0	16,0	4.970	895	229,1
CuZn Legierungen <i>CuZn alloys</i> <i>Alliage CuZn</i> <i>Leghe CuZn</i>	3	270 (230-300)	0,035 (0,020-0,050)	3,0	3,0	28.650	2.005	18,0
	4	270 (230-300)	0,035 (0,020-0,050)	4,0	4,0	21.490	1.505	24,1
	5	270 (230-300)	0,060 (0,045-0,075)	5,0	5,0	17.190	2.065	51,6
	6	270 (230-300)	0,060 (0,045-0,075)	6,0	6,0	14.320	1.720	61,9
	8	270 (230-300)	0,060 (0,045-0,075)	8,0	8,0	10.740	1.290	82,6
	10	270 (230-300)	0,070 (0,055-0,085)	10,0	10,0	8.590	1.205	120,5
	12	270 (230-300)	0,070 (0,055-0,085)	12,0	12,0	7.160	1.000	144,0
	16	270 (230-300)	0,090 (0,075-0,110)	16,0	16,0	5.370	965	247,0
Thermoplaste <i>Thermoplastics</i> <i>Thermoplastique</i> <i>Termoplastica</i>	3	1.200 (1.100-1.300)	0,035 (0,020-0,050)	3,0	3,0	127.320	8.910	80,2
	4	1.200 (1.100-1.300)	0,035 (0,020-0,050)	4,0	4,0	95.490	6.685	107,0
	5	1.200 (1.100-1.300)	0,060 (0,045-0,075)	5,0	5,0	76.390	9.165	229,1
	6	1.200 (1.100-1.300)	0,060 (0,045-0,075)	6,0	6,0	63.660	7.640	275,0
	8	1.200 (1.100-1.300)	0,060 (0,045-0,075)	8,0	8,0	47.750	5.730	366,7
	10	1.200 (1.100-1.300)	0,070 (0,055-0,085)	10,0	10,0	38.200	5.350	535,0
	12	1.200 (1.100-1.300)	0,070 (0,055-0,085)	12,0	12,0	31.830	4.455	641,5
	16	1.200 (1.100-1.300)	0,090 (0,075-0,110)	16,0	16,0	23.870	4.295	1.099,5
20	1.200 (1.100-1.300)	0,120 (0,100-0,140)	20,0	20,0	19.100	4.585	1.834,0	