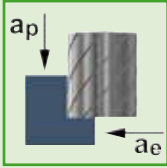
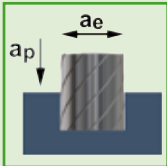


Schnittdatenempfehlung VHM 309 AL05

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)	0,06 (0,040-0,080)	5,0	1,2	53.050	9.550	61,9
	4	500 (460-560)	0,06 (0,040-0,080)	7,0	1,6	39.790	7.160	82,5
	5	500 (460-560)	0,09 (0,070-0,100)	9,0	2,0	31.830	6.595	154,7
	6	500 (460-560)	0,10 (0,080-0,120)	11,0	2,4	26.530	7.960	206,3
	8	500 (460-560)	0,10 (0,080-0,120)	14,0	3,2	19.890	5.965	274,9
	10	500 (460-560)	0,11 (0,090-0,130)	18,0	4,0	15.920	5.255	378,4
	12	500 (460-560)	0,11 (0,090-0,130)	22,0	4,8	13.260	4.375	453,6
	16	500 (460-560)	0,13 (0,110-0,150)	29,0	6,4	9.950	3.880	715,2
Alu kurzspanend >6% Si <i>Alu short chipping</i> <i>Alu copeaux courts</i> <i>Alluminio truciolo corto</i>	3	480 (400-520)	0,06 (0,040-0,080)	5,0	1,2	50.930	9.165	59,4
	4	480 (400-520)	0,06 (0,040-0,080)	7,0	1,6	38.200	6.875	79,2
	5	480 (400-520)	0,09 (0,070-0,100)	9,0	2,0	30.560	8.250	148,5
	6	480 (400-520)	0,10 (0,080-0,120)	11,0	2,4	25.460	7.640	198,0
	8	480 (400-520)	0,10 (0,080-0,120)	14,0	3,2	19.100	5.730	264,0
	10	480 (400-520)	0,10 (0,080-0,120)	18,0	4,0	15.280	4.585	330,1
	12	480 (400-520)	0,10 (0,080-0,120)	22,0	4,8	12.730	3.820	396,1
	16	480 (460-560)	0,13 (0,110-0,150)	29,0	6,4	9.550	3.725	686,6
Alu Guss >10% Si <i>Cast aluminium</i> <i>Fonte Alu</i> <i>Alluminio fuso</i>	3	250 (200-300)	0,06 (0,040-0,080)	5,0	1,2	26.530	4.775	30,9
	4	250 (200-300)	0,06 (0,040-0,080)	7,0	1,6	19.890	3.580	41,2
	5	250 (200-300)	0,08 (0,080-0,120)	9,0	2,0	15.920	3.820	68,8
	6	250 (200-300)	0,09 (0,070-0,110)	11,0	2,4	13.260	3.580	92,8
	8	250 (200-300)	0,09 (0,070-0,110)	14,0	3,2	9.950	2.685	123,7
	10	250 (200-300)	0,09 (0,070-0,110)	18,0	4,0	7.960	2.150	154,8
	12	250 (200-300)	0,09 (0,070-0,110)	22,0	4,8	6.630	1.790	185,6
	16	250 (200-300)	0,15 (0,130-0,170)	29,0	6,4	4.970	2.235	412,0
CuZn Legierungen <i>CuZn alloys</i> <i>Alliage CuZn</i> <i>Leghe CuZn</i>	3	270 (230-300)	0,05 (0,040-0,080)	5,0	1,2	28.650	4.300	27,9
	4	270 (230-300)	0,05 (0,040-0,080)	7,0	1,6	21.490	3.225	37,2
	5	270 (230-300)	0,08 (0,070-0,100)	9,0	2,0	17.190	4.125	74,3
	6	270 (230-300)	0,08 (0,080-0,120)	11,0	2,4	14.320	3.435	89,0
	8	270 (230-300)	0,08 (0,080-0,120)	14,0	3,2	10.740	2.580	118,9
	10	270 (230-300)	0,08 (0,090-0,130)	18,0	4,0	8.590	2.060	148,3
	12	270 (230-300)	0,08 (0,090-0,130)	22,0	4,8	7.160	1.720	178,3
	16	270 (230-300)	0,12 (0,110-0,150)	29,0	6,4	5.370	1.935	356,7
CuZn Legierungen <i>CuZn alloys</i> <i>Alliage CuZn</i> <i>Leghe CuZn</i>	20	270 (230-300)	0,16 (0,140-0,180)	36,0	8,0	4.300	2.065	594,7



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)	0,05 (0,020-0,050)	3,0	3,0	53.050	7.960	71,6
	4	500 (460-560)	0,05 (0,020-0,050)	4,0	4,0	39.790	5.970	95,5
	5	500 (460-560)	0,07 (0,045-0,075)	5,0	5,0	31.830	6.685	167,1
	6	500 (460-560)	0,08 (0,045-0,075)	6,0	6,0	26.530	6.365	229,1
	8	500 (460-560)	0,08 (0,045-0,075)	8,0	8,0	19.890	4.775	305,6
	10	500 (460-560)	0,09 (0,055-0,085)	10,0	10,0	15.920	4.300	430,0
	12	500 (460-560)	0,09 (0,055-0,085)	12,0	12,0	13.260	3.580	515,5
	16	500 (460-560)	0,11 (0,075-0,110)	16,0	16,0	9.950	3.285	841,0
Alu kurzspanend >6% Si <i>Alu short chipping</i> <i>Alu copeaux courts</i> <i>Alluminio truciolo corto</i>	20	500 (460-560)	0,14 (0,100-0,140)	20,0	20,0	7.960	3.345	1.338,0
	3	480 (400-520)	0,05 (0,030-0,070)	3,0	3,0	50.930	7.640	68,8
	4	480 (400-520)	0,05 (0,030-0,070)	4,0	4,0	38.200	5.730	91,7
	5	480 (400-520)	0,07 (0,050-0,090)	5,0	5,0	30.560	6.420	160,5
	6	480 (400-520)	0,08 (0,060-0,100)	6,0	6,0	25.460	6.110	220,0
	8	480 (400-520)	0,08 (0,060-0,100)	8,0	8,0	19.100	4.585	293,4
	10	480 (400-520)	0,08 (0,060-0,100)	10,0	10,0	15.280	3.665	366,5
	12	480 (400-520)	0,08 (0,060-0,100)	12,0	12,0	12.730	3.055	439,9
Alu Guss >10% Si <i>Cast aluminium</i> <i>Fonte Alu</i> <i>Alluminio fuso</i>	16	500 (460-560)	0,11 (0,090-0,130)	16,0	16,0	9.950	3.285	841,0
	20	500 (460-560)	0,18 (0,160-0,200)	20,0	20,0	7.960	4.300	1.720,0
	3	250 (200-300)	0,05 (0,030-0,070)	3,0	3,0	26.530	3.980	35,8
	4	250 (200-300)	0,05 (0,030-0,070)	4,0	4,0	19.890	2.985	47,8
	5	250 (200-300)	0,06 (0,040-0,080)	5,0	5,0	15.920	2.865	71,6
	6	250 (200-300)	0,07 (0,050-0,090)	6,0	6,0	13.260	2.785	100,3
	8	250 (200-300)	0,07 (0,050-0,090)	8,0	8,0	9.950	2.090	133,8
	10	250 (200-300)	0,07 (0,050-0,090)	10,0	10,0	7.960	1.670	167,0
CuZn Legierungen <i>CuZn alloys</i> <i>Alliage CuZn</i> <i>Leghe CuZn</i>	12	250 (200-300)	0,07 (0,050-0,090)	12,0	12,0	6.630	1.390	200,2
	16	250 (200-300)	0,14 (0,120-0,160)	16,0	16,0	4.970	2.085	533,8
	20	250 (200-300)	0,18 (0,160-0,200)	20,0	20,0	3.980	2.150	860,0
	3	270 (230-300)	0,04 (0,020-0,060)	3,0	3,0	28.650	3.440	31,0
	4	270 (230-300)	0,04 (0,020-0,060)	4,0	4,0	21.490	2.580	41,3
	5	270 (230-300)	0,06 (0,040-0,080)	5,0	5,0	17.190	3.095	77,4
	6	270 (230-300)	0,06 (0,040-0,080)	6,0	6,0	14.320	2.580	92,9
	8	270 (230-300)	0,06 (0,040-0,080)	8,0	8,0	10.740	1.935	123,8
CuZn Legierungen <i>CuZn alloys</i> <i>Alliage CuZn</i> <i>Leghe CuZn</i>	10	270 (230-300)	0,06 (0,040-0,080)	10,0	10,0	8.590	1.545	154,5
	12	270 (230-300)	0,06 (0,040-0,080)	12,0	12,0	7.160	1.290	185,8
	16	270 (230-300)	0,10 (0,080-0,120)	16,0	16,0	5.370	1.610	412,2
	20	270 (230-300)	0,14 (0,120-0,160)	20,0	20,0	4.300	1.805	722,0