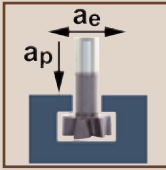
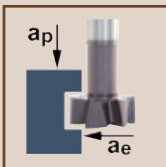


Schnittdatenempfehlung VHM 650W TS35

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]
Baustahl Unlegierter Stahl <i>Structural steel Unalloyed steel</i> Acier de construction Acier non allié Acciaio di costruzione Acciaio non legato <800 N/mm ²	12,5	120 (100-140)	0,04 (0,02-0,09)	6,0	12,5	3.060	370	27,8
	16,0	120 (100-140)	0,05 (0,04-0,12)	8,0	16,0	2.390	360	46,1
	18,0	120 (100-140)	0,06 (0,05-0,13)	8,0	18,0	2.120	380	54,7
	21,0	120 (100-140)	0,06 (0,05-0,14)	9,0	21,0	1.820	330	62,4
	25,0	120 (100-140)	0,07 (0,06-0,16)	11,0	25,0	1.530	320	88,0
	28,0	120 (100-140)	0,08 (0,07-0,18)	12,0	28,0	1.360	330	110,9
Werkzeugstahl Vergütungsstahl Legierter Stahl <i>Tool steel, heat-treatable steel, alloyed steel</i> Acier à outil, acier par traitement thermique, acier allié Acciaio d'utensile, acciaio bonificato, acciaio legato 800-1200 N/mm ²	12,5	100 (80-140)	0,04 (0,02-0,09)	6,0	12,5	2.550	310	23,3
	16,0	100 (80-140)	0,05 (0,04-0,12)	8,0	16,0	1.990	300	38,4
	18,0	100 (80-140)	0,06 (0,05-0,13)	8,0	18,0	1.770	320	46,1
	21,0	100 (80-140)	0,06 (0,05-0,14)	9,0	21,0	1.520	270	51,0
	25,0	100 (80-140)	0,07 (0,06-0,16)	11,0	25,0	1.270	270	74,3
	28,0	100 (80-140)	0,08 (0,07-0,18)	12,0	28,0	1.140	270	90,7
Edelstahl Hochlegierter Stahl <i>High grade steel High alloyed steel</i> Acier noble Acier fortement allié Acciaio superiore Acciaio di alta lega	12,5	80 (50-100)	0,02 (0,02-0,06)	6,0	12,5	2.040	120	9,0
	16,0	80 (50-100)	0,04 (0,02-0,08)	8,0	16,0	1.590	190	24,3
	18,0	80 (50-100)	0,05 (0,03-0,09)	8,0	18,0	1.410	210	30,2
	21,0	80 (50-100)	0,05 (0,03-0,10)	9,0	21,0	1.210	180	34,0
	25,0	80 (50-100)	0,06 (0,04-0,12)	11,0	25,0	1.020	180	49,5
	28,0	80 (50-100)	0,07 (0,05-0,14)	12,0	28,0	910	190	63,8
Gusseisen GG(G) <i>Cast iron GG(G) Fonte GG(G) Ghisa GG(G)</i>	12,5	110 (80-140)	0,04 (0,02-0,09)	6,0	12,5	2.800	340	25,5
	16,0	110 (80-140)	0,05 (0,02-0,12)	8,0	16,0	2.190	330	42,2
	18,0	110 (80-140)	0,06 (0,05-0,13)	8,0	18,0	1.950	350	50,4
	21,0	110 (80-140)	0,06 (0,05-0,14)	9,0	21,0	1.670	300	56,7
	25,0	110 (80-140)	0,07 (0,06-0,16)	11,0	25,0	1.400	290	79,8
	28,0	110 (80-140)	0,08 (0,07-0,18)	12,0	28,0	1.250	300	100,8
32,0	110 (80-140)	0,08 (0,01-0,18)	14,0	32,0	1.090	260	116,5	



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]
Baustahl Unlegierter Stahl <i>Structural steel Unalloyed steel</i> Acier de construction Acier non allié Acciaio di costruzione Acciaio non legato <800 N/mm ²	12,5	120 (100-140)	0,06 (0,04-0,08)	6,0	3,50	3.060	550	11,6
	16,0	120 (100-140)	0,07 (0,05-0,09)	8,0	4,25	2.390	500	17,0
	18,0	120 (100-140)	0,09 (0,07-0,11)	8,0	4,75	2.120	570	21,7
	21,0	120 (100-140)	0,09 (0,07-0,11)	9,0	5,25	1.820	490	23,2
	25,0	120 (100-140)	0,10 (0,08-0,12)	11,0	6,25	1.530	460	31,6
	28,0	120 (100-140)	0,10 (0,08-0,12)	12,0	7,25	1.360	410	35,7
Werkzeugstahl Vergütungsstahl Legierter Stahl <i>Tool steel, heat-treatable steel, alloyed steel</i> Acier à outil, acier par traitement thermique, acier allié Acciaio d'utensile, acciaio bonificato, acciaio legato 800-1200 N/mm ²	12,5	100 (80-140)	0,06 (0,04-0,08)	6,0	3,50	2.550	460	9,7
	16,0	100 (80-140)	0,07 (0,05-0,09)	8,0	4,25	1.990	420	14,3
	18,0	100 (80-140)	0,09 (0,07-0,11)	8,0	4,75	1.770	480	18,2
	21,0	100 (80-140)	0,09 (0,07-0,11)	9,0	5,25	1.520	410	19,4
	25,0	100 (80-140)	0,10 (0,08-0,12)	11,0	6,25	1.270	380	26,1
	28,0	100 (80-140)	0,10 (0,08-0,12)	12,0	7,25	1.140	340	29,6
Edelstahl Hochlegierter Stahl <i>High grade steel High alloyed steel</i> Acier noble Acier fortement allié Acciaio superiore Acciaio di alta lega	12,5	80 (50-100)	0,04 (0,02-0,06)	6,0	3,50	2.040	240	5,0
	16,0	80 (50-100)	0,06 (0,04-0,08)	8,0	4,25	1.590	290	9,9
	18,0	80 (50-100)	0,09 (0,07-0,11)	8,0	4,75	1.410	380	14,4
	21,0	80 (50-100)	0,09 (0,07-0,11)	9,0	5,25	1.210	330	15,6
	25,0	80 (50-100)	0,10 (0,08-0,12)	11,0	6,25	1.020	310	21,3
	28,0	80 (50-100)	0,12 (0,10-0,14)	12,0	7,25	910	330	28,7
Gusseisen GG(G) <i>Cast iron GG(G) Fonte GG(G) Ghisa GG(G)</i>	12,5	110 (80-140)	0,06 (0,04-0,08)	6,0	3,50	2.800	500	10,5
	16,0	110 (80-140)	0,07 (0,05-0,09)	8,0	4,25	2.190	460	15,6
	18,0	110 (80-140)	0,09 (0,07-0,11)	8,0	4,75	1.950	530	20,1
	21,0	110 (80-140)	0,09 (0,07-0,11)	9,0	5,25	1.670	450	21,3
	25,0	110 (80-140)	0,10 (0,08-0,12)	11,0	6,25	1.400	420	28,9
	28,0	110 (80-140)	0,10 (0,08-0,12)	12,0	7,25	1.250	380	33,1
32,0	110 (80-140)	0,10 (0,08-0,12)	14,0	8,25	1.090	330	38,1	