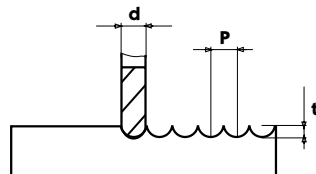


Schruppen

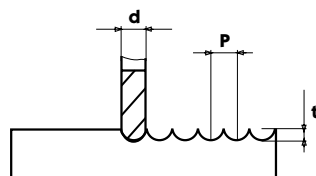


P Zeilensprung = $0,7 \times d_1$

t Schnitttiefe = $0,3 \times d_1$

Härte		150 ~ 200 HB Vc = 90~150 m/min		180 ~ 200 HB Vc = 75~120 m/min		200 ~ 250 HB Vc = 60~90 m/min		25 ~ 40 HB Vc = 50~75 m/min		40 ~ 60 HB Vc = 30~50 m/min	
d_1	r	n (min ⁻¹)	V _f (mm/min)	n (min ⁻¹)	V _f (mm/min)	n (min ⁻¹)	V _f (mm/min)	n (min ⁻¹)	V _f (mm/min)	n (min ⁻¹)	V _f (mm/min)
2	1r	19000	330	15500	230	12000	190	10000	140	6400	120
4	2r	9500	710	7700	350	6000	310	5000	270	3200	140
6	3r	6400	800	5200	510	4000	400	3300	300	2100	150
8	4r	4800	890	3900	600	3000	460	2500	330	1600	180
10	5r	3800	1040	3100	600	2400	460	2000	330	1500	200
12	6r	3200	1100	2600	600	2000	490	1700	380	1300	210
16	8r	2400	1320	2000	600	1500	490	1250	380	800	270
20	10r	1900	1350	1600	600	1200	490	1000	380	650	270

Schlichten

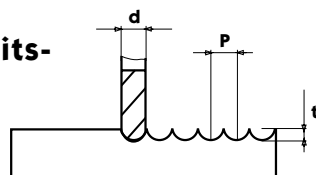


P Zeilensprung = $0,1 \times d_1$

t Schnitttiefe = $0,1 \times d_1$

Härte		150 ~ 200 HB Vc = 150~200 m/min		180 ~ 200 HB Vc = 100~150 m/min		200 ~ 250 HB Vc = 80~150 m/min		25 ~ 40 HB Vc = 75~140 m/min		40 ~ 60 HB Vc = 50~75 m/min	
d_1	r	n (min ⁻¹)	V _f (mm/min)	n (min ⁻¹)	V _f (mm/min)	n (min ⁻¹)	V _f (mm/min)	n (min ⁻¹)	V _f (mm/min)	n (min ⁻¹)	V _f (mm/min)
2	1r	28000	680	20000	450	18000	300	17000	150	10000	120
4	2r	14000	900	10000	750	9000	490	8500	230	5000	150
6	3r	9300	1200	6600	900	6000	640	5700	380	3300	180
8	4r	7000	1500	5000	980	4600	680	4300	380	2500	200
10	5r	5600	1700	4000	1050	3700	750	3400	450	2000	240
12	6r	4600	1700	3300	1050	3000	820	2850	600	1650	240
16	8r	3500	1800	2500	1200	2300	900	2150	600	1250	300
20	10r	2800	1800	2000	1200	1850	900	1700	600	1000	300

Hochgeschwindigkeitsbearbeitung



P Zeilensprung = $0,05 \times d_1$

t Schnitttiefe = $0,02 \times d_1$

Härte		150 ~ 200 HB Vc = 300~400 m/min		180 ~ 200 HB Vc = 200~300 m/min		200 ~ 250 HB Vc = 180~280 m/min		25 ~ 40 HB Vc = 150~240 m/min		40 ~ 60 HB Vc = 100~150 m/min	
d_1	r	n (min ⁻¹)	V _f (mm/min)	n (min ⁻¹)	V _f (mm/min)	n (min ⁻¹)	V _f (mm/min)	n (min ⁻¹)	V _f (mm/min)	n (min ⁻¹)	V _f (mm/min)
6	3r	19000	6600	13000	5600	12000	5200	10000	5000	6600	2600
10	5r	11000	4000	8000	3600	7400	3200	6200	2900	4000	1600
12	6r	9300	3300	6600	2800	6100	2600	5200	2400	3300	1300
16	8r	7000	2500	5000	2100	4600	2000	3900	1800	2500	1000
20	10r	5600	2000	4000	1600	3700	1500	3100	1400	2000	800