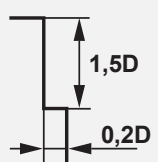
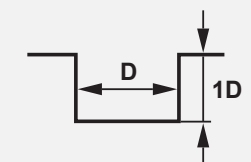


AL2D-2 / AL2D-2DLC

Schnittdatenempfehlungen
Cutting data recommendations



| Material | Aluminium aluminum A1070 | | | | Aluminiumlegierung aluminum alloy A2017 / A5052 / A7075 | | | | Aluminiumguss aluminum cast AC8C | | | |
|---|--|------------------|-------------------------|------------------|---|------------------|-------------------------|------------------|--|------------------|-------------------------|------------------|
| Geschwindigkeit speed | 340 m/min | | 270 m/min | | 380 m/min | | 300 m/min | | 280 m/min | | 200 m/min | |
| Ø | Besäumen side milling | | Nutenfräsen slotting | | Besäumen side milling | | Nutenfräsen slotting | | Besäumen side milling | | Nutenfräsen slotting | |
| | Drehzahl rpm | Vorschub feed | Drehzahl rpm | Vorschub feed | Drehzahl rpm | Vorschub feed | Drehzahl rpm | Vorschub feed | Drehzahl rpm | Vorschub feed | Drehzahl rpm | Vorschub feed |
| | min ⁻¹ | mm / min | min ⁻¹ | mm / min | min ⁻¹ | mm / min | min ⁻¹ | mm / min | min ⁻¹ | mm / min | min ⁻¹ | mm / min |
| 0,50 | 20.000 | 400 | 20.000 | 200 | 20.000 | 400 | 20.000 | 300 | 20.000 | 400 | 20.000 | 300 |
| 1,00 | 20.000 | 700 | 20.000 | 400 | 20.000 | 700 | 20.000 | 400 | 20.000 | 700 | 20.000 | 400 |
| 1.50 | 20.000 | 800 | 20.000 | 500 | 20.000 | 800 | 20.000 | 500 | 20.000 | 800 | 20.000 | 500 |
| 2,00 | 20.000 | 1000 | 20.000 | 600 | 20.000 | 1000 | 20.000 | 600 | 20.000 | 1000 | 20.000 | 600 |
| 2.50 | 20.000 | 1200 | 20.000 | 700 | 20.000 | 1200 | 20.000 | 700 | 20.000 | 1200 | 20.000 | 700 |
| 3,00 | 20.000 | 1300 | 20.000 | 800 | 20.000 | 1500 | 20.000 | 900 | 20.000 | 1500 | 20.000 | 800 |
| 4,00 | 20.000 | 1500 | 20.000 | 900 | 20.000 | 1700 | 20.000 | 1100 | 20.000 | 1700 | 15.900 | 800 |
| 5,00 | 20.000 | 1700 | 17.200 | 900 | 20.000 | 2000 | 19.100 | 1300 | 17.800 | 1700 | 12.700 | 800 |
| 6,00 | 18.000 | 1800 | 14.300 | 900 | 20.000 | 2200 | 15.900 | 1300 | 14.900 | 1700 | 10.600 | 800 |
| 7,00 | 15.500 | 1800 | 12.300 | 900 | 17.300 | 2300 | 13.600 | 1300 | 12.700 | 1700 | 9.100 | 800 |
| 8,00 | 13.500 | 1800 | 10.700 | 1000 | 15.100 | 2400 | 11.900 | 1300 | 11.100 | 1800 | 8.000 | 800 |
| 9,00 | 12.000 | 1800 | 9.600 | 1000 | 13.400 | 2400 | 10.600 | 1300 | 9.900 | 1800 | 7.100 | 800 |
| 10,00 | 10.800 | 1800 | 8.600 | 1000 | 12.100 | 2400 | 9.600 | 1300 | 8.900 | 1800 | 6.400 | 800 |
| 11,00 | 9.800 | 1900 | 7.800 | 1000 | 11.000 | 2500 | 8.700 | 1300 | 8.100 | 1800 | 5.800 | 800 |
| 12,00 | 9.000 | 2000 | 7.200 | 1100 | 10.100 | 2500 | 8.000 | 1400 | 7.400 | 1800 | 5.300 | 900 |
| Schnitttiefe depth of cut D = Ø | <div><div><div>Besäumen side milling</div><div></div></div><div><div>Nutenfräsen slotting</div><div></div></div></div> | | | | | | | | | | | |