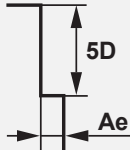
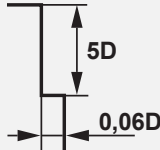


| Material | Kohlenstoffstähle carbon steels S50C | | legierte Stähle alloy steels SCM / SKD / SUS | | vorvergütete Stähle prehardened steels HPM / NAK | | Kupfer copper | |
|---|---|------------------|--|------------------|--|------------------|--|------------------|
| Geschwindigkeit speed | 15 ~ 25 m/min | | 10 ~ 20 m/min | | 10 ~ 15 m/min | | 15 ~ 35 m/min | |
| Ø | 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 |
| 0,30 | 21.200 | 40 | 15.900 | 30 | 13.300 | 25 | 26.500 | 80 |
| 0,40 | 15.900 | 50 | 11.900 | 35 | 9.900 | 30 | 19.900 | 80 |
| 0,50 | 12.700 | 50 | 9.500 | 35 | 8.000 | 30 | 15.900 | 80 |
| 1,00 | 6.400 | 65 | 4.800 | 40 | 4.000 | 35 | 8.000 | 100 |
| 1,50 | 4.200 | 65 | 3.200 | 40 | 2.700 | 35 | 5.300 | 110 |
| 2,00 | 3.200 | 65 | 2.400 | 45 | 2.000 | 40 | 4.000 | 120 |
| 2,50 | 2.500 | 75 | 1.900 | 45 | 1.600 | 40 | 3.200 | 130 |
| 3,00 | 2.100 | 85 | 1.600 | 50 | 1.300 | 45 | 2.700 | 140 |
| 4,00 | 1.600 | 95 | 1.200 | 50 | 1.000 | 45 | 2.000 | 140 |
| 5,00 | 1.300 | 100 | 1.000 | 60 | 800 | 55 | 1.600 | 140 |
| 6,00 | 1.100 | 110 | 800 | 65 | 700 | 60 | 1.300 | 140 |
| 7,00 | 900 | 100 | 700 | 60 | 600 | 55 | 1.100 | 135 |
| 8,00 | 800 | 95 | 600 | 60 | 500 | 55 | 1.000 | 130 |
| 9,00 | 700 | 90 | 550 | 60 | 450 | 50 | 900 | 125 |
| 10,00 | 600 | 85 | 500 | 60 | 400 | 50 | 800 | 120 |
| 12,00 | 500 | 80 | 400 | 55 | 300 | 45 | 700 | 120 |
| Schnitttiefe depth of cut D = Ø | Besäumen side milling  Ae Ø0,3~0,8 = 0,02D Ø1,0~2,5 = 0,03D Ø3,0~12,0 = 0,06D | | | | | | Besäumen side milling  0,06D | |
| | | | | | | | | |