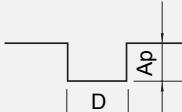
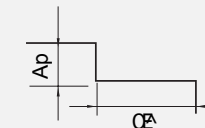


Material		ABS-Kunststoffe ABS plastics				Acryl / Polyacetal acrylic / polyacetal				Polycarbonat polycarbonate			
Ø	Eingriffstiefe effective length	Drehzahl rpm	Vorschub feed	Schnitttiefe depth of cut		Drehzahl rpm	Vorschub feed	Schnitttiefe depth of cut		Drehzahl rpm	Vorschub feed	Schnitttiefe depth of cut	
		min ⁻¹	mm / min	Ap (mm)	Ae (mm)	min ⁻¹	mm / min	Ap (mm)	Ae (mm)	min ⁻¹	mm / min	Ap (mm)	Ae (mm)
1,00	10,00	6.360	560	0,300	0,030	10.812	264	0,300	0,030	8.250	1568	0,300	0,030
	15,00	6.360	560	0,300	0,020	9.328	172	0,300	0,020	7.360	1120	0,300	0,020
	20,00	6.360	560	0,300	0,010	8.056	103	0,300	0,010	6.750	840	0,300	0,010
1,50	10,00	6.360	851	0,500	0,050	10.812	370	0,500	0,050	7.950	1568	0,500	0,050
	15,00	6.360	818	0,500	0,030	9.328	280	0,500	0,030	7.102	1120	0,500	0,030
	20,00	6.254	784	0,500	0,020	8.056	202	0,500	0,020	6.466	840	0,500	0,020
2,00	10,00	6.330	1100	1,000	0,100	10.339	471	1,000	0,100	8.124	1795	1,000	0,100
	15,00	6.225	1043	1,000	0,050	9.284	404	1,000	0,050	7.491	1571	1,000	0,050
	20,00	6.014	999	1,000	0,030	8.440	337	1,000	0,030	6.858	1346	1,000	0,030
	25,00	5.908	954	1,000	0,030	7.596	281	1,000	0,030	6.330	1234	1,000	0,030
3,00	20,00	5.863	1466	1,500	0,200	6.701	496	1,500	0,200	6.596	2030	1,500	0,200
	30,00	5.444	1241	1,500	0,100	4.712	327	1,500	0,100	5.026	1354	1,500	0,100
4,00	20,00	5.026	1579	2,000	0,300	6.282	496	2,000	0,300	5.340	1466	2,000	0,300
	30,00	4.712	1466	2,000	0,200	4.921	384	2,000	0,200	4.607	1241	2,000	0,200
6,00	30,00	3.186	1224	3,000	0,400	3.451	306	3,000	0,400	2.522	969	3,000	0,400
	40,00	2.791	1093	3,000	0,300	2.411	209	3,000	0,300	2.157	823	3,000	0,300
8,00	40,00	2.568	1028	4,000	0,500	2.218	196	4,000	0,500	1.984	774	4,000	0,500
	50,00	1.977	863	4,000	0,400	1.708	165	4,000	0,400	1.528	650	4,000	0,400
10,00	50,00	1.740	803	5,000	0,600	1.503	153	5,000	0,600	1.345	604	5,000	0,600
	60,00	1.305	337	5,000	0,500	1.127	64	5,000	0,500	1.008	254	5,000	0,500
12,00	60,00	1.109	307	6,000	0,600	958	59	6,000	0,600	857	231	6,000	0,600
Schnitttiefe depth of cut		<div> <div>Nutenfräsen slotting</div>  </div> <div> <div>Umsäumen side milling</div>  </div>											