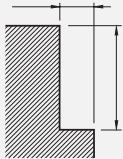
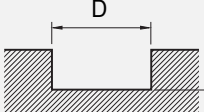
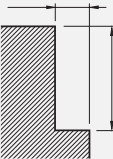
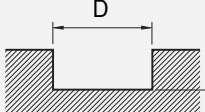


Material	Aluminiumlegierungen aluminum alloys				Aluminiumlegierungen aluminum alloys			
	Umsäumen / side milling		Nutenfräsen / slotting		Umsäumen / side milling		Nutenfräsen / slotting	
Ø	Drehzahl rpm	Vorschub feed	Drehzahl rpm	Vorschub feed	Drehzahl rpm	Vorschub feed	Drehzahl rpm	Vorschub feed
	min ⁻¹	mm / min	min ⁻¹	mm / min	min ⁻¹	mm / min	min ⁻¹	mm / min
1,00	34.000	500	34.000	400	34.000	400	34.000	300
2,00	34.000	950	32.300	720	32.300	720	27.200	470
3,00	27.200	1200	21.300	800	21.300	800	18.000	510
4,00	20.400	1300	16.000	850	16.000	850	14.000	550
5,00	16.200	1400	13.000	850	13.000	850	11.000	600
6,00	13.600	1600	11.000	940	11.000	940	9.400	640
8,00	10.200	1600	8.000	1000	8.000	1000	6.800	680
10,00	8.100	1600	6.500	1000	6.500	1000	5.400	680
12,00	6.800	1600	5.400	1000	5.400	1000	4.500	680
16,00	5.100	1600	4.100	1000	4.100	1000	3.400	610
20,00	4.100	1300	3.200	850	3.200	850	2.700	560
Schnitttiefe depth of cut	0,20D (D < Ø3,00) 0,50D (D ≥ Ø3,00)  ≤ 1,00D		 D ≤ 1,00D Max. 12,00mm		0,20D (D < Ø3,00) 0,50D (D ≥ Ø3,00)  ≤ 1,00D		 D ≤ 1,00D Max. 12,00mm	