

Schnittgeschwindigkeitsübersicht

dopa Topfwerkzeuge



Werkzeug- durchmesser in mm	Empfohlener Bereich										
	10 m/sec.	12,5 m/sec.	15 m/sec.	17,5 m/sec.	20 m/sec.	22,5 m/sec.	25 m/sec.	27,5 m/sec.	30 m/sec.	32,5 m/sec.	35 m/sec.
10	19.099	23.874	28.649	33.424	38.198	42.973	47.748	52.523	57.297	62.072	66.847
15	12.733	15.916	19.099	22.282	25.466	28.649	31.832	35.015	38.198	41.382	44.565
20	9.550	11.937	14.324	16.712	19.099	21.487	23.874	26.261	28.649	31.036	33.424
25	7.640	9.550	11.459	13.369	15.279	17.189	19.099	21.009	22.919	24.829	26.739
30	6.366	7.958	9.550	11.141	12.733	14.324	15.916	17.508	19.099	20.691	22.282
35	5.457	6.821	8.185	9.550	10.914	12.278	13.642	15.006	16.371	17.735	19.099
40	4.775	5.968	7.162	8.356	9.550	10.743	11.937	13.131	14.324	15.518	16.712
50	3.820	4.775	5.730	6.685	7.640	8.595	9.550	10.505	11.459	12.414	13.369
60	3.183	3.979	4.775	5.571	6.366	7.162	7.958	8.754	9.550	10.345	11.141
70	2.728	3.411	4.093	4.775	5.457	6.139	6.821	7.503	8.185	8.867	9.550
80	2.387	2.984	3.581	4.178	4.775	5.372	5.968	6.565	7.162	7.759	8.356
90	2.122	2.653	3.183	3.714	4.244	4.775	5.305	5.836	6.366	6.897	7.427
100	1.910	2.387	2.865	3.342	3.820	4.297	4.775	5.252	5.730	6.207	6.685
125	1.528	1.910	2.292	2.674	3.056	3.438	3.820	4.202	4.584	4.966	5.348
150	1.273	1.592	1.910	2.228	2.547	2.865	3.183	3.502	3.820	4.138	4.456

dopa Entwicklungsgesellschaft für
Oberflächenbearbeitungstechnologie mbH
Zu den Krugwiesen 1
13057 Berlin / Germany

fon +49(0) 30 58 58 428 00
fax +49(0) 30 58 58 428 99
info@dopa-diatools.com
www.dopa-diatools.com