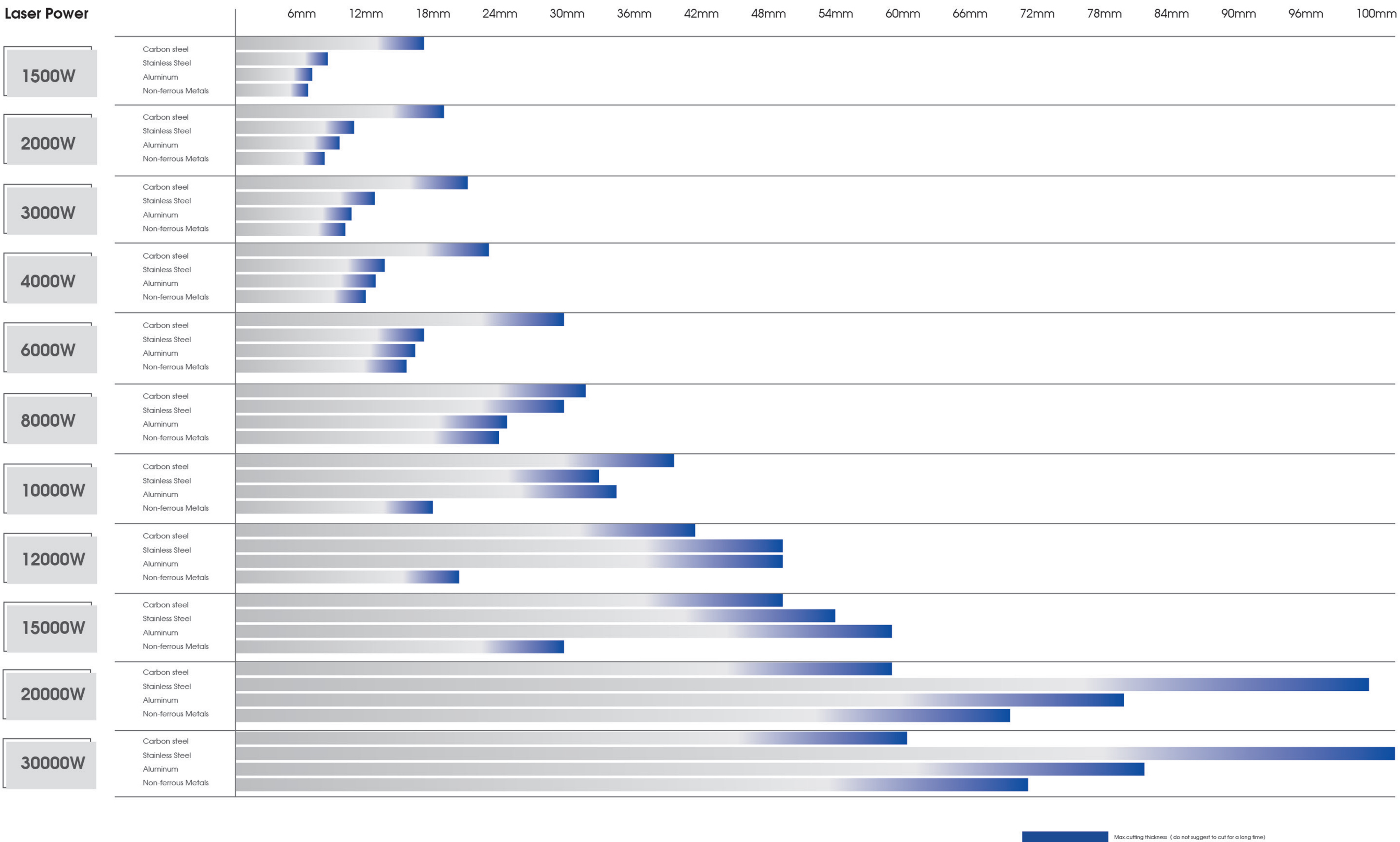


Analyse der Schnittfähigkeit



Parametereinstellungen (Richtwert)

Material	Thickness (mm)	1500W	2000W	3000W	4000W	6000W	8000W	12000W	15000W	20000W	30000W	40000W
		Speed (m/min)	Speed (m/min)	Speed (m/min)	Speed (m/min)	Speed (m/min)	Speed (m/min)	Speed (m/min)	Speed (m/min)	Speed (m/min)	Speed (m/min)	Speed (m/min)
Carbon Steel Air	1	15.0-20.0	25.0-30.0	28.0-35.0	30.0-38.0	35.0-42.0	38.0-45.0	45.0-50.0	50.0-60.0	60.0-70.0	70.0-100.0	75.0-100.0
	2	5.0-8.0	7.0-10.0	8.0-12.0	10.0-16.0	20.0-28.0	25.0-30.0	35.0-48.0	45.0-52.0	50.0-70.0	60.0-73.0	65.0-80.0
	3	1.5-3.0	2.0-4.0	3.0-5.0	3.0-5.0	8.0-15.0	10.0-20.0	25.0-38.0	30.0-40.0	40.0-50.0	50.0-57.0	55.0-65.0
	4			1.5-2.3	2.5-3.5	7.0-12.0	15.0-18.0	18.0-26.0	25.0-29.0	30.0-40.0	35.0-43.0	38.0-50.0
	5				2.5-4.0	5.0-9.0	10.0-12.0	12.0-20.0	18.0-23.0	23.0-28.0	25.0-30.0	28.0-32.0
	6				3.0-6.0	8.0-9.0	10.0-12.0	13.0-19.0	18.0-23.0	23.0-28.0	19.0-26.0	25.0-28.0
	8					6.0-8.0	8.0-12.0	12.0-16.0	14.0-18.0	12.0-16.0	14.0-18.0	22.0-24.0
	10					5.6-5.5	6.0-8.5	11.0-13.0	12.0-14.0	16.0-20.0	16.0-20.0	16.0-20.0
	12					5.0-4.6	5.0-4.6	7.0-10.0	10.0-12.0	10.0-12.0	14.0-17.0	14.0-17.0
	16							4.5-5.5	4.5-5.5	6.5-7.0	8.0-8.5	8.0-9.5
	20								2.7-3.2	2.7-3.2	4.5-5.5	7.0-8.0
	22										2.5-3.5	5.5-7.5
	25										2.0-3.2	5.0-5.5
30											3.0-4.0	
40											1.5-2.0	
50											0.7-1.0	
Carbon N ₂	1	18.0-25.0	22.0-30.0	25.0-38.0	30.0-44.0	35.0-48.0	60.0-70.0	66.0-80.0	70.0-90.0	80.0-95.0	83.0-100.0	86.0-100.0
	2	3.8-5.0	5.0-6.0	5.5-7.0	5.5-7.7	6.0-8.25	6.8-7.2	7.2-7.8	7.5-8.2	7.8-8.5	8.0-10.0	8.5-10.0
	3	2.8-3.8	3.5-4.3	3.6-5.0	3.7-5.5	4.0-5.5	4.8-5.5	5.2-5.8	5.5-6.0	5.8-6.3	6.0-7.0	6.5-7.2
	4	2.3-3.5	2.8-4.0	3.0-4.5	3.5-4.6	3.9-5.0	3.8-4.3	4.2-4.6	4.5-5.2	4.8-5.5	5.0-6.5	5.3-6.8
	5	1.6-2.5	2.0-3.0	2.5-3.3	2.5-4.0	3.0-4.2	3.3-4.3	3.8-4.7	4.0-5.0	4.3-4.8	4.5-5.0	5.0-5.6
	6	1.4-1.8	2.2-2.5	2.3-2.8	2.5-3.5	2.6-3.5	3.0-3.4	3.5-4.0	3.8-4.3	4.0-4.5	4.2-4.8	4.7-5.2
	8	0.9-1.3	1.3-1.8	1.8-2.2	2.0-2.8	2.3-3.0	2.6-3.3	2.6-3.3	2.8-3.5	3.0-3.6	3.5-4.0	4.2-4.8
	10	0.8-1.2	1.2-1.5	1.2-1.6	1.2-2.2	1.8-2.3	2.0-2.5	2.0-2.5	2.3-3.0	2.8-3.2	3.0-3.5	3.5-4.0
	12	0.7-1.0	0.8-1.0	1.0-1.3	1.0-1.7	1.6-2.1	1.7-2.2	2.0-2.3	2.5-3.0	2.7-3.2	2.8-3.4	3.5-4.0
	16	0.5-0.7	0.6-0.8	0.6-0.9	0.7-1.0	1.2-1.4	1.4-1.6	1.4-1.6	1.7-2.0	1.9-2.3	2.0-2.5	2.6-3.2
	20			0.5-0.8	0.6-0.9	0.5-0.9	1.0-1.1	1.2-1.5	1.3-1.6	1.5-1.8	1.6-2.0	1.8-2.2
	22				0.5-0.7	0.5-0.7	0.9-1.0	0.9-1.2	1.1-1.3	1.3-1.6	1.5-1.8	1.6-1.9
	25					0.6-0.7	0.6-0.9	0.9-1.2	1.0-1.4	1.0-1.4	1.3-1.5	1.4-1.5
30					0.4-0.6	0.3-0.6	0.3-0.6	0.5-0.8	0.6-0.8	0.8-1.2	1.2-1.3	
40							0.25-0.33	0.4-0.7	0.7-0.9	0.9-1.1	0.9-1.1	
50							0.18-0.2	0.2-0.25	0.3-0.5	0.4-0.8	0.8-1.0	
60								0.18-0.2	0.2-0.25	0.22-0.28	0.6-0.9	
70								0.19-0.22	0.18-0.22	0.5-0.7	0.4-0.6	
80									0.12-0.15	0.12-0.15	0.3-0.4	
90											0.2-0.3	
100											0.2-0.3	
Carbon Steel O ₂	1	18.0-30.0	20.0-35.0	32.0-40.0	35.0-50.0	55.0-70.0	65.0-75.0	70.0-85.0	80.0-95.0	83.0-100.0	85.0-100.0	87.0-100.0
	2	8.0-12.0	10.0-15.0	14.0-18.0	16.0-23.0	22.0-45.0	40.0-50.0	48.0-55.0	55.0-70.0	65.0-70.0	65.0-80.0	68.0-80.0
	3	3.0-4.0	5.0-7.0	8.0-12.0	8.0-14.0	8.0-20.0	20.0-28.0	30.0-38.0	35.0-40.0	45.0-52.0	55.0-60.0	56.0-65.0
	4	2.0-3.0	3.5-4.5	5.5-8.0	6.0-10.0	10.0-18.0	15.0-20.0	25.0-30.0	25.0-29.0	30.0-40.0	38.0-45.0	40.0-50.0
	5	1.2-1.8	1.8-2.5	3.5-5.0	4.5-6.0	10.0-15.0	12.0-16.0	16.0-19.0	18.0-23.0	23.0-28.0	27.0-33.0	29.0-32.0
	6	0.5-0.8	0.7-0.8	2.8-4.8	2.8-4.8	7.0-10.0	9.0-11.0	14.0-19.0	14.0-19.0	18.0-23.0	24.0-28.0	25.0-30.0
	8		0.5	1.2-1.5	1.5-6.0	4.5-6.0	8.0-11.0	8.0-11.0	10.0-12.0	14.0-16.0	20.0-25.0	22.0-25.0
	10			0.8-1.2	0.85-1.8	2.0-3.0	4.0-4.5	6.5-8.0	6.8-8.5	9.0-12.0	15.0-20.0	17.0-23.0
	12				0.65-1.0	1.4-1.8	2.5-3.5	5.5-6.0	5.5-6.5	8.0-10.0	12.5-15.0	15.0-18.0
	16					1.3-2.0	1.8-2.8	4.5-5.5	4.5-5.5	8.0-9.0	10.0-11.0	10.0-11.0
	20					0.5	0.7-1.0	1.5-2.0	1.9-2.1	2.7-3.2	4.5-5.5	7.0-9.0
	25						0.5-0.8	0.8-1.2	1.2-1.4	1.8-2.5	2.5-3.0	5.0-5.5
	30						0.25-0.4	0.5-0.8	0.8-1.0	1.5-2.2	3.5-4.5	7.0-9.0
40							0.4-0.5	0.4-0.5	0.5-0.8	0.8-1.0	1.7-2.2	
50							0.3-0.4	0.3-0.4	0.3-0.4	0.3-0.4	0.7-1.0	
60								0.16-0.18	0.16-0.2	0.4-0.6	0.4-0.6	
70								0.1-0.13	0.1-0.13	0.3-0.4	0.3-0.4	
80										0.25-0.3	0.25-0.3	
90										0.2-0.25	0.2-0.25	
100										0.15-0.2	0.15-0.2	
Stainless Steel N ₂	1	20.0-26.0	27.5-33.0	31.0-38.5	33.0-45.0	50.0-65.0	63.0-66.0	70.0-80.0	75.0-90.0	80.0-100.0	82.0-100.0	87.0-100.0
	2	7.0-10.0	9.0-11.0	12.0-16.5	15.0-20.0	30.0-40.0	40.0-44.0	44.0-48.0	46.0-50.0	50.0-60.0	63.0-75.0	68.0-80.0
	3	4.5-5.5	5.0-6.5	7.0-10.0	7.5-12.0	18.0-25.0	18.0-25.0	28.0-35.0	30.0-38.0	35.0-45.0	52.0-58.0	56.0-65.0
	4	2.9-3.5	2.2-2.8	5.0-7.2	5.0-9.0	10.0-18.5	15.0-18.0	20.0-26.0	20.0-28.0	30.0-38.0	35.0-43.0	40.0-50.0
	5	1.5-2.0	1.8-2.4	4.0-5.5	4.0-5.5	8.0-13.5	12.0-14.0	15.0-20.0	16.0-22.0	20.0-28.0	24.0-28.0	29.0-32.0
	6	0.6-0.9	0.7-1.3	1.0-1.6	2.6-4.5	6.0-9.0	9.0-9.5	11.0-13.0	12.0-15.0	20.0-25.0	22.0-25.0	22.0-25.0
	8		0.3-0.6	1.2-2.0	1.6-2.8	4.5-5.5	5.0-5.5	7.0-7.5	7.5-8.5	14.0-17.0	18.0-22.0	20.0-23.0
	10			0.7-1.0	0.7-1.6	1.8-2.8	3.8-4.0	5.0-5.5	5.5-6.5	10.0-11.0	14.0-18.0	16.0-21.0
	12				0.5-0.9	1.2-1.6	2.5-2.7	3.0-3.5	3.3-4.0	9.0-10.0	12.0-14.0	12.0-14.0
	14					0.8-1.2	1.8-1.9	2.3-2.8	2.5-3.0	7.0-8.5	8.0-10.0	10.0-12.0
	16					0.6-0.9	1.3-1.5	2.1-2.5	2.5-2.8	5.0-6.0	7.0-8.0	9.0-11.0
	20						0.7-0.8	1.4-1.7	1.5-1.9	2.5-3.0	4.0-5.0	7.0-8.5
	25						0.5-0.6	0.7-1.0	0.9-1.2	1.4-1.8	2.0-2.5	4.5-5.5
30							0.5-0.7	0.6-0.8	0.9-1.2	1.2-2.0	3.0-4.0	
35							0.4-0.5	0.5-0.8	0.7-1.0	0.7-1.0	1.8-3.0	
40							0.3	0.4	0.4-0.5	0.6-0.8	1.5-2.0	
50							0.2	0.25	0.3-0.35	0.3-0.4	0.5-0.8	
60								0.15	0.15	0.15-0.25	0.4-0.6	
70									0.1-0.13	0.12-0.15	0.2-0.3	
80									0.06-0.08	0.08-0.1	0.2-0.25	
90									0.05-0.06	0.5-0.08	0.14-0.18	
100									0.03-0.04	0.04-0.05	0.08-0.12	
Aluminum N ₂	1	15.0-27.5	22.0-31.0	25.0-30.0	28.0-32.0	35.0-45.0	40.0-50.0	45.0-55.0	50.0-60.0	55.0-65.0	60.0-70.0	63.0-75.0
	2	7.0-8.6	10.0-13.2	15.0-18.0	16.0-20.0	20.0-25.0	25.0-30.0	30.0-35.0	35.0-38.0	40.0-45.0	45.0-50.0	48.0-55.0
	3	2.5-4.0	3.0-4.5	5.0-6.6	7.0-8.0	10.0-12.0	14.0-16.0	20.0-25.0	25.0-30.0	30.0-35.0	38.0-45.0	40.0-50.0
	4	1.0-1.6	1.5-2.2	2.0-3.0	2.0-3.0	7.0-10.0	12.0-16.0	18.0-20.0	20.0-22.0	25.0-30.0	28.0-35.0	30.0-35.0
	5	0.6-0.9	1.0-1.3	2.5-3.0	4.0-5.0	5.0-7.0	7.0-10.0	10.0-16.0	15.0-18.0	20.0-28.0	25.0-30.0	25.0-30.0
	6		0.6-0.9	1.5-2.0	2.5-3.0	3.5-4.0	5.0-7.0	10.0-12.0	12.0-14.0	16.0-18.0	18.0-22.0	20.0-25.0
	8			0.4-0.7	1.0-1.3	1.5-2.0	2.5-4.0	8.0-10.0				