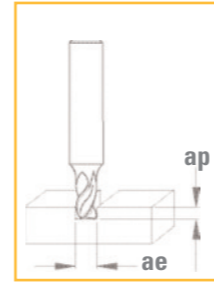


## DIXI 7543

### SCHNITTBEDINGUNGEN



| Zu bearbeitender Werkstoff |                                       |                              | XIDUR      |     | ap [mm]     | ae [mm] |
|----------------------------|---------------------------------------|------------------------------|------------|-----|-------------|---------|
|                            |                                       |                              | Vc [m/min] |     |             |         |
| <b>P</b>                   | Niedrig leg. / unleg. Stahl           | < 600 N/mm <sup>2</sup>      | <b>90</b>  | 110 | < 1.0 x ØD1 | 1 x ØD1 |
| <b>P</b>                   | Niedrig leg. / unleg. Stahl           | 600 – 1500 N/mm <sup>2</sup> | <b>70</b>  | 90  | < 0.6 x ØD1 | 1 x ØD1 |
| <b>P</b>                   | Bleilegiertes Automatenstahl          |                              | <b>90</b>  | 110 | < 1.0 x ØD1 | 1 x ØD1 |
| <b>P</b>                   | Hochlegierter Stahl                   | 700 – 1500 N/mm <sup>2</sup> | <b>40</b>  | 55  | < 0.3 x ØD1 | 1 x ØD1 |
| <b>M</b>                   | Rostfreier Stahl                      | 400 – 700 N/mm <sup>2</sup>  | <b>70</b>  | 90  | < 0.8 x ØD1 | 1 x ØD1 |
| <b>K</b>                   | Grauguss / Sphäroguss perlitisch      | < 250 HB                     | <b>90</b>  | 110 | < 0.7 x ØD1 | 1 x ØD1 |
| <b>K</b>                   | Leg. Grauguss / Sphäroguss perlitisch | > 250 HB                     | <b>70</b>  | 90  | < 0.4 x ØD1 | 1 x ØD1 |
| <b>K</b>                   | Sphäroguss ferritisch / Temperguss    |                              | <b>90</b>  | 110 | < 0.4 x ØD1 | 1 x ØD1 |
| <b>S</b>                   | Titan, Titanlegierung                 |                              | <b>40</b>  | 60  | < 0.3 x ØD1 | 1 x ØD1 |

$$n \text{ [tr/min]} = \frac{Vc \text{ [m/min]} \times 1000}{\pi \times D_1 \text{ [mm]}}$$

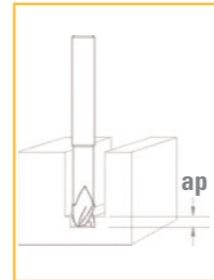
$$Vf \text{ [mm/min]} = n \text{ [tr/min]} \times fz \text{ [mm]} \times Z$$

Vorschub pro Zahn

fz [mm]

| Ø D <sub>1</sub><br>1.00 - 1.50 | Ø D <sub>1</sub><br>1.50 - 3.00 | Ø D <sub>1</sub><br>3.00 - 5.00 | Ø D <sub>1</sub><br>5.00 - 7.00 | Ø D <sub>1</sub><br>7.00 - 10.00 | Ø D <sub>1</sub><br>10.00 - 12.00 |
|---------------------------------|---------------------------------|---------------------------------|---------------------------------|----------------------------------|-----------------------------------|
| 0.002 - 0.01                    | 0.003 - 0.01                    | 0.006 - 0.02                    | 0.010 - 0.02                    | 0.014 - 0.04                     | 0.02 - 0.05                       |
| 0.002 - 0.01                    | 0.002 - 0.01                    | 0.005 - 0.01                    | 0.008 - 0.02                    | 0.011 - 0.03                     | 0.02 - 0.04                       |
| 0.003 - 0.01                    | 0.004 - 0.01                    | 0.008 - 0.03                    | 0.013 - 0.04                    | 0.018 - 0.05                     | 0.03 - 0.07                       |
| 0.002 - 0.01                    | 0.002 - 0.01                    | 0.005 - 0.01                    | 0.008 - 0.02                    | 0.011 - 0.03                     | 0.02 - 0.04                       |
| 0.002 - 0.01                    | 0.002 - 0.01                    | 0.005 - 0.01                    | 0.008 - 0.02                    | 0.011 - 0.03                     | 0.02 - 0.04                       |
| 0.002 - 0.01                    | 0.003 - 0.01                    | 0.006 - 0.02                    | 0.010 - 0.02                    | 0.014 - 0.04                     | 0.02 - 0.05                       |
| 0.002 - 0.01                    | 0.002 - 0.01                    | 0.005 - 0.01                    | 0.008 - 0.02                    | 0.011 - 0.03                     | 0.02 - 0.04                       |
| 0.002 - 0.01                    | 0.003 - 0.01                    | 0.006 - 0.02                    | 0.010 - 0.02                    | 0.014 - 0.04                     | 0.02 - 0.05                       |
| 0.002 - 0.01                    | 0.002 - 0.01                    | 0.005 - 0.01                    | 0.008 - 0.02                    | 0.011 - 0.03                     | 0.02 - 0.04                       |

## DIXI 7593



| DIXI 7593 Z = 3-4 Aluminium (Vc 400 - 600 m/min) |   |            |                        |             |         |         |         |
|--|---|------------|------------------------|-------------|---------|---------|---------|
| D <sub>1</sub>                                   | Z | Vc [m/min] | n [min <sup>-1</sup> ] | Vf [mm/min] | ap [mm] | ae [mm] | fz [mm] |
| 6  | 3 | 400        | 21220                  | 570         | 3       | 6       | 0.009   |
| 8  | 3 | 400        | 15920                  | 570         | 4       | 8       | 0.012   |
| 10   | 3 | 400        | 12730                  | 760         | 5       | 10      | 0.02    |
| 12   | 3 | 400        | 10610                  | 760         | 6       | 12      | 0.024   |
| 16   | 3 | 400        | 7960                   | 760         | 8       | 16      | 0.032   |
| 18   | 3 | 400        | 7070                   | 760         | 9       | 18      | 0.036   |
| 20   | 4 | 400        | 6370                   | 1020        | 10      | 20      | 0.04    |