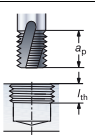
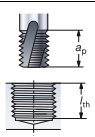


Schnittdaten CoroMill® Plura Gewindefräser

Schnittgeschwindigkeits- und Vorschubempfehlungen

ISO	Werkstoff			Gewindefräser	Abmessungen, mm, Zoll			 $f_{Th} = 0.5 \times a_p$				 $f_{Th} = a_p$				
	MC	Härte			Gewinde	DC	DC"	ZEFP	Schnittgeschwindigkeit		Schnittgeschwindigkeit		Vorschub pro Zahn, 1/2		Vorschub pro Zahn, 1/2	
		HB	HRC						1/2	1/2	mm	Zoll	mm	Zoll		
P	Unlegierter Stahl P1.1.Z.AN 125			M4	3.2	.126	3	152	500	0.030	.0012	141	465	0.018	.0007	
				M10	8.2	.323	4	132	435	0.052	.0020	124	410	0.029	.0012	
				M20	16	.630	5	141	465	0.130	.0051	131	430	0.069	.0028	
	Niedriglegierter Stahl P2.5.Z.HT 300			M4	3.2	.126	3	147	485	0.012	.0005	137	440	0.006	.0003	
				M10	8.2	.323	4	164	540	0.086	.0034	153	500	0.050	.0020	
				M20	16	.630	5	173	570	0.089	.0036	162	535	0.118	.0046	
	Hochlegierter Stahl P3.0.Z.HT 450			M4	3.2	.126	3	163	540	0.035	.0014	151	500	0.015	.0006	
				M10	8.2	.323	4	164	550	0.061	.0024	153	520	0.049	.0020	
				M20	16	.630	5	173	570	0.012	.0005	162	540	0.118	.0046	
M	Rostfreier Stahl P5.0.Z.AN 200			M4	3.2	.126	3	81	265	0.024	.0010	75	245	0.009	.0004	
				M10	8.2	.323	4	82	270	0.052	.0020	76	250	0.036	.0014	
				M20	16	.630	5	86	280	0.089	.0036	93	310	0.089	.0036	
	M1.0.Z.AQ 200			M4	3.2	.126	3	53	175	0.018	.0007	49	160	0.007	.0007	
				M10	8.2	.323	4	53	175	0.052	.0020	50	165	0.027	.0012	
				M20	16	.630	5	56	185	0.089	.0036	53	175	0.072	.0029	
	M3.1.Z.AQ 230			M4	3.2	.126	3	53	175	0.018	.0008	49	160	0.007	.0003	
				M10	8.2	.323	4	53	175	0.052	.0020	50	165	0.027	.0012	
				M20	16	.630	5	56	185	0.131	.0052	53	175	0.074	.0030	
K	Temperguss K1.1.C.NS			M4	3.2	.126	3	80	265	0.020	.0008	77	260	0.016	.0006	
				M10	8.2	.323	4	89	290	0.061	.0022	83	275	0.036	.0014	
				M20	16	.630	5	82	270	0.084	.0032	83	275	0.089	.0036	
	Grauguss K2.2.C.UT			M4	3.2	.126	3	76	260	0.018	.0007	73	250	0.014	.0006	
				M10	8.2	.323	4	86	310	0.038	.0014	79	285	0.034	.0013	
				M20	16	.630	5	79	285	0.075	.0030	80	290	0.080	.0032	
	Kugelgraphitguß K3.1.C.UT			M4	3.2	.126	3	101	340	0.027	.0012	97	330	0.020	.0008	
				M10	8.2	.323	4	104	345	0.047	.0020	105	340	0.048	.0020	
				M20	16	.630	5	104	345	0.089	.0036	97	330	0.067	.0026	
N	Aluminium N1.2.Z.UT 60			M4	3.2	.126	3	503	1660	0.040	.0016	503	1660	0.035	.0014	
				M10	8.2	.323	4	1120	3700	0.089	.0036	1060	3500	0.061	.0024	
				M20	16	.630	5	1130	3750	0.089	.0036	1060	3500	0.089	.0036	
	N1.3.C.UT 95			M4	3.2	.126	3	434	1430	0.040	.0016	404	1330	0.018	.0007	
				M10	8.2	.323	4	461	1520	0.061	.0025	432	1420	0.061	.0034	
				M20	16	.630	5	467	1540	0.089	.0036	436	1445	0.089	.0036	
	150			M4	3.2	.126	3	273	900	0.028	.0011	262	890	0.021	.0009	
				M10	8.2	.323	4	278	920	0.053	.0021	260	870	0.026	.0012	
				M20	16	.630	5	282	930	0.089	.0036	263	880	0.071	.0028	
S	Warmfeste Legierungen S1.0.U.AN 200			M4	3.2	.126	3	35	115	0.006	.0002	35	115	0.003	.0001	
				M10	8.2	.323	4	37	120	0.023	.0011	35	115	0.013	.0006	
				M20	16	.630	5	38	125	0.066	.0026	38	125	0.063	.0025	
	Titanlegierungen S2.0.Z.AG 300			M4	3.2	.126	3	30	100	0.030	.0012	29	100	0.020	.0008	
				M10	8.2	.323	4	32	105	0.013	.0006	30	100	0.007	.0003	
				M20	16	.630	5	32	105	0.037	.0015	30	100	0.018	.0007	
	S4.2.Z.AN 300			M4	3.2	.126	3	55	180	0.012	.0005	51	165	0.060	.0022	
				M10	8.2	.323	4	58	190	0.037	.0015	54	175	0.020	.0008	
				M20	12	.472	6	59	195	0.089	.0036	55	180	0.051	.0022	
H	H1.3.Z.HA 55			M4	4.5	.177	4	43	140	0.010	.0004	40	130	0.005	.0002	
				M10	8.2	.323	5	42	135	0.022	.0010	45	150	0.035	.0014	
				M20	12	.472	5	45	150	0.042	.0017	42	135	0.021	.0009	
	H1.3.Z.HA 60			M4	4.5	.177	4	30	100	0.005	.0002	30	100	0.003	.0001	
				M10	8.2	.323	5	29	100	0.011	.0005	28	100	0.006	.0002	
				M20	12	.472	5	30	100	0.022	.0010	28	100	0.010	.0004	