

CoroMill® QD

Schnittdatenempfehlungen

Metrische Ausführung

Geometrie	Sorte	HEX		Durchmesser <160		Durchmesser >160	
		ISO P	ISO M	V_c	V_c	V_c	V_c
				ISO P	ISO M	ISO P	ISO M
PM	1030	0.11 (0.07 - 0.015)	0.11 (0.07 - 0.15)	220 (270-180)	220 (290 - 180)	180 (270 - 180)	180 (290 - 180)
PM	4240	0.11 (0.07 - 0.015)	0.11 (0.07 - 0.15)	220 (270-180)		180 (270 - 180)	
PL	1030	0.05 (0.02 - 0.08)	0.05 (0.02 - 0.08)	220 (270-180)	220 (290 - 180)	180 (270 - 180)	180 (290 - 180)
PL	4240	0.05 (0.02 - 0.08)	0.05 (0.02 - 0.08)	220 (270-180)		180 (270 - 180)	
MM	1040	0.08 (0.04 - 0.12)	0.08 (0.04 - 0.12)	180 (200 - 160)	180 (225 - 160)	160 (200 - 160)	160 (225 - 160)
MM	2040	0.08 (0.04 - 0.12)	0.08 (0.04 - 0.12)		230 (275 - 210)		210 (275 - 210)
ML	1040	0.04 (0.01 - 0.07)	0.04 (0.01 - 0.07)	180 (200 - 160)	180 (225 - 160)	160 (200 - 160)	160 (225 - 160)
ML	2040	0.04 (0.01 - 0.07)	0.04 (0.01 - 0.07)		230 (275 - 210)		210 (275 - 210)

Zoll-Werte

Geometrie	Sorte	HEX		Durchmesser <160		Durchmesser >160	
		ISO P	ISO M	V_c	V_c	V_c	V_c
				ISO P	ISO M	ISO P	ISO M
PM	1030	.004 (.003 - .006)	.004 (.003 - .006)	720 (880-590)	720 (950 - 590)	590 (885 - 590)	590 (950 - 590)
PM	4240	.004 (.003 - .006)	.004 (.003 - .006)	720 (880-590)		590 (885 - 590)	
PL	1030	.002 (.001 - .003)	.002 (.001 - .003)	720 (880-590)	720 (950 - 590)	590 (885 - 590)	590 (950 - 590)
PL	4240	.002 (.001 - .003)	.002 (.001 - .003)	720 (880-590)		590 (885 - 590)	
MM	1040	.003 (.002 - .005)	.003 (.002 - .005)	590 (655 - 525)	590 (735 - 525)	525 (655 - 525)	525 (735 - 525)
MM	2040	.003 (.002 - .005)	.003 (.002 - .005)		755 (900 - 685)		685 (900 - 685)
ML	1040	.002 (.000 - .003)	.002 (.000 - .003)	590 (655 - 525)	590 (735 - 525)	525 (655 - 525)	525 (735 - 525)
ML	2040	.002 (.000 - .003)	.002 (.000 - .003)		755 (900 - 685)		685 (900 - 685)