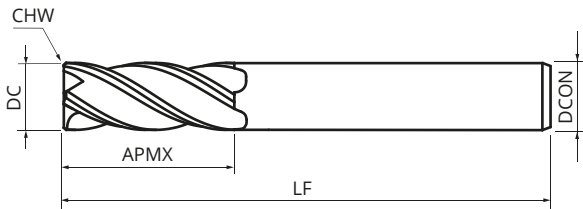


GSXMVA 3000



- Zur Anwendung in Stahl, rostfreiem Stahl, Guss und Superlegierungen
- Spezielle Geometrie zur Herstellung von Passfedernuten
- Minustoleranz

ABMESSUNGEN

| Artikelnummer (WGR. 9814) | DC mm | APMX mm | LF mm | DCON mm | CHW mm | TOL mm | ZEPF | Preis EUR |
|------------------------------|----------|------------|----------|------------|-----------|--------------|------|--------------|
| GSXMVA 3010 | 1 | 2 | 38 | 4 | - | -0.02/-0.035 | 3 | 22.20 |
| GSXMVA 3011 | 1.1 | 2.2 | 38 | 4 | - | -0.02/-0.035 | 3 | 22.20 |
| GSXMVA 3012 | 1.2 | 2.4 | 38 | 4 | - | -0.02/-0.035 | 3 | 22.20 |
| GSXMVA 3013 | 1.3 | 2.6 | 38 | 4 | - | -0.02/-0.035 | 3 | 22.20 |
| GSXMVA 3014 | 1.4 | 2.8 | 38 | 4 | - | -0.02/-0.035 | 3 | 22.20 |
| GSXMVA 3015 | 1.5 | 3 | 38 | 4 | - | -0.02/-0.035 | 3 | 22.20 |
| GSXMVA 3016 | 1.6 | 3.2 | 38 | 4 | - | -0.02/-0.035 | 3 | 22.20 |
| GSXMVA 3017 | 1.7 | 3.4 | 38 | 4 | - | -0.02/-0.035 | 3 | 22.20 |
| GSXMVA 3018 | 1.8 | 3.6 | 38 | 4 | - | -0.02/-0.035 | 3 | 22.20 |
| GSXMVA 3019 | 1.9 | 3.8 | 38 | 4 | - | -0.02/-0.035 | 3 | 22.20 |
| GSXMVA 3020 | 2 | 4 | 38 | 6 | - | -0.02/-0.035 | 3 | 23.10 |
| GSXMVA 3021 | 2.1 | 4.2 | 38 | 6 | - | -0.02/-0.035 | 3 | 23.10 |
| GSXMVA 3022 | 2.2 | 4.4 | 38 | 6 | - | -0.02/-0.035 | 3 | 23.10 |
| GSXMVA 3023 | 2.3 | 4.6 | 38 | 6 | - | -0.02/-0.035 | 3 | 23.10 |
| GSXMVA 3024 | 2.4 | 4.8 | 38 | 6 | - | -0.02/-0.035 | 3 | 23.10 |
| GSXMVA 3025 | 2.5 | 5 | 38 | 6 | 0.1 | -0.02/-0.035 | 3 | 23.10 |
| GSXMVA 3026 | 2.6 | 5.2 | 38 | 6 | 0.1 | -0.02/-0.035 | 3 | 23.10 |

ABMESSUNGEN

| Artikelnummer (WGR. 9814) | DC mm | APMX mm | LF mm | DCON mm | CHW mm | TOL mm | ZEFP | Preis EUR |
|------------------------------|----------|------------|----------|------------|-----------|---------------|------|---------------|
| GSXMVA 3027 | 2.7 | 5.4 | 38 | 6 | 0.1 | -0.02/-0.035 | 3 | 23.10 |
| GSXMVA 3028 | 2.8 | 5.6 | 50 | 6 | 0.1 | -0.02/-0.035 | 3 | 23.10 |
| GSXMVA 3029 | 2.9 | 5.8 | 50 | 6 | 0.1 | -0.02/-0.035 | 3 | 23.10 |
| GSXMVA 3030 | 3 | 6 | 50 | 6 | 0.1 | -0.02/-0.035 | 3 | 23.10 |
| GSXMVA 3031 | 3.1 | 7 | 50 | 6 | 0.1 | -0.025/-0.04 | 3 | 23.10 |
| GSXMVA 3032 | 3.2 | 7 | 50 | 6 | 0.1 | -0.025/-0.04 | 3 | 23.10 |
| GSXMVA 3033 | 3.3 | 7 | 50 | 6 | 0.1 | -0.025/-0.04 | 3 | 23.10 |
| GSXMVA 3034 | 3.4 | 7 | 50 | 6 | 0.1 | -0.025/-0.04 | 3 | 23.10 |
| GSXMVA 3035 | 3.5 | 8 | 50 | 6 | 0.1 | -0.025/-0.04 | 3 | 23.10 |
| GSXMVA 3038 | 3.8 | 8 | 54 | 6 | 0.1 | -0.025/-0.04 | 3 | 23.10 |
| GSXMVA 3039 | 3.9 | 8 | 54 | 6 | 0.1 | -0.025/-0.04 | 3 | 23.10 |
| GSXMVA 3040 | 4 | 8 | 54 | 6 | 0.1 | -0.025/-0.04 | 3 | 23.10 |
| GSXMVA 3045 | 4.5 | 10 | 54 | 6 | 0.1 | -0.025/-0.04 | 3 | 23.50 |
| GSXMVA 3048 | 4.8 | 10 | 54 | 6 | 0.1 | -0.025/-0.04 | 3 | 23.50 |
| GSXMVA 3050 | 5 | 10 | 54 | 6 | 0.1 | -0.025/-0.04 | 3 | 23.50 |
| GSXMVA 30575 | 5.75 | 13 | 54 | 6 | 0.1 | -0.025/-0.04 | 3 | 23.50 |
| GSXMVA 3060 | 6 | 13 | 54 | 6 | 0.15 | -0.025/-0.04 | 3 | 23.50 |
| GSXMVA 3070 | 7 | 16 | 58 | 8 | 0.15 | -0.03/-0.05 | 3 | 31.70 |
| GSXMVA 30775 | 7.75 | 19 | 58 | 8 | 0.15 | -0.03/-0.05 | 3 | 31.70 |
| GSXMVA 3080 | 8 | 19 | 58 | 8 | 0.15 | -0.03/-0.05 | 3 | 31.70 |
| GSXMVA 3090 | 9 | 19 | 66 | 10 | 0.15 | -0.03/-0.05 | 3 | 45.40 |
| GSXMVA 3097 | 9.7 | 22 | 66 | 10 | 0.15 | -0.03/-0.05 | 3 | 45.40 |
| GSXMVA 3100 | 10 | 22 | 66 | 10 | 0.2 | -0.03/-0.05 | 3 | 45.40 |
| GSXMVA 3117 | 11.7 | 26 | 73 | 12 | 0.2 | -0.035/-0.055 | 3 | 59.00 |
| GSXMVA 3120 | 12 | 26 | 73 | 12 | 0.2 | -0.035/-0.055 | 3 | 59.00 |
| GSXMVA 3137 | 13.7 | 26 | 75 | 14 | 0.2 | -0.035/-0.055 | 3 | 69.80 |
| GSXMVA 3140 | 14 | 26 | 75 | 14 | 0.2 | -0.035/-0.055 | 3 | 69.80 |
| GSXMVA 3157 | 15.7 | 30 | 82 | 16 | 0.2 | -0.035/-0.055 | 3 | 117.60 |
| GSXMVA 3160 | 16 | 30 | 82 | 16 | 0.2 | -0.035/-0.055 | 3 | 117.60 |

SCHNITTDATEN

| Material | Stahl / legierter Stahl | | | | | | | | | | |
|----------|-------------------------|--------|---------|-------------------|--------|------|------|-------------------|--------|------|-----|
| | < 850 N/mm ² | | | | | | | | | | |
| | Bohren | | | 100% ae | | | | Schichten | | | |
| DC | n | Vf | ap Step | n | Vf | ap | ae | n | Vf | ap | ae |
| mm | min ⁻¹ | mm/min | mm | min ⁻¹ | mm/min | mm | mm | min ⁻¹ | mm/min | mm | mm |
| 1.0 | 31850 | 287 | 1 | 19110 | 287 | 1 | 1 | 22930 | 344 | 1 | 0.1 |
| 1.1 | 28960 | 261 | 1.1 | 18820 | 311 | 1.1 | 1.1 | 22590 | 373 | 1.1 | 0.1 |
| 1.2 | 26540 | 239 | 1.2 | 18580 | 335 | 1.2 | 1.2 | 22300 | 402 | 1.2 | 0.1 |
| 1.3 | 24500 | 220 | 1.3 | 18380 | 359 | 1.3 | 1.3 | 22050 | 430 | 1.3 | 0.1 |
| 1.4 | 22750 | 273 | 1.4 | 18200 | 383 | 1.4 | 1.4 | 21840 | 459 | 1.4 | 0.1 |
| 1.5 | 21240 | 255 | 1.5 | 18050 | 407 | 1.5 | 1.5 | 21660 | 488 | 1.5 | 0.1 |
| 1.6 | 19910 | 239 | 1.6 | 17920 | 431 | 1.6 | 1.6 | 21500 | 516 | 1.6 | 0.1 |
| 1.7 | 18740 | 281 | 1.7 | 17800 | 454 | 1.7 | 1.7 | 21360 | 545 | 1.7 | 0.1 |
| 1.8 | 17700 | 265 | 1.8 | 17700 | 478 | 1.8 | 1.8 | 21240 | 574 | 1.8 | 0.1 |
| 1.9 | 16770 | 251 | 1.9 | 17600 | 502 | 1.9 | 1.9 | 21120 | 602 | 1.9 | 0.1 |
| 2.0 | 15930 | 287 | 2 | 17520 | 526 | 2 | 2 | 21020 | 631 | 2 | 0.1 |
| 2.1 | 15170 | 273 | 2.1 | 17450 | 550 | 2.1 | 2.1 | 20930 | 660 | 2.1 | 0.1 |
| 2.2 | 14480 | 261 | 2.2 | 17380 | 574 | 2.2 | 2.2 | 20850 | 689 | 2.2 | 0.1 |
| 2.3 | 13850 | 291 | 2.3 | 16620 | 574 | 2.3 | 2.3 | 20770 | 717 | 2.3 | 0.1 |
| 2.4 | 13270 | 279 | 2.4 | 15930 | 574 | 2.4 | 2.4 | 21240 | 765 | 2.4 | 0.1 |
| 2.5 | 12740 | 268 | 2.5 | 15290 | 574 | 2.5 | 2.5 | 20390 | 765 | 2.5 | 0.1 |
| 2.6 | 12250 | 294 | 2.6 | 14700 | 574 | 2.6 | 2.6 | 19600 | 765 | 2.6 | 0.1 |
| 2.7 | 11800 | 283 | 2.7 | 14160 | 574 | 2.7 | 2.7 | 18880 | 765 | 2.7 | 0.1 |
| 2.8 | 11380 | 273 | 2.8 | 13650 | 574 | 2.8 | 2.8 | 18200 | 765 | 2.8 | 0.1 |
| 2.9 | 10990 | 264 | 2.9 | 13180 | 574 | 2.9 | 2.9 | 17580 | 765 | 2.9 | 0.1 |
| 3.0 | 12740 | 344 | 3 | 12740 | 574 | 3 | 3 | 16990 | 765 | 3 | 0.2 |
| 3.1 | 12330 | 333 | 3.1 | 12330 | 574 | 3.1 | 3.1 | 16440 | 765 | 3.1 | 0.2 |
| 3.2 | 11950 | 322 | 3.2 | 11950 | 574 | 3.2 | 3.2 | 15930 | 765 | 3.2 | 0.2 |
| 3.3 | 11590 | 313 | 3.3 | 11590 | 574 | 3.3 | 3.3 | 15450 | 765 | 3.3 | 0.2 |
| 3.4 | 11250 | 405 | 3.4 | 11250 | 574 | 3.4 | 3.4 | 14990 | 765 | 3.4 | 0.2 |
| 3.5 | 10920 | 393 | 3.5 | 10920 | 574 | 3.5 | 3.5 | 14560 | 765 | 3.5 | 0.2 |
| 3.8 | 10060 | 362 | 3.8 | 10060 | 574 | 3.8 | 3.8 | 13410 | 765 | 3.8 | 0.2 |
| 3.9 | 9800 | 353 | 3.9 | 9800 | 574 | 3.9 | 3.9 | 13070 | 765 | 3.9 | 0.2 |
| 4.0 | 9560 | 430 | 4 | 9560 | 574 | 4 | 4 | 12740 | 765 | 4 | 0.2 |
| 4.5 | 9910 | 446 | 4.5 | 8500 | 574 | 4.5 | 4.5 | 11330 | 765 | 4.5 | 0.2 |
| 4.8 | 9290 | 418 | 4.8 | 7970 | 574 | 4.8 | 4.8 | 10620 | 765 | 4.8 | 0.2 |
| 5.0 | 8920 | 401 | 5 | 7650 | 574 | 5 | 5 | 10200 | 765 | 5 | 0.2 |
| 5.75 | 7760 | 349 | 5.8 | 6590 | 574 | 5.8 | 5.75 | 8790 | 765 | 5.8 | 0.2 |
| 6.0 | 7440 | 401 | 6 | 6370 | 574 | 6 | 6 | 8500 | 765 | 6 | 0.2 |
| 7.0 | 6370 | 344 | 7 | 5460 | 574 | 7 | 7 | 7280 | 765 | 7 | 0.2 |
| 7.75 | 5760 | 345 | 7.8 | 4900 | 574 | 7.8 | 7.75 | 6540 | 766 | 7.8 | 0.2 |
| 8.0 | 5580 | 334 | 8 | 4780 | 574 | 8 | 8 | 6370 | 765 | 8 | 0.2 |
| 9.0 | 4960 | 297 | 8 | 4250 | 574 | 9 | 9 | 5670 | 766 | 9 | 0.2 |
| 9.7 | 4600 | 345 | 8 | 3940 | 574 | 9.7 | 9.7 | 5260 | 766 | 9.7 | 0.2 |
| 10.0 | 4460 | 334 | 8 | 3830 | 575 | 10 | 10 | 5100 | 765 | 10 | 0.2 |
| 11.7 | 3820 | 286 | 8 | 3270 | 574 | 11.7 | 11.7 | 4360 | 766 | 11.7 | 0.2 |
| 12.0 | 3720 | 334 | 8 | 3190 | 575 | 12 | 12 | 4250 | 765 | 12 | 0.2 |
| 13.7 | 3260 | 293 | 8 | 2790 | 574 | 13.7 | 13.7 | 3720 | 765 | 13.7 | 0.2 |
| 14.0 | 3190 | 382 | 8 | 2730 | 574 | 14 | 14 | 3640 | 765 | 14 | 0.2 |
| 15.7 | 2840 | 341 | 4 | 2440 | 575 | 15.7 | 15.7 | 3250 | 766 | 15.7 | 0.2 |
| 16.0 | 2790 | 334 | 4 | 2390 | 574 | 16 | 16 | 3190 | 766 | 16 | 0.2 |

SCHNITTDATEN

| Material | Stahl / legierter Stahl | | | | | | | | | | |
|----------|--------------------------|--------|---------|-------------------|--------|------|------|-------------------|--------|------|-----|
| | < 1300 N/mm ² | | | | | | | | | | |
| | Bohren | | | 100% ae | | | | Schlichten | | | |
| DC | n | Vf | ap Step | n | Vf | ap | ae | n | Vf | ap | ae |
| mm | min ⁻¹ | mm/min | mm | min ⁻¹ | mm/min | mm | mm | min ⁻¹ | mm/min | mm | mm |
| 1.0 | 25480 | 229 | 1 | 17520 | 169 | 1 | 1 | 22930 | 207 | 1 | 0.1 |
| 1.1 | 23170 | 208 | 1.1 | 17380 | 183 | 1.1 | 1.1 | 22590 | 224 | 1.1 | 0.1 |
| 1.2 | 21240 | 191 | 1.2 | 17260 | 197 | 1.2 | 1.2 | 22300 | 241 | 1.2 | 0.1 |
| 1.3 | 19600 | 176 | 1.3 | 17150 | 211 | 1.3 | 1.3 | 22050 | 258 | 1.3 | 0.1 |
| 1.4 | 18200 | 218 | 1.4 | 17070 | 226 | 1.4 | 1.4 | 21840 | 276 | 1.4 | 0.1 |
| 1.5 | 16990 | 204 | 1.5 | 16990 | 240 | 1.5 | 1.5 | 21660 | 293 | 1.5 | 0.1 |
| 1.6 | 15930 | 191 | 1.6 | 15930 | 239 | 1.6 | 1.6 | 21500 | 310 | 1.6 | 0.1 |
| 1.7 | 14990 | 225 | 1.7 | 14990 | 243 | 1.7 | 1.7 | 21360 | 321 | 1.7 | 0.1 |
| 1.8 | 14160 | 212 | 1.8 | 14160 | 243 | 1.8 | 1.8 | 21240 | 338 | 1.8 | 0.1 |
| 1.9 | 13410 | 201 | 1.9 | 13410 | 242 | 1.9 | 1.9 | 21120 | 355 | 1.9 | 0.1 |
| 2.0 | 12740 | 229 | 2 | 12740 | 241 | 2 | 2 | 21020 | 373 | 2 | 0.1 |
| 2.1 | 12140 | 218 | 2.1 | 12140 | 241 | 2.1 | 2.1 | 20930 | 390 | 2.1 | 0.1 |
| 2.2 | 11590 | 208 | 2.2 | 11590 | 240 | 2.2 | 2.2 | 20850 | 407 | 2.2 | 0.1 |
| 2.3 | 11080 | 233 | 2.3 | 11080 | 240 | 2.3 | 2.3 | 20770 | 424 | 2.3 | 0.1 |
| 2.4 | 10620 | 223 | 2.4 | 10620 | 239 | 2.4 | 2.4 | 21240 | 453 | 2.4 | 0.1 |
| 2.5 | 10200 | 214 | 2.5 | 10200 | 242 | 2.5 | 2.5 | 20390 | 453 | 2.5 | 0.1 |
| 2.6 | 9800 | 235 | 2.6 | 9800 | 242 | 2.6 | 2.6 | 19600 | 453 | 2.6 | 0.1 |
| 2.7 | 9440 | 226 | 2.7 | 9440 | 241 | 2.7 | 2.7 | 18880 | 454 | 2.7 | 0.1 |
| 2.8 | 9100 | 218 | 2.8 | 9100 | 241 | 2.8 | 2.8 | 18200 | 454 | 2.8 | 0.1 |
| 2.9 | 8790 | 211 | 2.9 | 8790 | 240 | 2.9 | 2.9 | 17580 | 454 | 2.9 | 0.1 |
| 3.0 | 10620 | 287 | 3 | 8500 | 240 | 3 | 3 | 16990 | 454 | 3 | 0.2 |
| 3.1 | 10280 | 277 | 3.1 | 8220 | 240 | 3.1 | 3.1 | 16440 | 454 | 3.1 | 0.2 |
| 3.2 | 9960 | 269 | 3.2 | 7970 | 240 | 3.2 | 3.2 | 15930 | 455 | 3.2 | 0.2 |
| 3.3 | 9660 | 261 | 3.3 | 7730 | 242 | 3.3 | 3.3 | 15450 | 455 | 3.3 | 0.2 |
| 3.4 | 9370 | 337 | 3.4 | 7500 | 241 | 3.4 | 3.4 | 14990 | 450 | 3.4 | 0.2 |
| 3.5 | 9100 | 328 | 3.5 | 7280 | 241 | 3.5 | 3.5 | 14560 | 450 | 3.5 | 0.2 |
| 3.8 | 8390 | 302 | 3.8 | 6710 | 240 | 3.8 | 3.8 | 13410 | 451 | 3.8 | 0.2 |
| 3.9 | 8170 | 294 | 3.9 | 6540 | 240 | 3.9 | 3.9 | 13070 | 451 | 3.9 | 0.2 |
| 4.0 | 7970 | 358 | 4 | 6370 | 239 | 4 | 4 | 12740 | 451 | 4 | 0.2 |
| 4.5 | 8500 | 382 | 4.5 | 5670 | 240 | 4.5 | 4.5 | 11330 | 453 | 4.5 | 0.2 |
| 4.8 | 7970 | 358 | 4.8 | 5310 | 239 | 4.8 | 4.8 | 10620 | 453 | 4.8 | 0.2 |
| 5.0 | 7650 | 344 | 5 | 5100 | 241 | 5 | 5 | 10200 | 453 | 5 | 0.2 |
| 5.75 | 6650 | 299 | 5.8 | 4400 | 241 | 5.8 | 5.75 | 8790 | 451 | 5.8 | 0.2 |
| 6.0 | 6370 | 344 | 6 | 4250 | 240 | 6 | 6 | 8500 | 495 | 6 | 0.2 |
| 7.0 | 5460 | 295 | 7 | 3640 | 240 | 7 | 7 | 7280 | 494 | 7 | 0.2 |
| 7.75 | 4940 | 296 | 7.8 | 3270 | 240 | 7.8 | 7.75 | 6540 | 495 | 7.8 | 0.2 |
| 8.0 | 4780 | 287 | 8 | 3190 | 240 | 8 | 8 | 6370 | 495 | 8 | 0.2 |
| 9.0 | 4250 | 255 | 8 | 2840 | 241 | 9 | 9 | 5670 | 495 | 9 | 0.2 |
| 9.7 | 3940 | 295 | 8 | 2630 | 240 | 9.7 | 9.7 | 5260 | 494 | 9.7 | 0.2 |
| 10.0 | 3830 | 287 | 8 | 2550 | 240 | 10 | 10 | 5100 | 495 | 10 | 0.2 |
| 11.7 | 3270 | 245 | 8 | 2180 | 240 | 11.7 | 11.7 | 4360 | 495 | 11.7 | 0.2 |
| 12.0 | 3190 | 287 | 8 | 2130 | 240 | 12 | 12 | 4250 | 495 | 12 | 0.2 |
| 13.7 | 2790 | 251 | 8 | 1860 | 240 | 13.7 | 13.7 | 3720 | 494 | 13.7 | 0.2 |
| 14.0 | 2730 | 328 | 8 | 1820 | 240 | 14 | 14 | 3640 | 494 | 14 | 0.2 |
| 15.7 | 2440 | 292 | 4 | 1630 | 241 | 15.7 | 15.7 | 3250 | 495 | 15.7 | 0.2 |
| 16.0 | 2390 | 287 | 4 | 1600 | 240 | 16 | 16 | 3190 | 495 | 16 | 0.2 |

SCHNITTDATEN

| Material | Rostfreier Stahl | | | | | | | | | | |
|----------|------------------------------|--------|---------|-------------------|--------|------|------|-------------------|--------|------|-----|
| | ferritisch und martensitisch | | | | | | | | | | |
| | Bohren | | | 100% ae | | | | Schlichten | | | |
| DC | n | Vf | ap Step | n | Vf | ap | ae | n | Vf | ap | ae |
| mm | min ⁻¹ | mm/min | mm | min ⁻¹ | mm/min | mm | mm | min ⁻¹ | mm/min | mm | mm |
| 1.0 | 22300 | 201 | 0.5 | 19110 | 230 | 1 | 1 | 22930 | 303 | 1 | 0.1 |
| 1.1 | 20270 | 182 | 0.55 | 18820 | 249 | 1.1 | 1.1 | 22590 | 326 | 1.1 | 0.1 |
| 1.2 | 18580 | 167 | 0.6 | 18580 | 268 | 1.2 | 1.2 | 22300 | 355 | 1.2 | 0.1 |
| 1.3 | 17150 | 154 | 0.65 | 18380 | 287 | 1.3 | 1.3 | 22050 | 378 | 1.3 | 0.1 |
| 1.4 | 15930 | 191 | 0.7 | 18200 | 306 | 1.4 | 1.4 | 21840 | 400 | 1.4 | 0.1 |
| 1.5 | 14870 | 178 | 0.75 | 19110 | 344 | 1.5 | 1.5 | 21660 | 429 | 1.5 | 0.1 |
| 1.6 | 13940 | 167 | 0.8 | 18910 | 364 | 1.6 | 1.6 | 21500 | 452 | 1.6 | 0.1 |
| 1.7 | 13120 | 197 | 0.85 | 18740 | 383 | 1.7 | 1.7 | 21360 | 475 | 1.7 | 0.1 |
| 1.8 | 12390 | 186 | 0.9 | 18580 | 402 | 1.8 | 1.8 | 21240 | 504 | 1.8 | 0.1 |
| 1.9 | 11740 | 176 | 0.95 | 18440 | 421 | 1.9 | 1.9 | 21120 | 526 | 1.9 | 0.1 |
| 2.0 | 11150 | 201 | 1 | 18320 | 440 | 2 | 2 | 21020 | 549 | 2 | 0.1 |
| 2.1 | 10620 | 191 | 1.05 | 18200 | 459 | 2.1 | 2.1 | 20930 | 578 | 2.1 | 0.1 |
| 2.2 | 10140 | 182 | 1.1 | 17380 | 459 | 2.2 | 2.2 | 20850 | 601 | 2.2 | 0.1 |
| 2.3 | 9700 | 204 | 1.15 | 16620 | 459 | 2.3 | 2.3 | 20770 | 624 | 2.3 | 0.1 |
| 2.4 | 9290 | 195 | 1.2 | 15930 | 459 | 2.4 | 2.4 | 21240 | 670 | 2.4 | 0.1 |
| 2.5 | 8920 | 187 | 1.25 | 15290 | 459 | 2.5 | 2.5 | 20390 | 667 | 2.5 | 0.1 |
| 2.6 | 8580 | 206 | 1.3 | 14700 | 459 | 2.6 | 2.6 | 19600 | 671 | 2.6 | 0.1 |
| 2.7 | 8260 | 198 | 1.35 | 14160 | 459 | 2.7 | 2.7 | 18880 | 669 | 2.7 | 0.1 |
| 2.8 | 7970 | 191 | 1.4 | 13650 | 459 | 2.8 | 2.8 | 18200 | 667 | 2.8 | 0.1 |
| 2.9 | 7690 | 184 | 1.45 | 13180 | 459 | 2.9 | 2.9 | 17580 | 670 | 2.9 | 0.1 |
| 3.0 | 9560 | 258 | 1.5 | 12740 | 459 | 3 | 3 | 16990 | 668 | 3 | 0.2 |
| 3.1 | 9250 | 250 | 1.55 | 12330 | 459 | 3.1 | 3.1 | 16440 | 666 | 3.1 | 0.2 |
| 3.2 | 8960 | 242 | 1.6 | 11950 | 459 | 3.2 | 3.2 | 15930 | 670 | 3.2 | 0.2 |
| 3.3 | 8690 | 235 | 1.65 | 11590 | 459 | 3.3 | 3.3 | 15450 | 668 | 3.3 | 0.2 |
| 3.4 | 8440 | 303 | 1.7 | 11250 | 459 | 3.4 | 3.4 | 14990 | 666 | 3.4 | 0.2 |
| 3.5 | 8190 | 295 | 1.75 | 10920 | 459 | 3.5 | 3.5 | 14560 | 669 | 3.5 | 0.2 |
| 3.8 | 7550 | 272 | 1.9 | 10060 | 459 | 3.8 | 3.8 | 13410 | 668 | 3.8 | 0.2 |
| 3.9 | 7350 | 265 | 1.95 | 9800 | 459 | 3.9 | 3.9 | 13070 | 667 | 3.9 | 0.2 |
| 4.0 | 7170 | 322 | 2 | 9560 | 459 | 4 | 4 | 12740 | 666 | 4 | 0.2 |
| 4.5 | 6730 | 303 | 2.25 | 8500 | 459 | 4.5 | 4.5 | 11330 | 667 | 4.5 | 0.2 |
| 4.8 | 6310 | 284 | 2.4 | 7970 | 460 | 4.8 | 4.8 | 10620 | 666 | 4.8 | 0.2 |
| 5.0 | 6060 | 272 | 2.5 | 7650 | 459 | 5 | 5 | 10200 | 668 | 5 | 0.2 |
| 5.75 | 5270 | 237 | 2.9 | 6590 | 459 | 5.8 | 5.75 | 8790 | 668 | 5.8 | 0.2 |
| 6.0 | 5050 | 272 | 3 | 6370 | 522 | 6 | 6 | 8500 | 765 | 6 | 0.2 |
| 7.0 | 4330 | 233 | 3.5 | 5460 | 523 | 7 | 7 | 7280 | 765 | 7 | 0.2 |
| 7.75 | 3910 | 234 | 3.9 | 4900 | 522 | 7.8 | 7.75 | 6540 | 766 | 7.8 | 0.2 |
| 8.0 | 3790 | 227 | 4 | 4780 | 522 | 8 | 8 | 6370 | 765 | 8 | 0.2 |
| 9.0 | 3370 | 202 | 4.5 | 4250 | 523 | 9 | 9 | 5670 | 766 | 9 | 0.2 |
| 9.7 | 3120 | 234 | 4.85 | 3940 | 522 | 9.7 | 9.7 | 5260 | 766 | 9.7 | 0.2 |
| 10.0 | 3030 | 227 | 5 | 3830 | 523 | 10 | 10 | 5100 | 765 | 10 | 0.2 |
| 11.7 | 2590 | 194 | 4 | 3270 | 522 | 11.7 | 11.7 | 4360 | 766 | 11.7 | 0.2 |
| 12.0 | 2530 | 227 | 4 | 3190 | 523 | 12 | 12 | 4250 | 765 | 12 | 0.2 |
| 13.7 | 2210 | 199 | 4 | 2790 | 522 | 13.7 | 13.7 | 3720 | 765 | 13.7 | 0.2 |
| 14.0 | 2170 | 259 | 4 | 2730 | 522 | 14 | 14 | 3640 | 765 | 14 | 0.2 |
| 15.7 | 1930 | 231 | 4 | 2440 | 523 | 15.7 | 15.7 | 3250 | 766 | 15.7 | 0.2 |
| 16.0 | 1900 | 227 | 4 | 2390 | 522 | 16 | 16 | 3190 | 766 | 16 | 0.2 |

SCHNITTDATEN

| Material | Rostfreier Stahl | | | | | | | | | | | |
|----------|-------------------|--------|---------|-------------------|--------|-----|------|-------------------|--------|------|-----|--|
| | austenitisch | | | | | | | | | | | |
| | Bohren | | | 100% ae | | | | Schlichten | | | | |
| DC | n | Vf | ap Step | n | Vf | ap | ae | n | Vf | ap | ae | |
| mm | min ⁻¹ | mm/min | mm | min ⁻¹ | mm/min | mm | mm | min ⁻¹ | mm/min | mm | mm | |
| 1.0 | 19110 | 172 | 0.3 | 17520 | 163 | 0.3 | 1 | 22930 | 221 | 0.3 | 0.1 | |
| 1.1 | 17380 | 156 | 0.33 | 17380 | 178 | 0.4 | 1.1 | 22590 | 238 | 0.4 | 0.1 | |
| 1.2 | 15930 | 143 | 0.36 | 17260 | 192 | 0.4 | 1.2 | 22300 | 255 | 0.4 | 0.1 | |
| 1.3 | 14700 | 132 | 0.39 | 17150 | 206 | 0.4 | 1.3 | 22050 | 272 | 0.4 | 0.1 | |
| 1.4 | 13650 | 164 | 0.42 | 17070 | 221 | 0.5 | 1.4 | 21840 | 289 | 0.5 | 0.1 | |
| 1.5 | 12740 | 153 | 0.45 | 16990 | 235 | 0.5 | 1.5 | 21660 | 306 | 0.5 | 0.1 | |
| 1.6 | 11950 | 143 | 0.48 | 15930 | 235 | 0.5 | 1.6 | 21500 | 323 | 0.5 | 0.1 | |
| 1.7 | 11250 | 169 | 0.51 | 14990 | 234 | 0.6 | 1.7 | 21360 | 347 | 0.6 | 0.1 | |
| 1.8 | 10620 | 159 | 0.54 | 14160 | 234 | 0.6 | 1.8 | 21240 | 364 | 0.6 | 0.1 | |
| 1.9 | 10060 | 151 | 0.57 | 13410 | 234 | 0.6 | 1.9 | 20120 | 363 | 0.6 | 0.1 | |
| 2.0 | 9560 | 172 | 0.6 | 12740 | 234 | 0.7 | 2 | 19110 | 362 | 0.7 | 0.1 | |
| 2.1 | 9100 | 164 | 0.63 | 12140 | 234 | 0.7 | 2.1 | 18200 | 361 | 0.7 | 0.1 | |
| 2.2 | 8690 | 156 | 0.66 | 11590 | 233 | 0.7 | 2.2 | 17380 | 360 | 0.7 | 0.1 | |
| 2.3 | 8310 | 174 | 0.69 | 11080 | 233 | 0.8 | 2.3 | 16620 | 359 | 0.8 | 0.1 | |
| 2.4 | 7970 | 167 | 0.72 | 10620 | 233 | 0.8 | 2.4 | 15930 | 359 | 0.8 | 0.1 | |
| 2.5 | 7650 | 161 | 0.75 | 10200 | 233 | 0.8 | 2.5 | 15290 | 363 | 0.8 | 0.1 | |
| 2.6 | 7350 | 176 | 0.78 | 9800 | 233 | 0.9 | 2.6 | 14700 | 362 | 0.9 | 0.1 | |
| 2.7 | 7080 | 170 | 0.81 | 9440 | 233 | 0.9 | 2.7 | 14160 | 362 | 0.9 | 0.1 | |
| 2.8 | 6830 | 164 | 0.84 | 9100 | 233 | 0.9 | 2.8 | 13650 | 361 | 0.9 | 0.1 | |
| 2.9 | 6590 | 158 | 0.87 | 8790 | 233 | 1 | 2.9 | 13180 | 360 | 1 | 0.1 | |
| 3.0 | 8500 | 229 | 0.9 | 8500 | 233 | 1 | 3 | 12740 | 360 | 1 | 0.2 | |
| 3.1 | 8220 | 222 | 0.93 | 8220 | 232 | 1 | 3.1 | 12330 | 359 | 1 | 0.2 | |
| 3.2 | 7970 | 215 | 0.96 | 7970 | 232 | 1.1 | 3.2 | 11950 | 359 | 1.1 | 0.2 | |
| 3.3 | 7730 | 208 | 0.99 | 7730 | 232 | 1.1 | 3.3 | 11590 | 362 | 1.1 | 0.2 | |
| 3.4 | 7500 | 270 | 1.02 | 7500 | 234 | 1.1 | 3.4 | 11250 | 362 | 1.1 | 0.2 | |
| 3.5 | 7280 | 262 | 1.05 | 7280 | 234 | 1.2 | 3.5 | 10920 | 361 | 1.2 | 0.2 | |
| 3.8 | 6710 | 241 | 1.14 | 6710 | 234 | 1.3 | 3.8 | 10060 | 360 | 1.3 | 0.2 | |
| 3.9 | 6540 | 235 | 1.17 | 6540 | 234 | 1.3 | 3.9 | 9800 | 359 | 1.3 | 0.2 | |
| 4.0 | 6370 | 287 | 1.2 | 6370 | 234 | 1.3 | 4 | 9560 | 359 | 1.3 | 0.2 | |
| 4.5 | 5310 | 239 | 1.35 | 5670 | 234 | 1.5 | 4.5 | 8500 | 360 | 1.5 | 0.2 | |
| 4.8 | 4980 | 224 | 1.44 | 5310 | 233 | 1.6 | 4.8 | 7970 | 359 | 1.6 | 0.2 | |
| 5.0 | 4780 | 215 | 1.5 | 5100 | 233 | 1.7 | 5 | 7650 | 361 | 1.7 | 0.2 | |
| 5.75 | 4160 | 187 | 1.74 | 4400 | 233 | 1.9 | 5.75 | 6590 | 360 | 5.8 | 0.2 | |
| 6.0 | 3990 | 215 | 1.8 | 4250 | 248 | 2 | 6 | 6370 | 383 | 6 | 0.2 | |
| 7.0 | 3420 | 184 | 2.1 | 3640 | 247 | 2.3 | 7 | 5460 | 384 | 7 | 0.2 | |
| 7.75 | 3090 | 185 | 2.34 | 3270 | 248 | 2.6 | 7.75 | 4900 | 383 | 7.8 | 0.2 | |
| 8.0 | 2990 | 179 | 2.4 | 3190 | 248 | 2.6 | 8 | 4780 | 383 | 8 | 0.2 | |
| 9.0 | 2660 | 159 | 2.7 | 2840 | 248 | 3 | 9 | 4250 | 383 | 9 | 0.2 | |
| 9.7 | 2470 | 185 | 2.91 | 2630 | 247 | 3.2 | 9.7 | 3940 | 383 | 9.7 | 0.2 | |
| 10.0 | 2390 | 179 | 3 | 2550 | 248 | 3.3 | 10 | 3830 | 384 | 10 | 0.2 | |
| 11.7 | 2050 | 153 | 3.51 | 2180 | 248 | 3.9 | 11.7 | 3270 | 383 | 11.7 | 0.2 | |
| 12.0 | 2000 | 179 | 3.6 | 2130 | 248 | 4 | 12 | 3190 | 383 | 12 | 0.2 | |
| 13.7 | 1750 | 157 | 4 | 1860 | 247 | 4.5 | 13.7 | 2790 | 383 | 13.7 | 0.2 | |
| 14.0 | 1710 | 205 | 4 | 1820 | 247 | 4.6 | 14 | 2730 | 383 | 14 | 0.2 | |
| 15.7 | 1530 | 183 | 4 | 1630 | 248 | 5.2 | 15.7 | 2440 | 384 | 15.7 | 0.2 | |
| 16.0 | 1500 | 179 | 4 | 1600 | 249 | 5.3 | 16 | 2390 | 383 | 16 | 0.2 | |

SCHNITTDATEN

| Material | Superlegierung | | | | | | | | | | |
|----------|-------------------|--------|---------|-------------------|--------|-----|------|-------------------|--------|------|-----|
| | Bohren | | | 100% ae | | | | Schlichten | | | |
| DC | n | Vf | ap Step | n | Vf | ap | ae | n | Vf | ap | ae |
| mm | min ⁻¹ | mm/min | mm | min ⁻¹ | mm/min | mm | mm | min ⁻¹ | mm/min | mm | mm |
| 1.0 | 11150 | 100 | 0.33 | 19110 | 178 | 0.3 | 1 | 22300 | 208 | 0.3 | 0.1 |
| 1.1 | 10140 | 91 | 0.36 | 17380 | 178 | 0.4 | 1.1 | 20270 | 207 | 0.4 | 0.1 |
| 1.2 | 9290 | 84 | 0.39 | 15930 | 177 | 0.4 | 1.2 | 18580 | 207 | 0.4 | 0.1 |
| 1.3 | 8580 | 77 | 0.43 | 14700 | 177 | 0.4 | 1.3 | 17150 | 206 | 0.4 | 0.1 |
| 1.4 | 7970 | 96 | 0.46 | 13650 | 177 | 0.5 | 1.4 | 15930 | 206 | 0.5 | 0.1 |
| 1.5 | 7440 | 89 | 0.49 | 12740 | 176 | 0.5 | 1.5 | 14870 | 206 | 0.5 | 0.1 |
| 1.6 | 6970 | 84 | 0.53 | 11950 | 176 | 0.5 | 1.6 | 13940 | 205 | 0.5 | 0.1 |
| 1.7 | 6560 | 98 | 0.56 | 11250 | 176 | 0.6 | 1.7 | 13120 | 205 | 0.6 | 0.1 |
| 1.8 | 6200 | 93 | 0.59 | 10620 | 176 | 0.6 | 1.8 | 12390 | 205 | 0.6 | 0.1 |
| 1.9 | 5870 | 88 | 0.63 | 10060 | 176 | 0.6 | 1.9 | 11740 | 205 | 0.6 | 0.1 |
| 2.0 | 5580 | 100 | 0.66 | 9560 | 175 | 0.7 | 2 | 11150 | 205 | 0.7 | 0.1 |
| 2.1 | 5310 | 96 | 0.69 | 9100 | 175 | 0.7 | 2.1 | 10620 | 204 | 0.7 | 0.1 |
| 2.2 | 5070 | 91 | 0.72 | 8690 | 175 | 0.7 | 2.2 | 10140 | 204 | 0.7 | 0.1 |
| 2.3 | 4850 | 102 | 0.76 | 8310 | 175 | 0.8 | 2.3 | 9700 | 204 | 0.8 | 0.1 |
| 2.4 | 4650 | 98 | 0.79 | 7970 | 175 | 0.8 | 2.4 | 9290 | 204 | 0.8 | 0.1 |
| 2.5 | 4460 | 94 | 0.82 | 7650 | 175 | 0.8 | 2.5 | 8920 | 204 | 0.8 | 0.1 |
| 2.6 | 4290 | 103 | 0.86 | 7350 | 175 | 0.9 | 2.6 | 8580 | 204 | 0.9 | 0.1 |
| 2.7 | 4130 | 99 | 0.89 | 7080 | 175 | 0.9 | 2.7 | 8260 | 204 | 0.9 | 0.1 |
| 2.8 | 3990 | 96 | 0.92 | 6830 | 175 | 0.9 | 2.8 | 7970 | 204 | 0.9 | 0.1 |
| 2.9 | 3850 | 92 | 0.96 | 6590 | 174 | 1 | 2.9 | 7690 | 204 | 1 | 0.1 |
| 3.0 | 4780 | 129 | 0.99 | 6370 | 174 | 1 | 3 | 7440 | 204 | 1 | 0.2 |
| 3.1 | 4630 | 125 | 1.02 | 6170 | 174 | 1 | 3.1 | 7200 | 204 | 1 | 0.2 |
| 3.2 | 4480 | 121 | 1.06 | 5980 | 175 | 1.1 | 3.2 | 6970 | 203 | 1.1 | 0.2 |
| 3.3 | 4350 | 117 | 1.09 | 5800 | 174 | 1.1 | 3.3 | 6760 | 203 | 1.1 | 0.2 |
| 3.4 | 4220 | 152 | 1.12 | 5630 | 176 | 1.1 | 3.4 | 6560 | 205 | 1.1 | 0.2 |
| 3.5 | 4100 | 147 | 1.15 | 5460 | 176 | 1.2 | 3.5 | 6370 | 205 | 1.2 | 0.2 |
| 3.8 | 3780 | 136 | 1.25 | 5030 | 176 | 1.3 | 3.8 | 5870 | 205 | 1.3 | 0.2 |
| 3.9 | 3680 | 132 | 1.29 | 4900 | 175 | 1.3 | 3.9 | 5720 | 205 | 1.3 | 0.2 |
| 4.0 | 3590 | 161 | 1.32 | 4780 | 175 | 1.3 | 4 | 5580 | 205 | 1.3 | 0.2 |
| 4.5 | 3540 | 159 | 1.49 | 4250 | 175 | 1.5 | 4.5 | 4960 | 204 | 1.5 | 0.2 |
| 4.8 | 3320 | 149 | 1.58 | 3990 | 175 | 1.6 | 4.8 | 4650 | 204 | 1.6 | 0.2 |
| 5.0 | 3190 | 143 | 1.65 | 3830 | 175 | 1.7 | 5 | 4460 | 204 | 1.7 | 0.2 |
| 5.75 | 2770 | 125 | 1.91 | 3300 | 175 | 1.9 | 5.75 | 3850 | 204 | 1.9 | 0.2 |
| 6.0 | 2660 | 143 | 1.98 | 3190 | 192 | 2 | 6 | 3720 | 224 | 2 | 0.2 |
| 7.0 | 2280 | 123 | 2.31 | 2730 | 192 | 2.3 | 7 | 3190 | 224 | 2.3 | 0.2 |
| 7.75 | 2060 | 123 | 2.57 | 2450 | 192 | 2.6 | 7.75 | 2860 | 224 | 2.6 | 0.2 |
| 8.0 | 2000 | 119 | 2.64 | 2390 | 192 | 2.6 | 8 | 2790 | 224 | 8 | 0.2 |
| 9.0 | 1770 | 106 | 2.97 | 2130 | 192 | 3 | 9 | 2480 | 224 | 9 | 0.2 |
| 9.7 | 1650 | 123 | 3.2 | 1970 | 192 | 3.2 | 9.7 | 2300 | 224 | 9.7 | 0.2 |
| 10.0 | 1600 | 119 | 3.3 | 1920 | 193 | 3.3 | 10 | 2230 | 224 | 10 | 0.2 |
| 11.7 | 1370 | 102 | 3.86 | 1640 | 192 | 3.9 | 11.7 | 1910 | 224 | 11.7 | 0.2 |
| 12.0 | 1330 | 119 | 4 | 1600 | 192 | 4 | 12 | 1860 | 224 | 12 | 0.2 |
| 13.7 | 1170 | 105 | 4 | 1400 | 192 | 4.5 | 13.7 | 1630 | 224 | 13.7 | 0.2 |
| 14.0 | 1140 | 136 | 4 | 1370 | 192 | 4.6 | 14 | 1600 | 225 | 14 | 0.2 |
| 15.7 | 1020 | 122 | 4 | 1220 | 192 | 5.2 | 15.7 | 1420 | 224 | 15.7 | 0.2 |
| 16.0 | 1000 | 119 | 3 | 1200 | 193 | 5.3 | 16 | 1400 | 225 | 16 | 0.2 |