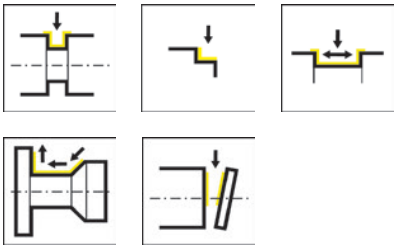
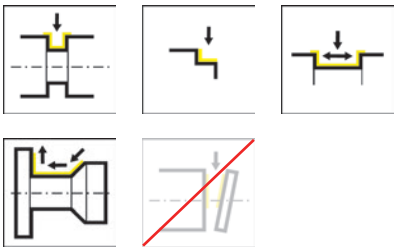
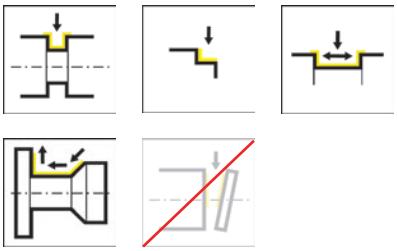
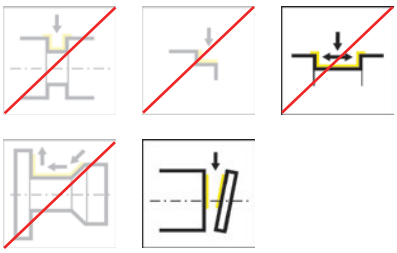
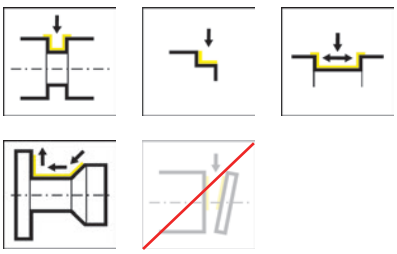
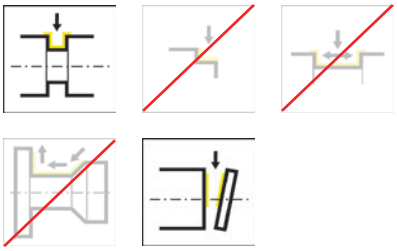
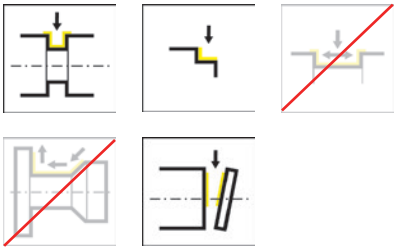
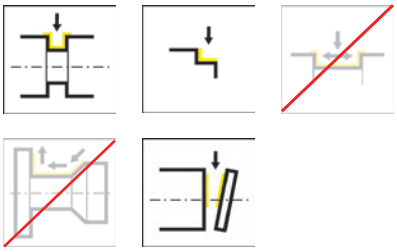
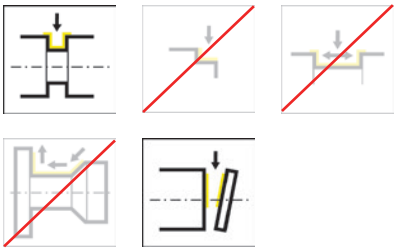
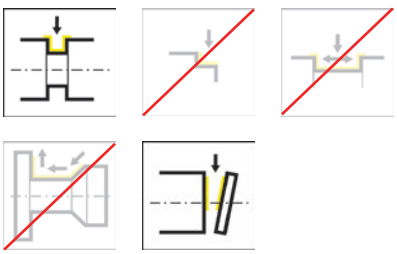
Geometrien und Vorschübe - Stechdrehen
Geometries and feed rates - Grooving

Geometrie Geometry	Werkstoff Material	Vorschubbereich f [mm/U] Feed rate f [mm/rev]	Bearbeitung Machining
.3	P M K N S H	↓ 0,15-0,25 ↔ 0,15-0,40	
.5	P M K N S H	↓ 0,10-0,45 ↔ 0,15-0,60	
.A	P M K N S H	↓ 0,05-0,30 ↔ 0,10-0,30	
.C	P M K N S H	↓ 0,02-0,10	
.D	P M K N S H	↓ 0,03-0,15 ↔ 0,05-0,20	

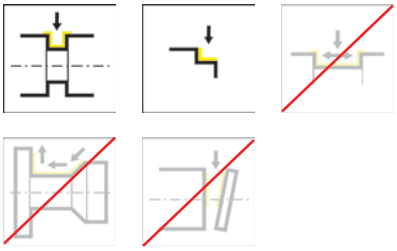
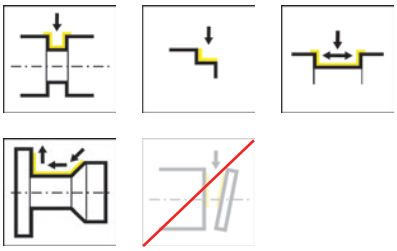
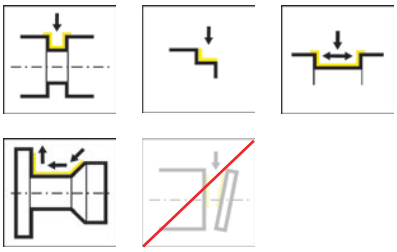
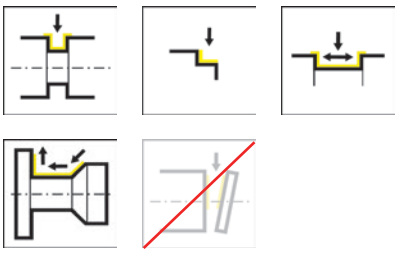
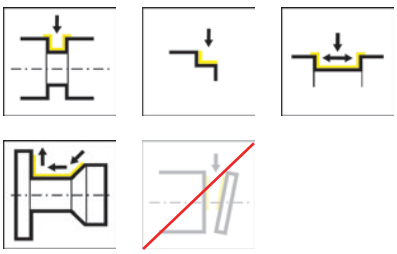
Geometrien und Vorschübe - Stechdrehen

Geometries and feed rates - Grooving

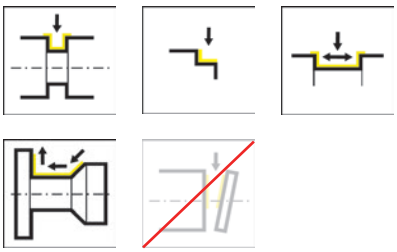
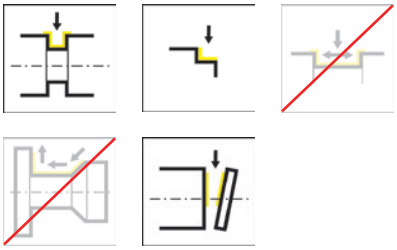
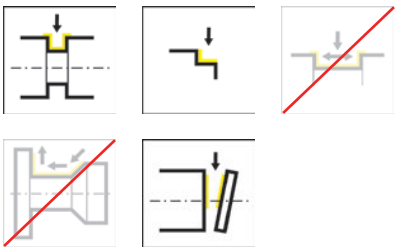
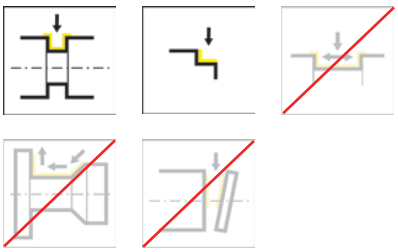
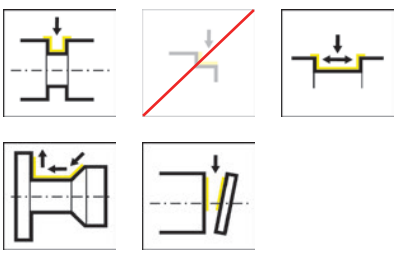
Geometrie Geometry	Werkstoff Material	Vorschubbereich f [mm/U] Feed rate f [mm/rev]	Bearbeitung Machining
.E	P M K N S H	0,08-0,30	
.EN	P M K N S H	0,10-0,45	
.EH	P M K N S H	0,25-0,4	
.F	P M K N S H	0,03-0,15	
.FY	P M K N S H	0,03-0,15	

Geometrien und Vorschübe - Stechdrehen

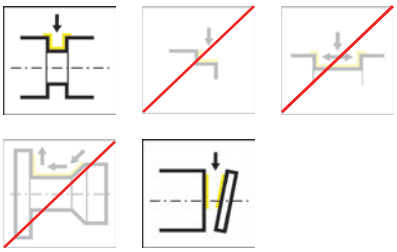
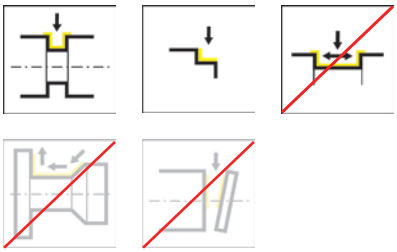
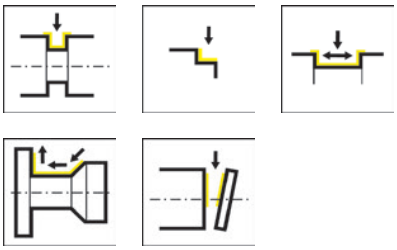
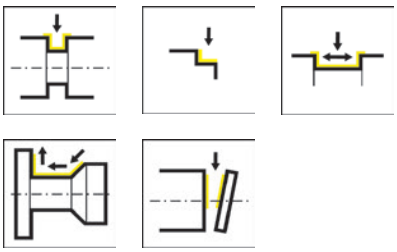
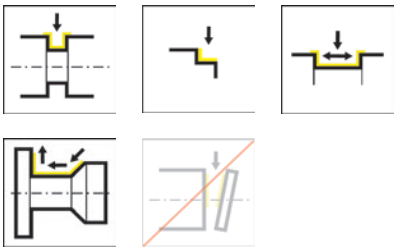
Geometries and feed rates - Grooving

Geometrie Geometry	Werkstoff Material	Vorschubbereich f [mm/U] Feed rate f [mm/rev]	Bearbeitung Machining
.H	P M K N S H	↓ 0,15-0,25 ↔ 0,10-0,25	
.K	P M K N S H	↓ 0,05-0,25 ↔ 0,05-0,25	
.KF	P M K N S H	↓ 0,10-0,45 ↔ 0,05-0,25	
.KR	P M K N S H	↓ 0,25-0,5 ↔ 0,25-0,5	
.L	P M K N S H	↓ 0,10-0,22 ↔ 0,05-0,20	

Geometrien und Vorschübe - Stechdrehen
Geometries and feed rates - Grooving

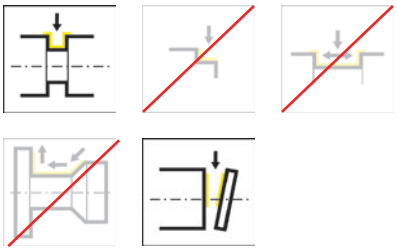
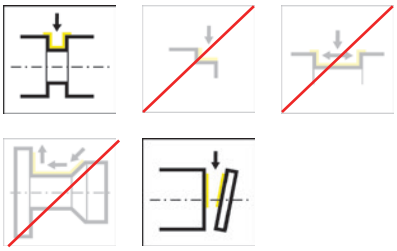
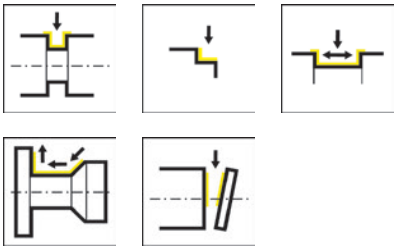
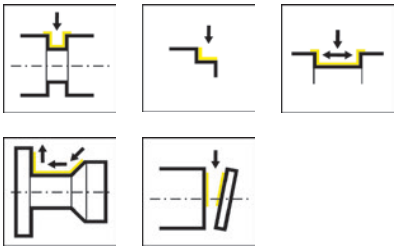
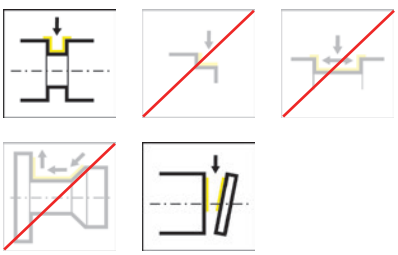
Geometrie Geometry	Werkstoff Material	Vorschubbereich f [mm/U] Feed rate f [mm/rev]	Bearbeitung Machining
.ZG	P M K N S H	↓ 0,10-0,22 ↔ 0,05-0,20	
.10	P M K N S H	↓ 0,05-0,15	
.20	P M K N S H	↓ 0,07-0,25	
.HR	P M K N S H	↓ 0,20-0,30	
.N	P M K N S H	↓ 0,05-0,25 ↔ 0,05-0,25	

Geometrien und Vorschübe - Stechdrehen
Geometries and feed rates - Grooving

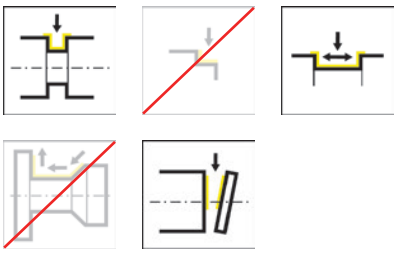
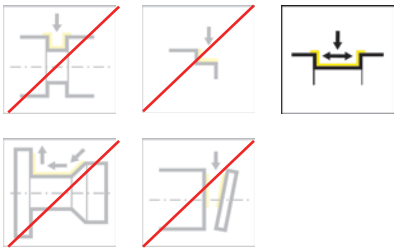
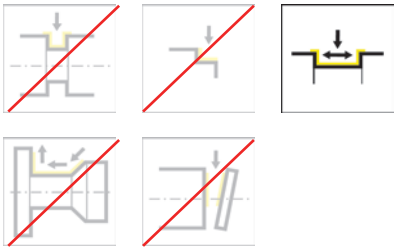
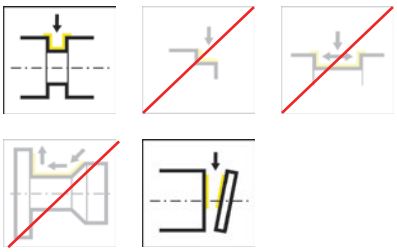
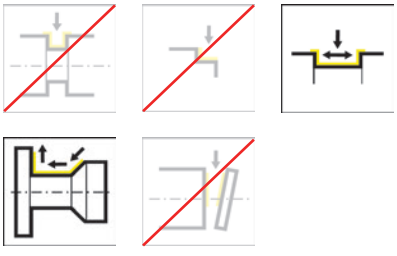
Geometrie Geometry	Werkstoff Material	Vorschubbereich f [mm/U] Feed rate f [mm/rev]	Bearbeitung Machining
.00	P M K N S H	↓ 0,02-0,12	
.1A	P M K N S H	↓ 0,03-0,12	
.M0	P M K N S H	↓ 0,02-0,10 ↔ 0,02-0,15	
.M	P M K N S H	↓ 0,02-0,12	
.P	P M K N S H	↓ 0,02-0,08 ↔ 0,02-0,04	

Geometrien und Vorschübe - Stechdrehen

Geometries and feed rates - Grooving

Geometrie Geometry	Werkstoff Material	Vorschubbereich f [mm/U] Feed rate f [mm/rev]	Bearbeitung Machining
.V	**P** M K N S H	↓ 0,04-0,15	
.3V	P **M** K **N** **S** H	↓ 0,05-0,20	
.FL	**P** M K N S H	↓ 0,03-0,15	
.DL	**P** M K N S H	↓ 0,05-0,15 ↔ 0,05-0,20	
.WA	P M K **N** S H	↓ 0,07-0,25	

Geometrien und Vorschübe - Stechdrehen
Geometries and feed rates - Grooving

Geometrie Geometry	Werkstoff Material	Vorschubbereich f [mm/U] Feed rate f [mm/rev]	Bearbeitung Machining
.WT	P M K N S H	↓ 0,06-0,08 ↔ 0,06-0,08	
.NC	P M K N S H	↓ 0,02-0,10 ↔ 0,02-0,15	
.FB	P M K N S H	↓ 0,02-0,10 ↔ 0,0015-0,07	
.S	P M K N S H	↓ 0,02-0,08	
.PT	P M K N S H	↔ 0,05-0,2	

Geometrien und Vorschübe - Nutstoßen

Geometries and feed rates - Broaching

Geometrie Geometry	Werkstoff Material	Bearbeitung Machining
.A	P M K N S H	Empfohlen für: Nutstoßaggregate Recommended for: Broaching units ap = 0,02 - 0,15 mm
.B	P M K N S H	Empfohlen für: konventionelles Stoßen Recommended for: Conventional broaching ap = 0,02 - 0,15 mm