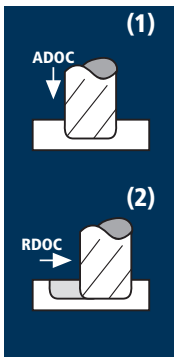




## Application

## Material

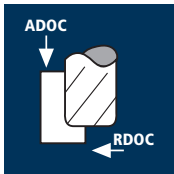


Construction aluminium  
Aviation  
[AlMg1SiCu / 6061]  
[AlCu4MgSi / 2017]  
[AlCu2Mg1,5Ni / 2618]  
[AlZn5,5MgCu / 7175]  
[AlZn6CuMgZr / 7150]  
[AlCu4Mg1 / 2124]

Wrought aluminium alloys  
[AlMgSi1 / 6082]

Cast aluminium  
[G-AlSi11Mg]

d1 [mm]	fl	FPT [mm]	ADOC [mm]	RDOC [mm]	RPM =	RPM =	RPM =	RPM =
					5000 min <sup>-1</sup>	10000 min <sup>-1</sup>	15000 min <sup>-1</sup>	20000 min <sup>-1</sup>
					Feed [mm/min]	Feed [mm/min]	Feed [mm/min]	Feed [mm/min]
3	2	0.050	2.0	3.0	500	1000	1500	2000
4	2	0.065	3.0	4.0	650	1300	1950	2600
6	2	0.100	4.0	6.0	1000	2000	3000	4000
8	2	0.130	5.0	8.0	1300	2600	3900	5200
10	2	0.165	5.5	10.0	1650	3300	4950	6600
12	2	0.195	6.0	12.0	1950	3900	5850	7800
16	2	0.210	6.5	16.0	2100	4200	6300	
20	2	0.220	7.0	20.0	2200	4400		
25	2	0.230	7.0	25.0	2300			

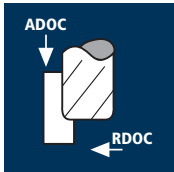


Construction aluminium  
[AlZn5,5MgCu / 7175]  
Wrought aluminium alloys  
[AlMgSi1 / 6082]  
Cast aluminium  
[G-AlSi11Mg]

3	2	0.050	3.0	1.8	500	1000	1500	2000
4	2	0.065	4.5	2.4	650	1300	1950	2600
6	2	0.100	6.0	3.6	1000	2000	3000	4000
8	2	0.130	7.5	4.8	1300	2600	3900	5200
10	2	0.165	8.3	6.0	1650	3300	4950	6600
12	2	0.195	9.0	7.2	1950	3900	5850	7800
16	2	0.210	9.8	9.6	2100	4200	6300	
20	2	0.220	10.5	12.0	2200	4400		
25	2	0.230	10.5	15.0	2300			

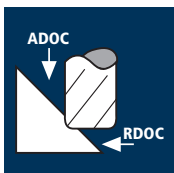
## Application

## Material



Construction aluminium  
[AlZn5,5MgCu / 7175]  
Wrought aluminium alloys  
[AlMgSi1 / 6082]  
Cast aluminium  
[G-AlSi11Mg]

d1 [mm]	fl	FPT [mm]	ADOC [mm]	RDOC [mm]	RPM =	RPM =	RPM =	RPM =
					5000 min <sup>-1</sup>	10000 min <sup>-1</sup>	15000 min <sup>-1</sup>	20000 min <sup>-1</sup>
					Feed [mm/min]	Feed [mm/min]	Feed [mm/min]	Feed [mm/min]
3	2	0.015	2.5	0.10	150	300	450	600
4	2	0.020	3.5	0.10	200	400	600	800
6	2	0.030	5.0	0.20	300	600	900	1200
8	2	0.040	7.0	0.25	400	800	1200	1600
10	2	0.050	8.5	0.30	500	1000	1500	2000
12	2	0.060	10.5	0.35	600	1200	1800	2400
16	2	0.065	15.0	0.50	650	1300	1950	2600
20	2	0.065	19.0	0.60	650	1300	1950	2600
25	2	0.070	23.5	0.75	700	1400	2100	2800



Construction aluminium  
[AlZn5,5MgCu / 7175]  
Wrought aluminium alloys  
[AlMgSi1 / 6082]  
Cast aluminium  
[G-AlSi11Mg]

*ap <sub>im</sub> see page 559								
3	2	0.110	0.30	0.30	1100	2200	3300	4400
4	2	0.145	0.35	0.35	1450	2900	4350	5800
6	2	0.220	0.40	0.40	2200	4400	6600	8800
8	2	0.285	0.45	0.45	2850	5700	8550	11400
10	2	0.365	0.50	0.50	3650	7300	10950	14600
12	2	0.430	0.60	0.60	4300	8600	12900	17200
16	2	0.460	0.75	0.75	4600	9200	13800	18400
20	2	0.485	1.00	1.00	4850	9700	14550	19400
25	2	0.505	1.20	1.20	5050	10100	15150	20200