

Schnittgeschwindigkeiten auf der Unimat 3

	BC-1 - I	BC-1 - II	BC-2 - I	BC-2 - II	AC-1 - I	AC-1 - II	AC-2 - I	AC-2 - II
Spindel-Geschwindigkeit in U/min								
	130	200	350	560	920	1500	2450	4000
1	0.4	0.6	1.1	1.8	2.9	4.7	7.7	12.6
2	0.8	1.3	2.2	3.5	5.8	9.4	15.4	25.1
3	1.2	1.9	3.3	5.3	8.7	14.1	23.1	37.7
4	1.6	2.5	4.4	7.0	11.6	18.8	30.8	50.3
5	2.0	3.1	5.5	8.8	14.5	23.6	38.5	62.8
6	2.5	3.8	6.6	10.6	17.3	28.3	46.2	75.4
7	2.9	4.4	7.7	12.3	20.2	33.0	53.9	88.0
8	3.3	5.0	8.8	14.1	23.1	37.7	61.6	100.5
9	3.7	5.7	9.9	15.8	26.0	42.4	69.3	113.1
10	4.1	6.3	11.0	17.6	28.9	47.1	77.0	125.7
11	4.5	6.9	12.1	19.4	31.8	51.8	84.7	138.2
12	4.9	7.5	13.2	21.1	34.7	56.5	92.4	150.8
13	5.3	8.2	14.3	22.9	37.6	61.3	100.1	163.4
14	5.7	8.8	15.4	24.6	40.5	66.0	107.8	175.9
15	6.1	9.4	16.5	26.4	43.4	70.7	115.5	188.5
16	6.5	10.1	17.6	28.1	46.2	75.4	123.2	201.1
17	6.9	10.7	18.7	29.9	49.1	80.1	130.8	213.6
18	7.4	11.3	19.8	31.7	52.0	84.8	138.5	226.2
19	7.8	11.9	20.9	33.4	54.9	89.5	146.2	238.8
20	8.2	12.6	22.0	35.2	57.8	94.2	153.9	251.3
21	8.6	13.2	23.1	36.9	60.7	99.0	161.6	263.9
22	9.0	13.8	24.2	38.7	63.6	103.7	169.3	276.5
23	9.4	14.5	25.3	40.5	66.5	108.4	177.0	289.0
24	9.8	15.1	26.4	42.2	69.4	113.1	184.7	301.6
25	10.2	15.7	27.5	44.0	72.3	117.8	192.4	314.2
26	10.6	16.3	28.6	45.7	75.1	122.5	200.1	326.7
27	11.0	17.0	29.7	47.5	78.0	127.2	207.8	339.3
28	11.4	17.6	30.8	49.3	80.9	131.9	215.5	351.9
29	11.8	18.2	31.9	51.0	83.8	136.7	223.2	364.4
30	12.3	18.8	33.0	52.8	86.7	141.4	230.9	377.0

Alle Werte angegeben in $\frac{m}{min}$

Empfehlung aus dem Unimat Handbuch

Material	Material	Ø des Werkstücks				Ø of work			U/min. rpm.
		- 5mm - 3/16"	5 - 10mm 3/16" - 3/8"	10 - 20mm 3/8 - 3/4"	20 - 35mm 3/4" - 1 3/8"	35 - 50mm 1 3/8" - 2"	50 - 90mm 2" - 3 9/16"		
Stahl	Steel	1500	920	560	350	200	130		
Buntmetall	Fancy Metal	2450	1500	920	560	350	200		
Holz, Kunststoff	Wood, Plastic	2450				1500	920		