

DE=		EN=				PT=				VN=			
Schnittmeter Info		Cutting Speed Info				Informacia				tiếng việt or other			
A	B	C	D	E	F	G	H	I	K	L	M	N	
1	Meter per Minute		de=	500 N/mm2	500-800	800-1200	Stahl	Stahl			Legierung	PVC	
2	Meter Minute		en=	Steel	Steel	Steel	Stainless	Tool	Iron	Brass	Aluminium	Plastic	
3	Metros / min.		pt=	Aco	Aco	Aco	Aco	Aco	fondogao	Lafao	Aluminio	Mat.	
4	Mét/ phút		vn=	Thép	Thép	Thép	thép	thép	gang	Đồng	Nhôm	Nhựa	
5	DE=	EN=	PT=	500 N/mm2	500-800	800-1200	không rỉ	dụng cụ		thau			
6	HSS, Hochleistungst	HSS, High Cutting Stee	Aço Rapido	Thép gió	24	18	12	8	12	18	50	70	45
7	HSS Tin	HSS Tin	Aço Rapido com cober	Thép gió mỏng	32	24	15	10	15	24	70	93	60
8	HM, Hartmetall	HP,Carbide	Metal duro	HỢp kim	100	72	48	30	48	72	280	280	180
9	Drehen aussen	Turn outside	Tornear externo	Tiện ngoài	100%	100%	100%	100%	100%	100%	100%	100%	100%
10	Drehen innen	Turn Inside	Tornear interno	Tiện trong	80%	80%	80%	80%	80%	80%	80%	80%	80%
11	Einstechen	Groove	Tornear entahle	Xoi rãnh	35%	35%	35%	35%	35%	35%	35%	35%	35%
12	Bohren	Drilling	Furar	Khoan	100%	100%	100%	100%	100%	100%	100%	100%	100%
13	Aufbohren	Biger Bore	Alargar furo	khoan lỗ lớn	66%	66%	66%	66%	66%	66%	66%	66%	66%
14	Flachsenken	Counterbore	Facear plano	Lã phẳng	66%	66%	66%	66%	66%	66%	66%	66%	66%
15	90° Senken	90 degree sinks	Chanfrar 90°	Lã 90 độ	33%	33%	33%	33%	33%	33%	33%	33%	33%
16	Reiben	Reamer Tool	Alargar Escarear	Doa	33%	33%	33%	33%	33%	33%	33%	33%	33%
17	Gewinde schneider	Thread Cutting	Fazer rosca	Làm răng	33%	33%	33%	33%	33%	33%	33%	33%	33%
18	<div style="display: flex; justify-content: space-between;"> <div style="width: 45%;"> <p>Bohrer Drehzahl Drill Speed</p> <p>$\text{Umfang Bohrer} \times \frac{3.14}{\pi} = \text{Scope Drill}$</p> <p>HSS High speed steel 24 m / Min = 24000 mm</p> <p>$\text{Umfang} = \text{Umdrehung RPM Bohrer Drill}$</p> </div> <div style="width: 45%;"> <p>Spindel Drehzahl für HM Platten Spindle Speed for carbide Insert</p> <p>HM Hartmetall 100 m / Min = 100 000 mm</p> <p>Carbide Insert =</p> <p>$\text{Umfang Dreh Durchm.} = \text{Scope Turn Dia meter}$</p> <p>$\text{Umfang Dreh Durchm.} = \text{RPM Main Spindle}$</p> </div> </div>												
design:	hpw	Datum: 2009	education project	Schnittmeter Info	translate/en_iwhp/p_cu/vn_ha	origin:wiap_kfkok							
Aenderung:	iw,sw	Datum:4.9.2011	WIAP KFKOK	Cutting Speed Info	r14a	datei_wi_8_f_1_3_b6_r14a_Schnittm							
Aenderung:	an	Datum: 13.05.2015	Safenwil Schweiz	old wi_8_f_3_a	www.wiap.ch	idee of / from hpw							