DE = Sprache 1	EN = Language 2	P = Language 3	VN = Language 4
Schnittmeter Info	Cutting Speed Info	Informacia	tiếng việt or other

Meter per Minute				German	Stahl	Stahl	Stahl	Rostfreier Stahl	Werkzeug Stahl	Grauguss	Messing	Aluminium Legierung	Kunstoff PVC
Meter Minute				English	Steel	Steel	Steel	Stainless Steel	Tool Steel	Iron Casting	Brass	Aluminium	Plastic
Metros / min.				*Portugese*	*Aco*	*Aco*	*Aco*	*Aco Inoxida*	*Aco Ferramenta*	*fondogao cinza*	*Lafao*	*Aluminio*	*Mat.Plastico*
Mét/ phút				Tiếng Việt	Thép 500 N/mm2	Thép 500-800	Thép 800-1200	thép không rỉ	thép dụng cụ	gang	Đồng thau	Nhôm	Nhựa
	German	English	Portugês										
1	HSS, Hochleistungst.	HSS, High Cutting Steel	*A ç o Rapido*	Thép gió	**24**	**18**	**12**	**8**	**12**	**18**	**50**	**70**	**45**
2	HSS Tin	HSS Tin	*Aço Rapido com cobertor*	Thép gió mỏng	**32**	**24**	**15**	**10**	**15**	**24**	**70**	**93**	**60**
3	HM, Hartmetall	HP,Carbide	*Metal duro*	Hợp kim	**100**	**72**	**48**	**30**	**48**	**72**	**280**	**280**	**180**
4	Drehen aussen	Turn oustside	*Tornear externo*	Tiện ngoài	100%	100%	100%	100%	100%	100%	100%	100%	100%
5	Drehen innen	Turn Inside	*Tornear interno*	Tiện trong	80%	80%	80%	80%	80%	80%	80%	80%	80%
6	Einstechen	Groove	*Tornear entahle*	Xoi rãnh	35%	35%	35%	35%	35%	35%	35%	35%	35%
7	Bohren	Drilling	*Furar*	Khoan	100%	100%	100%	100%	100%	100%	100%	100%	100%
8	Aufbohren	Biger Bore	*Alargar furo*	khoan lỗ lớn	66%	66%	66%	66%	66%	66%	66%	66%	66%
9	Flachsenken	Counterbore	*Facear plano*	Lã phẳng	66%	66%	66%	66%	66%	66%	66%	66%	66%
10	90° Senken	90 degree sinks	*Chanfrar 90°*	Lã 90 độ	33%	33%	33%	33%	33%	33%	33%	33%	33%
11	Reiben	Reamer Tool	*Alargar Escarear*	Doa	33%	33%	33%	33%	33%	33%	33%	33%	33%
12	Gewinde schneiden	Thread Cutting	*Fazer rosca*	Làm răng	33%	33%	33%	33%	33%	33%	33%	33%	33%

Bohrer Drehzahl Drill Speed	Ø	×	3.14 pi π	=	Umfang Bohrer / Scope Drill	HHS High speed steel 24 m / Min = 24000 mm	:	Umfang / Scope	=	Umdrehung RPM Bohrer Drill	←

Spindel Drehzahl für HM Platten / **Spindle Speed for carbide Insert**	Durchm. Diameter	×	3.14 pi π	=	Umfang Dreh Durchm. / Scope Turn Dia meter	HM Hartmetall 100 m / Min = 100 000 mm / Carbide Insert =	:	Umfang Dreh Durchm. / Scope Turn Dia meter	=	Umdrehung Spindel / RPM Main Spindle	Futter Jack / Fräswerkzeug Milling Tool

design:	hpw	Datum: 2009	**eduction project**	**Cutting Speed Information**	translate/en_iwhp/p_cu/vn_ha	orign:wiap_kfkok
Aenderung:	iw,sw	Datum:4.9.2011	**WIAP KFKOK**	spear 1	qref11	datei_wi_8_f_3_b6
Aenderung:	control 2	Data:	**Safenwil Schweiz**	spear 2	www.wiap.ch	idee of / from hpw