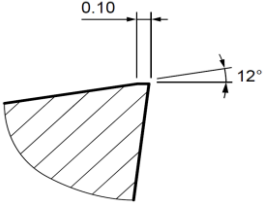
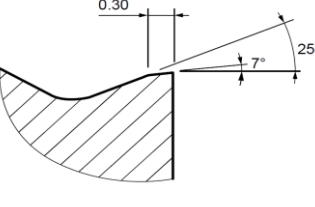


Schnittwertempfehlung CM20TU						
Werkstoffgruppe		V <sub>c</sub> [mm/min]	Positiv		Negativ	
			A <sub>p</sub> [mm]	f [mm/U]	A <sub>p</sub> [mm]	f [mm/U]
P	1	150-250	0,15-2,25	0,07-0,20	1,00-4,20	0,22-0,40
	2	100-200				
	3	120-220				
	4	120-220				
M	1	190-250				
	2	140-220				
	3	110-170				