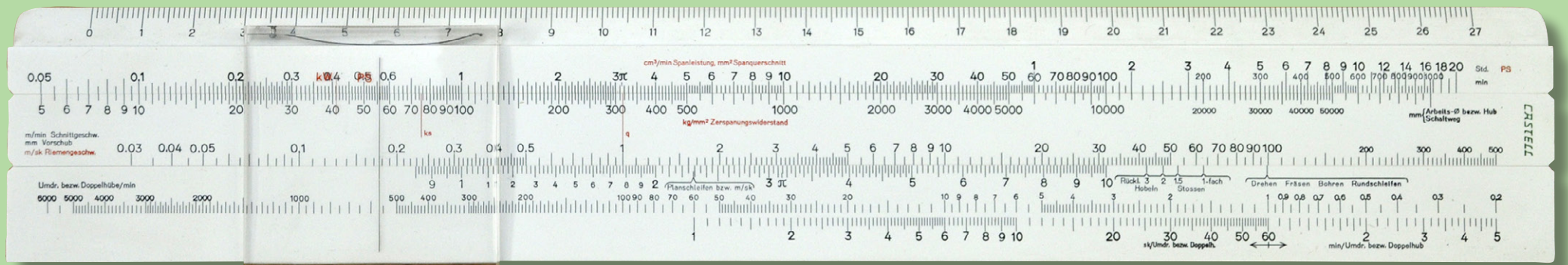
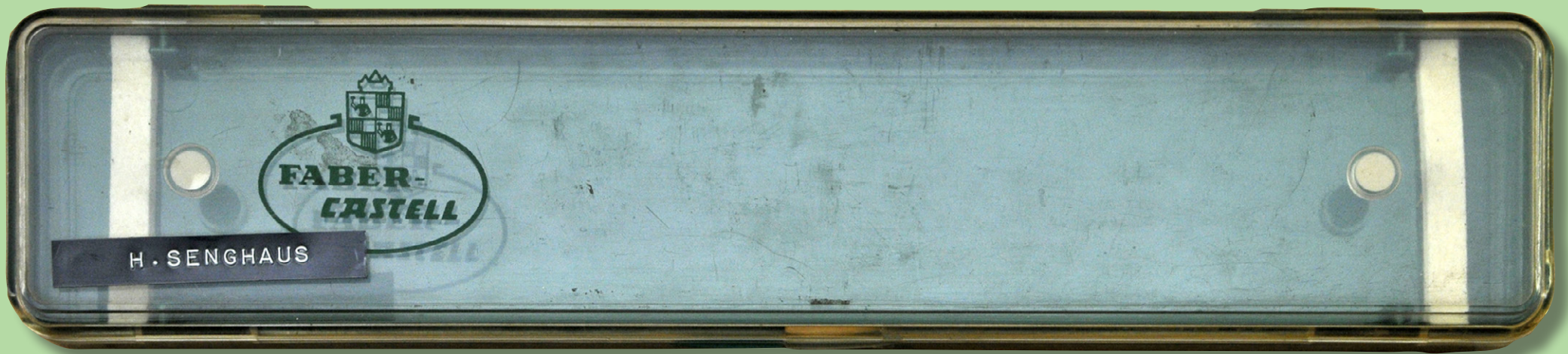


Faber Castell 111/48 (30 cm)

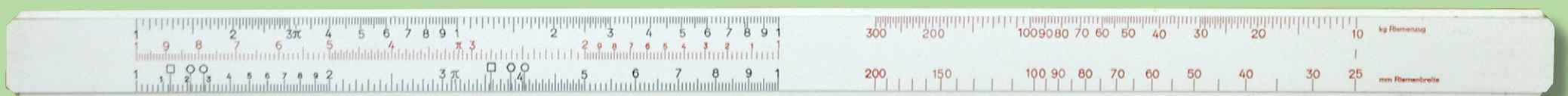
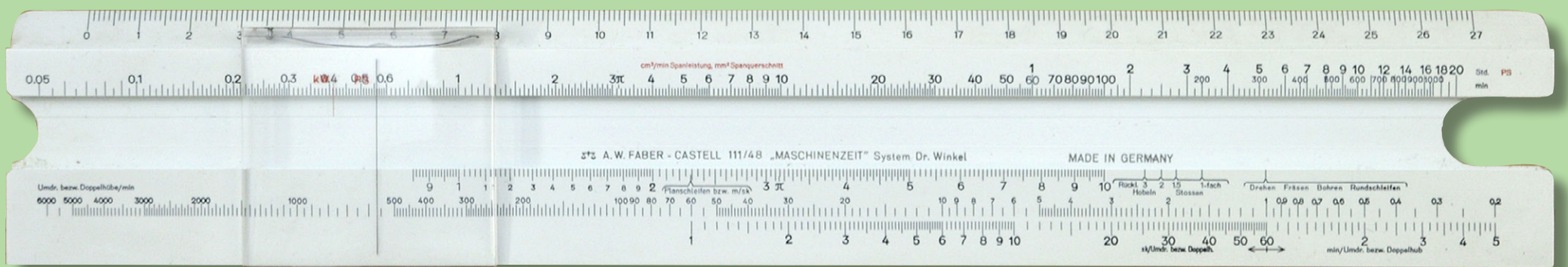
Variante 1



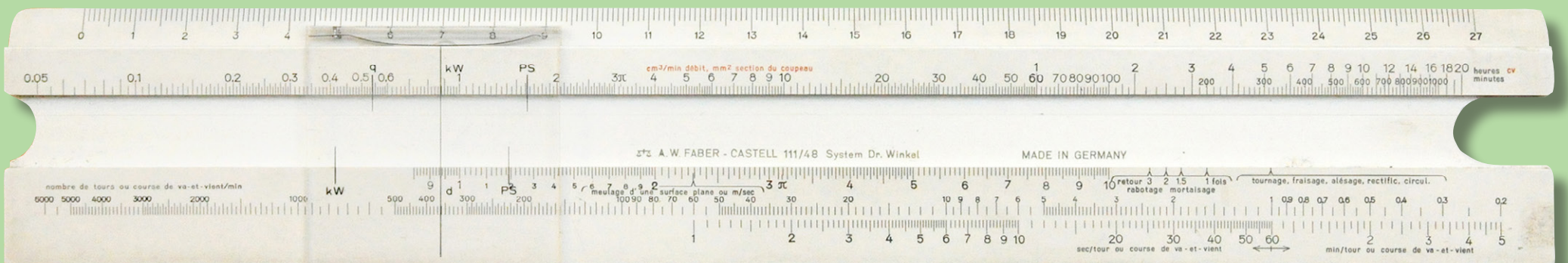
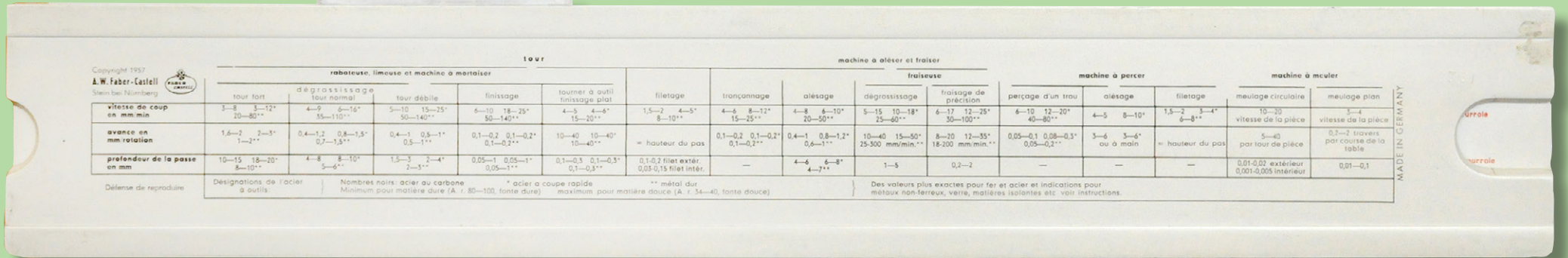
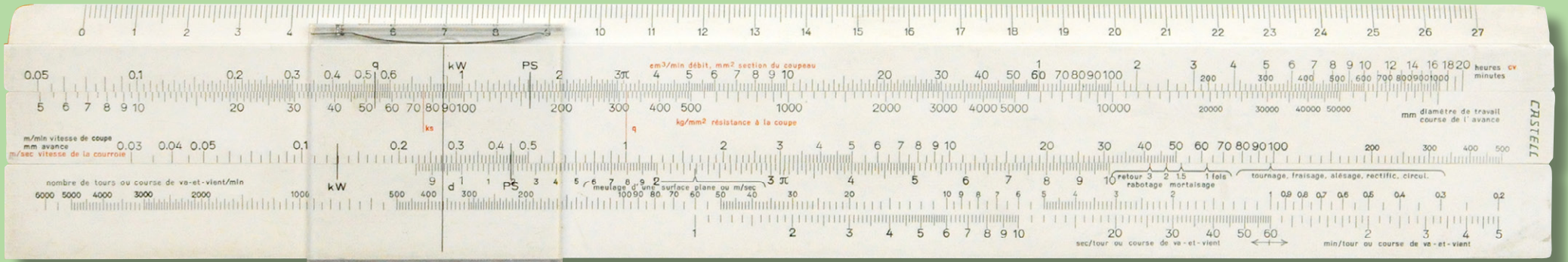
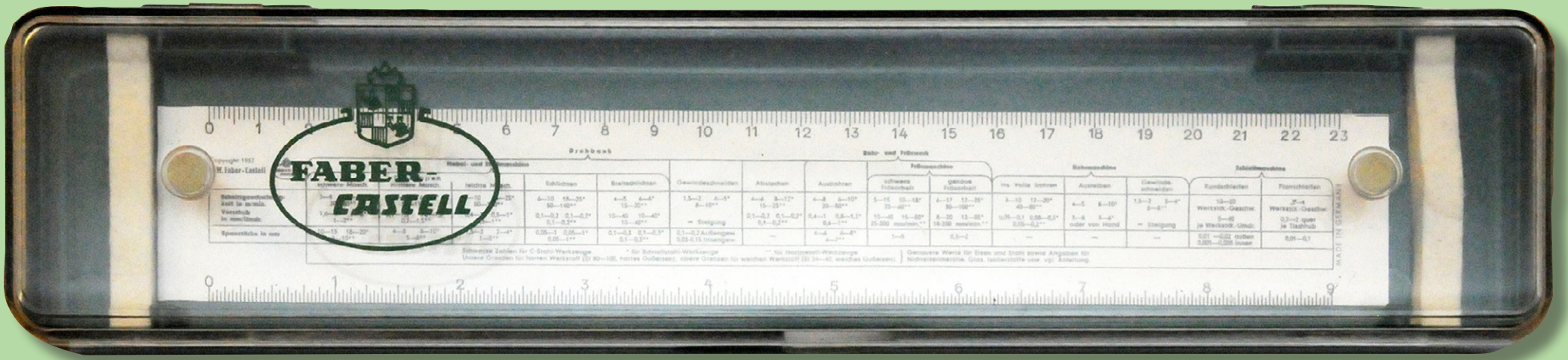
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| | Drehbank | | | | | Bohr- und Fräswerk | | | | | | | | | |
|----------------------------------|-------------------------|------------------|----------------|------------------|------------------|-------------------------------------|------------------|--------------------|-------------------|-------------------|--------------------|-----------------------------------|------------------------|-----------------|--|
| | Hebel- und Stoßmaschine | | Schruppen | | | Gewindeschneiden | Abstachen | Ausbohren | | Fräsmaschine | | Bohrmaschine | | Schleifmaschine | |
| | schwere Masch. | mittlere Masch. | leichte Masch. | Schlichten | Breitschlichten | | | schwere Fräsarbeit | genaue Fräsarbeit | ins. Volla bohren | Ausreiben | Gewinde-schneiden | Rundscheißen | Planscheißen | |
| Schnittgeschwindigkeit in m/min. | 5-8 5-12* | 4-8 6-16* | 5-10 15-25* | 6-10 18-35* | 4-5 4-6* | 1,5-2 4-5* | 4-6 8-12* | 4-8 6-10* | 5-15 10-18* | 6-17 12-25* | 6-10 12-20* | 10-30 | 3-4 | | |
| Vorschub in mm/Umdr. | 1,6-2 2-3* | 0,4-1,2 0,8-1,5* | 0,4-1 0,5-1* | 0,1-0,2 0,1-0,2* | 10-40 10-40* | = Steigung | 0,1-0,2 0,1-0,3* | 0,4-1 0,8-1,2* | 10-40 15-50* | 8-20 12-35* | 0,05-0,1 0,08-0,3* | 5-6 3-4* oder von Hand | 0,2-2 quer je Tischhub | | |
| Spanstärke in mm | 10-15 18-20* | 4-8 8-10* | 1,5-3 2-4* | 0,05-1 0,05-1* | 0,1-0,3 0,1-0,3* | 0,1-0,7 Außengew. 0,1-0,3 Innengew. | 4-6 6-8* | 1-5 | 0,2-2 | | | 0,01-0,02 außen 0,001-0,005 innen | 0,01-0,1 | | |

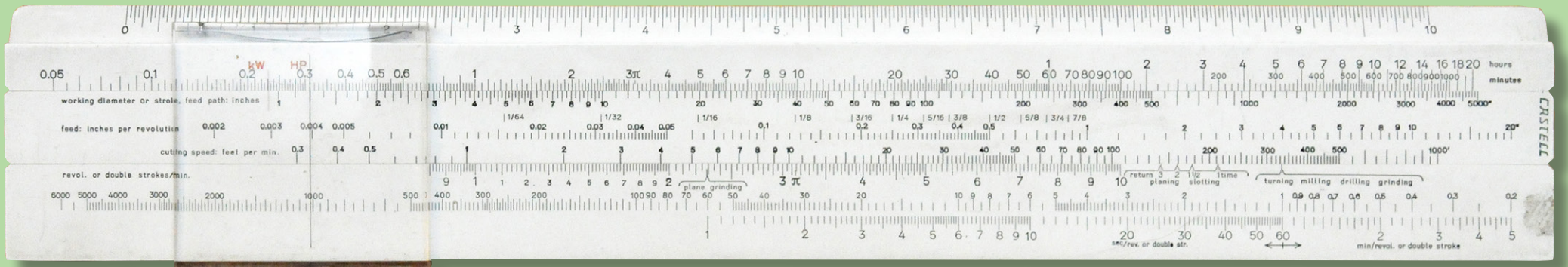
Schwarze Zahlen für C-Stahl-Werkzeuge. * für Schnellstahl-Werkzeuge. ** für Hartmetall-Werkzeuge. Genauere Werte für Eisen und Stahl sowie Angaben für Nichtfermetalle, Glas, Isolierstoffe usw. vgl. Anleitung. Untere Grenzen für harten Werkstoff (St 80-100, hartes Gußeisen), obere Grenzen für weichen Werkstoff (St 36-40, weiches Gußeisen).



Variante 2



Variante 3



| Lathes | | | | Milling machines | | | | Drilling machines | | Grinding machines | | | | | | | | | | | | | |
|--|--|--|--|-----------------------------------|--|-------------------------------------|--|-------------------|--|-------------------|--|------------------|--|----------------|--|--------------|--|--------------|--|-------------------|--|------------------|--|
| Planing, shaping and slotting machines | | | | combined boring and milling mach. | | | | | | | | | | | | | | | | | | | |
| rough turning or planing | | | | finishing | | finishing by (swan-neck) springtool | | boring | | rough milling | | accurate milling | | rough drilling | | reaming | | tapping | | circular grinding | | surface grinding | |
| heavy duty mach. | | | | med. duty mach. | | light duty mach. | | 10-26 15-40* | | 15-35 20-55* | | 16-33 30-60* | | 20-33 40-64* | | 20-33 40-64* | | 15-16 26-33* | | 5-7 10-13* | | 5-7 10-13* | |
| Cutting speed: feet per min. | | | | 10-26 15-40* | | 15-35 20-55* | | 16-33 30-60* | | 20-33 40-64* | | 20-33 40-64* | | 20-33 40-64* | | 15-16 26-33* | | 5-7 10-13* | | 5-7 10-13* | | 5-7 10-13* | |
| Feed: inches per rev. | | | | 1/32-1/16 | | 1/32-1/16 | | 1/32-1/16 | | 1/32-1/16 | | 1/32-1/16 | | 1/32-1/16 | | 1/32-1/16 | | 1/32-1/16 | | 1/32-1/16 | | 1/32-1/16 | |
| Depth of cut: inches | | | | 1/32-1/16 | | 1/32-1/16 | | 1/32-1/16 | | 1/32-1/16 | | 1/32-1/16 | | 1/32-1/16 | | 1/32-1/16 | | 1/32-1/16 | | 1/32-1/16 | | 1/32-1/16 | |

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Black numbers for carbon steel tools. * for high-speed tools. ** for cemented carbide tools.

Lower limits for hard material (steel of a strength above 45 tons per sq. inch, chill casting) upper limits for soft material (steel of a strength below 25 tons per sq. inch, soft cast iron). Exact estimates for iron and steel as well as data for non-ferrous metals, glass, insulation material etc. see table annexed to the instruction.

MADE IN GERMANY

