

| Materiale | Aluminium | | | | Kobber | | | |
|-----------|-----------|------|-------|-----|--------|-----|-------|-----|
| | n | vf | n | vf | n | vf | n | vf |
| 2 | 35032 | 1261 | 25478 | 917 | 35032 | 561 | 25478 | 408 |
| 3 | 23355 | 1168 | 16985 | 849 | 23355 | 467 | 16985 | 340 |
| 4 | 17516 | 1226 | 12739 | 892 | 17516 | 525 | 12739 | 382 |
| 5 | 14013 | 1121 | 10191 | 815 | 14013 | 561 | 10191 | 408 |
| 6 | 11677 | 1168 | 8493 | 849 | 11677 | 584 | 8493 | 425 |
| 8 | 8758 | 963 | 6369 | 701 | 8758 | 525 | 6369 | 382 |
| 10 | 7006 | 911 | 5096 | 662 | 7006 | 490 | 5096 | 357 |
| 12 | 5839 | 993 | 4246 | 722 | 5839 | 467 | 4246 | 340 |
| 14 | 5005 | 951 | 3640 | 692 | 5005 | 500 | 3640 | 364 |
| 16 | 4379 | 1007 | 3185 | 732 | 4379 | 525 | 3185 | 382 |
| 18 | 3892 | 1051 | 2831 | 764 | 3892 | 545 | 2831 | 396 |
| 20 | 3503 | 1121 | 2548 | 815 | 3503 | 561 | 2548 | 408 |

FORKLARING
 n = omdr. pr. min.
 vc = hastighed mtr. pr. min.
 fz = tilspænding mm/z
 vf = tilspænding mm/min
 z = antal skær
 Q = hastighed for spånafgang (cm³/min)
 ae = spånbredde
 ap = spåndybde

FORMLER*
 $n = (vc \times 1000) / (\emptyset \times \pi)$
 $vc = (\emptyset \times \pi \times n) / 1000$
 $fz = vf / z \times n$
 $vf = fz \times z \times n$
 $Q = ae \times ap \times vf / 1000$