

Schnittdaten
Données de coupe
Parametri di lavoro
Cutting data

Art. 44400

Mat.		∅ 0.80–1.50	∅ 2.00–3.00	∅ 4.00–6.00
P1	V _c	140–160	140–160	140–160
	f _z	0.020–0.030	0.030–0.040	0.040–0.060
P2	V _c	120–140	120–140	120–140
	f _z	0.010–0.020	0.020–0.030	0.030–0.050
P3	V _c	100–120	100–120	100–120
	f _z	0.005–0.015	0.015–0.025	0.025–0.045
M1	V _c	100–120	100–120	100–120
	f _z	0.010–0.020	0.020–0.030	0.030–0.050
M2	V _c	80–100	80–100	80–100
	f _z	0.005–0.015	0.015–0.025	0.025–0.045
K1	V _c	120–140	120–140	120–140
	f _z	0.015–0.025	0.025–0.035	0.035–0.055
K2	V _c	100–120	100–120	100–120
	f _z	0.010–0.020	0.020–0.030	0.030–0.040
N1	V _c	230–250	230–250	230–250
	f _z	0.020–0.030	0.030–0.040	0.040–0.060
N2	V _c	200–220	200–220	200–220
	f _z	0.020–0.030	0.030–0.040	0.040–0.060
N3	V _c	180–200	180–200	180–200
	f _z	0.020–0.030	0.030–0.040	0.040–0.060
N4	V _c	80–100	80–100	80–100
	f _z	0.015–0.025	0.025–0.035	0.035–0.055
N5	V _c	130–150	130–150	130–150
	f _z	0.015–0.025	0.025–0.035	0.035–0.055
N6	V _c	100–120	100–120	100–120
	f _z	0.010–0.020	0.020–0.030	0.030–0.050
N7	V _c	100–120	100–120	100–120
	f _z	0.010–0.020	0.020–0.030	0.030–0.050
N8	V _c	100–120	100–120	100–120
	f _z	0.010–0.020	0.020–0.030	0.030–0.050
S1	V _c	60–80	60–80	60–80
	f _z	0.010–0.020	0.020–0.030	0.030–0.050
S2	V _c	40–60	40–60	40–60
	f _z	0.005–0.015	0.015–0.025	0.025–0.045
H1	V _c	40–60	40–60	40–60
	f _z	0.005–0.015	0.015–0.025	0.025–0.035
H2	V _c	30–50	30–50	30–50
	f _z	0.005–0.010	0.010–0.020	0.020–0.030
H3	V _c			
	f _z			
O1	V _c	140–160	140–160	140–160
	f _z	0.015–0.025	0.025–0.035	0.035–0.055
O2	V _c			
	f _z			
O3	V _c			
	f _z			

Genannte Werte sind Richtwerte, die je nach Maschine, Aufspannung, Kühlschmierstoff usw. noch angepasst werden müssen.

Les valeurs mentionnées sont des valeurs recommandées qui doivent être adaptées selon les conditions de la machine, du serrage, du lubrifiant etc.

Questi valori sono valori raccomandati che devono essere adattati secondo le condizioni della macchina, del serraggio, del lubrificante etc.

These are recommended values that depend on the condition of the machine, fixture, coolant etc., and they may have to be adapted yet.