

**Schnittdaten**  
**Données de coupe**  
**Parametri di lavoro**  
**Cutting data**

**Art. 50622**

Mat.		∅ 0.20-0.50	∅ 0.51-1.00	∅ 1.01-2.00	∅ 2.01-3.00
P1	Vc	8-20	20-40	20-40	20-40
	f	0.001-0.010	0.010-0.020	0.020-0.030	0.030-0.045
P2	Vc	6-18	18-38	18-38	18-38
	f	0.001-0.008	0.008-0.018	0.018-0.028	0.028-0.042
P3	Vc	5-14	14-30	14-30	14-30
	f	0.001-0.007	0.007-0.016	0.016-0.025	0.025-0.038
M1	Vc	5-14	14-30	14-30	14-30
	f	0.001-0.007	0.007-0.016	0.016-0.025	0.025-0.038
M2	Vc				
	f				
K1	Vc	8-20	20-40	20-40	20-40
	f	0.001-0.010	0.010-0.020	0.020-0.030	0.030-0.045
K2	Vc	6-18	18-38	18-38	18-38
	f	0.001-0.008	0.008-0.018	0.018-0.028	0.028-0.042
N1	Vc				
	f				
N2	Vc	10-25	25-55	25-55	25-55
	f	0.001-0.010	0.010-0.020	0.020-0.030	0.030-0.045
N3	Vc	8-22	22-50	22-50	22-50
	f	0.001-0.008	0.008-0.018	0.018-0.028	0.028-0.042
N4	Vc				
	f				
N5	Vc	8-22	22-50	22-50	22-50
	f	0.001-0.010	0.010-0.020	0.020-0.035	0.035-0.060
N6	Vc				
	f				
N7	Vc				
	f				
N8	Vc				
	f				
S1	Vc				
	f				
S2	Vc				
	f				
H1	Vc	2-5	5-12	5-12	5-12
	f	0.001-0.004	0.004-0.008	0.008-0.015	0.015-0.025
H2	Vc				
	f				
H3	Vc				
	f				
O1	Vc				
	f				
O2	Vc				
	f				
O3	Vc				
	f				

**Art. 12604**

Mat.		∅ 0.05-0.30	∅ 0.31-0.80	∅ 0.81-1.50	∅ 1.55-3.17
P1	Vc	1.0-2.0	2.0-8.0	8.0-20	8.0-20
	f	0.001-0.005	0.005-0.011	0.010-0.015	0.014-0.021
P2	Vc	0.5-1.5	1.5-7.0	7.0-16	7.0-16
	f	0.001-0.002	0.002-0.006	0.005-0.009	0.008-0.012
P3	Vc				
	f				
M1	Vc	0.5-1.5	1.5-7.0	7.0-16	7.0-16
	f	0.001-0.002	0.002-0.006	0.005-0.009	0.008-0.015
M2	Vc	0.5-1.2	1.2-6.0	6.0-15	6.0-15
	f	0.001-0.002	0.002-0.005	0.004-0.007	0.006-0.012
K1	Vc	1.0-5.0	5.0-10	10-20	10-20
	f	0.001-0.005	0.004-0.011	0.010-0.015	0.014-0.020
K2	Vc	0.8-4.0	4.0-8.0	8.0-18	8.0-18
	f	0.001-0.004	0.003-0.008	0.007-0.011	0.010-0.016
N1	Vc	2.0-7.0	7.0-13	13-25	13-25
	f	0.001-0.004	0.003-0.010	0.009-0.016	0.015-0.022
N2	Vc	1.5-6.0	6.0-12	12-22	12-22
	f	0.001-0.005	0.004-0.011	0.010-0.020	0.018-0.035
N3	Vc				
	f				
N4	Vc				
	f				
N5	Vc	2.0-7.0	7.0-13	13-25	13-25
	f	0.001-0.004	0.003-0.010	0.009-0.018	0.017-0.030
N6	Vc				
	f				
N7	Vc				
	f				
N8	Vc				
	f				
S1	Vc				
	f				
S2	Vc				
	f				
H1	Vc				
	f				
H2	Vc				
	f				
H3	Vc				
	f				
O1	Vc				
	f				
O2	Vc				
	f				
O3	Vc				
	f				

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.