

# Schnittdaten

## Données de coupe

### Parametri di lavoro

### Cutting data

#### Art. 51609

Mat.		ø 0.30-0.95	ø 1.00-1.95	ø 2.00-3.00
P1	Vc	50-70	70-100	70-100
	f	0.010-0.025	0.025-0.040	0.040-0.055
P2	Vc	40-60	60-80	60-80
	f	0.010-0.025	0.025-0.035	0.035-0.050
P3	Vc	30-50	50-70	50-70
	f	0.010-0.020	0.015-0.025	0.025-0.040
M1	Vc	20-35	30-45	30-45
	f	0.005-0.008	0.015-0.025	0.025-0.035
M2	Vc	20-30	25-35	25-35
	f	0.005-0.008	0.010-0.020	0.020-0.030
K1	Vc	70-110	110-150	110-150
	f	0.020-0.050	0.030-0.040	0.040-0.050
K2	Vc	50-90	90-130	90-130
	f	0.015-0.040	0.025-0.035	0.035-0.050
N1	Vc	70-100	100-130	100-130
	f	0.020-0.030	0.030-0.040	0.040-0.050
N2	Vc	80-120	130-160	130-160
	f	0.020-0.030	0.030-0.050	0.050-0.060
N3	Vc	80-120	130-160	130-160
	f	0.020-0.030	0.030-0.050	0.050-0.060
N4	Vc	50-80	80-110	80-110
	f	0.015-0.025	0.025-0.035	0.035-0.045
N5	Vc	80-120	130-160	130-160
	f	0.015-0.025	0.025-0.035	0.035-0.045
N6	Vc			
	f			
N7	Vc			
	f			
N8	Vc			
	f			
S1	Vc	20-30	20-30	20-30
	f	0.005-0.010	0.010-0.020	0.020-0.030
S2	Vc	15-25	15-25	15-25
	f	0.005-0.010	0.010-0.020	0.020-0.030
H1	Vc	20-30	25-40	25-40
	f	0.005-0.015	0.015-0.025	0.025-0.035
H2	Vc	8-12	12-15	15-20
	f	0.003-0.008	0.008-0.015	0.015-0.020
H3	Vc			
	f			
O1	Vc	60-100	70-110	70-110
	f	0.010-0.020	0.020-0.030	0.030-0.040
O2	Vc			
	f			
O3	Vc			
	f			

#### Art. 52903 / 52906 / 52909

Mat.		ø 1.00-1.90	ø 2.00-5.00	ø 5.10-8.00	ø 8.10-12.70
P1	Vc	70-110	70-110	70-110	70-110
	f	0.025-0.055	0.050-0.130	0.125-0.170	0.165-0.215
P2	Vc	60-100	60-100	60-100	60-100
	f	0.020-0.050	0.045-0.120	0.115-0.150	0.140-0.190
P3	Vc	60-100	60-100	60-100	60-100
	f	0.020-0.050	0.045-0.120	0.115-0.150	0.140-0.190
M1	Vc	60-100	60-100	60-100	60-100
	f	0.020-0.050	0.045-0.120	0.115-0.150	0.140-0.190
M2	Vc	50-90	50-90	50-90	50-90
	f	0.015-0.045	0.040-0.100	0.090-0.130	0.120-0.150
K1	Vc	90-140	90-140	90-140	90-140
	f	0.050-0.110	0.100-0.270	0.260-0.340	0.320-0.420
K2	Vc	80-120	80-120	80-120	80-120
	f	0.040-0.100	0.090-0.250	0.240-0.300	0.280-0.360
N1	Vc	120-170	120-170	120-170	120-170
	f	0.050-0.110	0.100-0.250	0.240-0.340	0.320-0.420
N2	Vc	150-200	150-200	150-200	150-200
	f	0.050-0.110	0.100-0.250	0.240-0.340	0.320-0.420
N3	Vc	200-250	200-250	200-250	200-250
	f	0.050-0.110	0.100-0.250	0.240-0.340	0.320-0.420
N4	Vc	90-130	90-130	90-130	90-130
	f	0.050-0.110	0.100-0.250	0.240-0.340	0.320-0.420
N5	Vc	150-200	150-200	150-200	150-200
	f	0.050-0.110	0.100-0.250	0.240-0.340	0.320-0.420
N6	Vc	60-100	60-100	60-100	60-100
	f	0.020-0.050	0.045-0.120	0.115-0.150	0.140-0.190
N7	Vc				
	f				
N8	Vc				
	f				
S1	Vc	30-60	30-60	30-60	30-60
	f	0.015-0.035	0.030-0.085	0.080-0.110	0.100-0.135
S2	Vc	20-50	20-50	20-50	20-50
	f	0.020-0.050	0.045-0.120	0.115-0.150	0.140-0.190
H1	Vc	30-60	30-60	30-60	30-60
	f	0.020-0.030	0.030-0.100	0.090-0.140	0.120-0.170
H2	Vc				
	f				
H3	Vc				
	f				
O1	Vc	70-110	70-110	70-110	70-110
	vf	0.025-0.055	0.050-0.130	0.125-0.170	0.165-0.215
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.