Schnittdaten
Données de coupe
Parametri di lavoro
Cutting data

Art. 52912 / 52916

Mat.		1.00–2.40	2.50–5.00	5.10–8.00	8.10–10.00
P1	v_c	70–110	70–110	70–110	70–110
	f	0.030–0.080	0.060–0.130	0.125–0.170	0.170–0.240
P2	v_c	60–100	60–100	60–100	60–100
	f	0.020–0.060	0.050–0.120	0.115–0.150	0.150–0.220
P3	v_c	50–90	50–90	50–90	50–90
	f	0.015–0.050	0.040–0.100	0.080–0.130	0.140–0.200
M1	v_c	50–90	50–90	50–90	50–90
	f	0.015–0.050	0.040–0.100	0.080–0.130	0.140–0.190
M2	v_c	40–80	40–80	40–80	40–80
	f	0.010–0.045	0.030–0.090	0.070–0.120	0.120–0.170
K1	v_c	90–140	90–140	90–140	90–140
	f	0.030–0.080	0.080–0.150	0.150–0.280	0.280–0.350
K2	v_c	80–120	80–120	80–120	80–120
	f	0.040–0.100	0.060–0.130	0.130–0.220	0.220–0.300
N1	v_c	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
N2	v_c	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	v_c	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
N4	v_c	120–170	120–170	120–170	120–170
	f	0.030–0.080	0.060–0.130	0.140–0.190	0.165–0.210
N5	v_c	120–170	120–170	120–170	120–170
	f	0.040–0.100	0.100–0.250	0.240–0.300	0.280–0.360
N6	v_c	80–120	80–120	80–120	80–120
	f	0.040–0.100	0.100–0.250	0.240–0.300	0.280–0.360
N7	v_c				
	f				
N8	v_c				
	f				
S1	v_c	50–90	50–90	50–90	50–90
	f	0.020–0.060	0.040–0.100	0.100–0.200	0.100–0.135
S2	v_c	30–55	30–55	30–55	30–55
	f	0.010–0.040	0.030–0.070	0.080–0.130	0.100–0.170
H1	v_c	30–60	30–60	30–60	30–60
	f	0.015–0.050	0.040–0.100	0.090–0.140	0.120–0.150
H2	v_c				
	f				
H3	v_c				
	f				
O1	v_c	70–110	70–110	70–110	70–110
	f	0.025–0.050	0.050–0.130	0.130–0.170	0.170–0.220
O2	v_c				
	f				
O3	v_c				
	f				

Art. 52920 / 52930

Mat.		ø 3.00–5.00	ø 5.10–8.00	ø 8.10–10.00
P1	v_c			
	f			
P2	v_c			
	f			
P3	v_c	40–80	40–80	40–80
	f	0.050–0.085	0.080–0.110	0.100–0.150
M1	v_c	30–70	30–70	30–70
	f	0.045–0.070	0.065–0.085	0.080–0.120
M2	v_c	25–55	25–55	25–55
	f	0.035–0.050	0.045–0.065	0.080–0.110
K1	v_c	70–110	70–110	70–110
	f	0.100–0.200	0.180–0.250	0.230–0.280
K2	v_c	60–100	60–100	60–100
	f	0.090–0.180	0.170–0.240	0.220–0.260
N1	v_c	60–100	60–100	60–100
	f	0.130–0.250	0.230–0.340	0.320–0.380
N2	v_c	65–100	65–100	65–100
	f	0.130–0.250	0.230–0.340	0.320–0.380
N3	v_c	70–110	70–110	70–110
	f	0.130–0.250	0.230–0.340	0.320–0.380
N4	v_c			
	f			
N5	v_c			
	f			
N6	v_c			
	f			
N7	v_c			
	f			
N8	v_c			
	f			
S1	v_c	30–60	30–60	30–60
	f	0.035–0.070	0.065–0.085	0.080–0.110
S2	v_c	20–50	20–50	20–50
	f	0.030–0.060	0.050–0.080	0.070–0.100
H1	v_c	20–40	20–40	20–40
	f	0.010–0.035	0.030–0.040	0.035–0.060
H2	v_c			
	f			
H3	v_c			
	f			
O1	v_c	60–100	60–100	60–100
	f	0.090–0.180	0.170–0.240	0.220–0.260
O2	v_c			
	f			
O3	v_c			
	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.