

Schnittdaten
Données de coupe
Parametri di lavoro
Cutting data

Art. 50941

Mat.		ø 0.50-0.90	ø 1.00-1.90	ø 2.00-3.00
P1	Vc	50-70	70-100	70-100
	f	0.020-0.040	0.035-0.060	0.060-0.120
P2	Vc	40-60	60-80	60-80
	f	0.010-0.030	0.025-0.045	0.045-0.100
P3	Vc	30-50	50-70	50-70
	f	0.010-0.020	0.015-0.040	0.040-0.080
M1	Vc	20-35	30-45	30-45
	f	0.005-0.008	0.008-0.020	0.020-0.030
M2	Vc	20-30	25-35	25-35
	f	0.005-0.008	0.008-0.015	0.015-0.025
K1	Vc	50-100	100-150	100-150
	f	0.020-0.050	0.040-0.080	0.080-0.120
K2	Vc	50-90	90-130	90-130
	f	0.015-0.040	0.030-0.060	0.060-0.100
N1	Vc			
	f			
N2	Vc	60-120	120-150	120-150
	f	0.020-0.040	0.040-0.080	0.080-0.120
N3	Vc	80-120	130-170	130-170
	f	0.020-0.040	0.040-0.080	0.080-0.120
N4	Vc			
	f			
N5	Vc			
	f			
N6	Vc			
	f			
N7	Vc			
	f			
N8	Vc			
	f			
S1	Vc	30-40	30-40	30-40
	f	0.005-0.008	0.008-0.020	0.020-0.035
S2	Vc			
	f			
H1	Vc	10-20	15-30	15-30
	f	0.003-0.006	0.005-0.015	0.015-0.020
H2	Vc			
	f			
H3	Vc			
	f			
O1	Vc			
	f			
O2	Vc			
	f			
O3	Vc			
	f			

Art. 52100 / 52200

Mat.		ø 3.00-4.00	ø 4.10-8.00	ø 8.10-12.00	ø 12.10-16.00	ø 16.10-20.00
P1	Vc					
	f					
P2	Vc					
	f					
P3	Vc					
	f					
M1	Vc					
	f					
M2	Vc					
	f					
K1	Vc	60-110	60-110	60-110	60-110	60-110
	f	0.040-0.060	0.050-0.200	0.160-0.300	0.280-0.400	0.380-0.500
K2	Vc	50-100	50-100	50-100	50-100	50-100
	f	0.020-0.050	0.040-0.160	0.140-0.250	0.220-0.350	0.320-0.400
N1	Vc					
	f					
N2	Vc	200-250	200-250	200-250	200-250	200-250
	f	0.040-0.060	0.050-0.150	0.140-0.260	0.250-0.400	0.380-0.600
N3	Vc	220-280	220-280	220-280	220-280	220-280
	f	0.040-0.060	0.050-0.150	0.140-0.260	0.250-0.400	0.380-0.600
N4	Vc					
	f					
N5	Vc	80-120	80-120	80-120	80-120	80-120
	f	0.040-0.060	0.050-0.150	0.140-0.250	0.230-0.330	0.300-0.400
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	20-40	20-40	20-40	20-40	20-40
	f	0.030-0.050	0.040-0.100	0.080-0.150	0.130-0.180	0.160-0.200
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.