

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

**Art. 52150**

Mat.		φ 4.00–7.00	φ 7.10–10.00	φ 10.10–13.00	φ 13.10–16.00	φ 16.10–20.00
P1	Vc	90–120	90–120	90–120	90–120	90–120
	f	0.080–0.200	0.180–0.350	0.300–0.400	0.350–0.450	0.400–0.600
P2	Vc	80–150	80–150	80–150	80–150	80–150
	f	0.050–0.180	0.160–0.250	0.220–0.350	0.330–0.400	0.380–0.550
P3	Vc					
	f					
M1	Vc					
	f					
M2	Vc					
	f					
K1	Vc	200–250	200–250	200–250	200–250	200–250
	f	0.100–0.250	0.220–0.350	0.330–0.450	0.420–0.550	0.520–0.700
K2	Vc	160–200	160–200	160–200	160–200	160–200
	f	0.080–0.180	0.160–0.250	0.230–0.350	0.330–0.500	0.450–0.550
N1	Vc					
	f					
N2	Vc					
	f					
N3	Vc	250–300	250–300	250–300	250–300	250–300
	f	0.050–0.150	0.130–0.250	0.230–0.350	0.330–0.450	0.430–0.550
N4	Vc					
	f					
N5	Vc	80–120	80–120	80–120	80–120	80–120
	f	0.050–0.120	0.100–0.220	0.200–0.320	0.300–0.400	0.380–0.450
N6	Vc					
	f					
N7	Vc					
	f					
N8	Vc					
	f					
S1	Vc					
	f					
S2	Vc					
	f					
H1	Vc	70–100	70–100	70–100	70–100	70–100
	f	0.050–0.100	0.080–0.180	0.160–0.260	0.240–0.300	0.280–0.350
H2	Vc					
	f					
H3	Vc					
	f					
O1	Vc					
	f					
O2	Vc					
	f					
O3	Vc					
	f					

**Art. 50950**

Mat.		φ 3.00–5.00	φ 5.10–8.00	φ 8.10–12.00	φ 12.10–16.00	φ 16.10–20.00
P1	Vc	80–120	80–120	80–120	80–120	80–120
	f	0.060–0.150	0.120–0.250	0.220–0.350	0.320–0.450	0.400–0.500
P2	Vc	60–80	60–80	60–80	60–80	60–80
	f	0.050–0.120	0.100–0.220	0.200–0.300	0.280–0.360	0.340–0.450
P3	Vc	50–70	50–70	50–70	50–70	50–70
	f	0.040–0.100	0.090–0.180	0.160–0.260	0.240–0.320	0.300–0.380
M1	Vc	40–60	40–60	40–60	40–60	40–60
	f	0.030–0.080	0.070–0.150	0.140–0.180	0.170–0.250	0.230–0.320
M2	Vc	30–50	30–50	30–50	30–50	30–50
	f	0.030–0.080	0.070–0.130	0.120–0.160	0.150–0.220	0.200–0.300
K1	Vc	100–130	100–130	100–130	100–130	100–130
	f	0.100–0.250	0.230–0.350	0.320–0.450	0.400–0.500	0.450–0.600
K2	Vc	60–80	60–80	60–80	60–80	60–80
	f	0.060–0.200	0.180–0.280	0.250–0.350	0.320–0.450	0.420–0.500
N1	Vc					
	f					
N2	Vc	150–200	150–200	150–200	150–200	150–200
	f	0.100–0.270	0.250–0.350	0.330–0.400	0.380–0.480	0.460–0.550
N3	Vc	130–160	130–160	130–160	130–160	130–160
	f	0.100–0.250	0.220–0.320	0.300–0.380	0.360–0.450	0.420–0.500
N4	Vc					
	f					
N5	Vc					
	f					
N6	Vc					
	f					
N7	Vc					
	f					
N8	Vc					
	f					
S1	Vc	30–60	30–60	30–60	30–60	30–60
	f	0.005–0.040	0.030–0.070	0.060–0.110	0.100–0.150	0.140–0.180
S2	Vc					
	f					
H1	Vc	60–90	60–90	60–90	60–90	60–90
	f	0.050–0.120	0.100–0.220	0.200–0.300	0.280–0.360	0.340–0.400
H2	Vc	40–60	40–60	40–60	40–60	40–60
	f	0.030–0.070	0.060–0.130	0.110–0.180	0.160–0.240	0.200–0.260
H3	Vc	15–35	15–35	15–35	15–35	15–35
	f	0.005–0.030	0.020–0.050	0.040–0.070	0.060–0.100	0.080–0.120
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.