

# Schnittdaten

## Données de coupe

## Parametri di lavoro

## Cutting data

### Art. 50830

| Mat. |    | ø 0.30–1.00 | ø 1.10–5.00 | ø 5.10–10.00 | ø 10.10–15.00 | ø 15.10–20.00 |
|------|----|-------------|-------------|--------------|---------------|---------------|
| P1   | Vc | 30–60       | 50–90       | 50–90        | 50–90         | 50–90         |
|      | f  | 0.010–0.040 | 0.038–0.080 | 0.076–0.110  | 0.100–0.180   | 0.170–0.260   |
| P2   | Vc | 20–35       | 30–60       | 30–60        | 30–60         | 30–60         |
|      | f  | 0.010–0.030 | 0.028–0.070 | 0.065–0.090  | 0.085–0.160   | 0.150–0.230   |
| P3   | Vc | 15–30       | 25–50       | 25–50        | 25–50         | 25–50         |
|      | f  | 0.005–0.020 | 0.018–0.060 | 0.057–0.085  | 0.080–0.130   | 0.125–0.200   |
| M1   | Vc | 15–30       | 25–50       | 25–50        | 25–50         | 25–50         |
|      | f  | 0.005–0.020 | 0.018–0.060 | 0.057–0.085  | 0.080–0.130   | 0.125–0.200   |
| M2   | Vc | 10–20       | 15–40       | 15–40        | 15–40         | 15–40         |
|      | f  | 0.004–0.018 | 0.016–0.050 | 0.048–0.090  | 0.085–0.120   | 0.110–0.160   |
| K1   | Vc | 40–80       | 70–120      | 70–120       | 70–120        | 70–120        |
|      | f  | 0.010–0.060 | 0.055–0.090 | 0.085–0.110  | 0.100–0.280   | 0.260–0.500   |
| K2   | Vc | 30–50       | 40–80       | 40–80        | 40–80         | 40–80         |
|      | f  | 0.010–0.030 | 0.028–0.070 | 0.067–0.100  | 0.095–0.180   | 0.170–0.300   |
| N1   | Vc | 30–60       | 50–90       | 50–90        | 50–90         | 50–90         |
|      | f  | 0.012–0.045 | 0.042–0.085 | 0.080–0.140  | 0.135–0.250   | 0.230–0.300   |
| N2   | Vc | 40–80       | 70–120      | 70–120       | 70–120        | 70–120        |
|      | f  | 0.015–0.050 | 0.048–0.100 | 0.095–0.180  | 0.170–0.280   | 0.260–0.450   |
| N3   | Vc | 30–70       | 60–110      | 60–110       | 60–110        | 60–110        |
|      | f  | 0.010–0.045 | 0.040–0.085 | 0.080–0.160  | 0.150–0.260   | 0.240–0.400   |
| N4   | Vc | 20–40       | 30–70       | 30–70        | 30–70         | 30–70         |
|      | f  | 0.005–0.030 | 0.028–0.070 | 0.065–0.090  | 0.085–0.160   | 0.150–0.230   |
| N5   | Vc |             |             |              |               |               |
|      | f  |             |             |              |               |               |
| N6   | Vc | 15–30       | 25–50       | 25–50        | 25–50         | 25–50         |
|      | f  | 0.012–0.045 | 0.042–0.085 | 0.080–0.140  | 0.135–0.250   | 0.230–0.300   |
| N7   | Vc | 15–30       | 25–50       | 25–50        | 25–50         | 25–50         |
|      | f  | 0.012–0.045 | 0.042–0.085 | 0.080–0.140  | 0.135–0.250   | 0.230–0.300   |
| N8   | Vc | 10–20       | 15–35       | 15–35        | 15–35         | 15–35         |
|      | f  | 0.004–0.018 | 0.016–0.050 | 0.048–0.090  | 0.085–0.120   | 0.110–0.180   |
| S1   | Vc | 20–30       | 25–50       | 25–50        | 25–50         | 25–50         |
|      | f  | 0.020–0.040 | 0.038–0.070 | 0.065–0.100  | 0.095–0.150   | 0.145–0.200   |
| S2   | Vc | 10–20       | 15–35       | 15–35        | 15–35         | 15–35         |
|      | f  | 0.004–0.018 | 0.016–0.050 | 0.048–0.090  | 0.085–0.120   | 0.110–0.180   |
| H1   | Vc |             |             |              |               |               |
|      | f  |             |             |              |               |               |
| H2   | Vc |             |             |              |               |               |
|      | f  |             |             |              |               |               |
| H3   | Vc |             |             |              |               |               |
|      | f  |             |             |              |               |               |
| O1   | Vc | 20–40       | 30–70       | 30–70        | 30–70         | 30–70         |
|      | f  | 0.015–0.050 | 0.048–0.100 | 0.095–0.180  | 0.170–0.280   | 0.260–0.450   |
| O2   | Vc |             |             |              |               |               |
|      | f  |             |             |              |               |               |
| O3   | Vc |             |             |              |               |               |
|      | f  |             |             |              |               |               |

### Art. 50838

| Mat. |    | ø 0.30–1.00 | ø 1.05–3.00 | ø 3.105–6.00 |
|------|----|-------------|-------------|--------------|
| P1   | Vc | 30–60       | 50–90       | 50–90        |
|      | f  | 0.010–0.040 | 0.038–0.050 | 0.045–0.060  |
| P2   | Vc | 20–35       | 30–60       | 30–60        |
|      | f  | 0.010–0.030 | 0.028–0.045 | 0.040–0.055  |
| P3   | Vc | 15–30       | 25–50       | 25–50        |
|      | f  | 0.005–0.020 | 0.018–0.035 | 0.030–0.050  |
| M1   | Vc | 15–30       | 25–50       | 25–50        |
|      | f  | 0.005–0.020 | 0.018–0.035 | 0.030–0.050  |
| M2   | Vc | 10–20       | 15–40       | 15–40        |
|      | f  | 0.004–0.018 | 0.016–0.030 | 0.028–0.040  |
| K1   | Vc | 40–80       | 70–120      | 70–120       |
|      | f  | 0.010–0.060 | 0.055–0.070 | 0.065–0.100  |
| K2   | Vc | 30–50       | 40–80       | 40–80        |
|      | f  | 0.010–0.030 | 0.028–0.055 | 0.050–0.080  |
| N1   | Vc | 30–60       | 50–90       | 50–90        |
|      | f  | 0.012–0.045 | 0.042–0.060 | 0.055–0.090  |
| N2   | Vc | 40–80       | 70–120      | 70–120       |
|      | f  | 0.015–0.050 | 0.048–0.070 | 0.065–0.110  |
| N3   | Vc | 30–70       | 60–110      | 60–110       |
|      | f  | 0.010–0.045 | 0.040–0.065 | 0.060–0.100  |
| N4   | Vc | 20–40       | 30–70       | 30–70        |
|      | f  | 0.005–0.030 | 0.028–0.050 | 0.048–0.075  |
| N5   | Vc | 30–60       | 50–90       | 50–90        |
|      | f  | 0.015–0.050 | 0.048–0.070 | 0.065–0.110  |
| N6   | Vc | 15–30       | 25–50       | 25–50        |
|      | f  | 0.012–0.045 | 0.040–0.065 | 0.060–0.100  |
| N7   | Vc |             |             |              |
|      | f  |             |             |              |
| N8   | Vc |             |             |              |
|      | f  |             |             |              |
| S1   | Vc | 20–35       | 30–60       | 30–60        |
|      | f  | 0.010–0.030 | 0.028–0.045 | 0.040–0.055  |
| S2   | Vc |             |             |              |
|      | f  |             |             |              |
| H1   | Vc |             |             |              |
|      | f  |             |             |              |
| H2   | Vc |             |             |              |
|      | f  |             |             |              |
| H3   | Vc |             |             |              |
|      | f  |             |             |              |
| O1   | Vc | 20–40       | 30–70       | 30–70        |
|      | f  | 0.015–0.050 | 0.048–0.070 | 0.065–0.120  |
| 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.