

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

**Art. 50820**

Mat.		ø 0.70–2.50	ø 2.60–6.00	ø 6.10–9.00	ø 9.10–11.00	ø 11.10–14.00
P1	Vc	30–60	50–90	50–90	50–90	50–90
	f	0.010–0.020	0.018–0.040	0.038–0.065	0.060–0.090	0.085–0.120
P2	Vc	20–35	30–60	30–60	30–60	30–60
	f	0.008–0.018	0.016–0.035	0.033–0.055	0.050–0.075	0.070–0.100
P3	Vc					
	f					
M1	Vc					
	f					
M2	Vc					
	f					
K1	Vc	20–40	30–70	30–70	30–70	30–70
	f	0.010–0.025	0.023–0.045	0.042–0.075	0.072–0.110	0.100–0.150
K2	Vc	15–30	25–50	25–50	25–50	25–50
	f	0.010–0.020	0.018–0.040	0.038–0.065	0.060–0.090	0.085–0.120
N1	Vc					
	f					
N2	Vc	80–120	110–160	110–160	110–160	110–160
	f	0.010–0.030	0.028–0.080	0.075–0.120	0.110–0.160	0.150–0.200
N3	Vc	60–100	50–120	50–120	50–120	50–120
	f	0.010–0.030	0.028–0.080	0.075–0.120	0.110–0.160	0.150–0.200
N4	Vc					
	f					
N5	Vc	40–70	60–120	60–120	60–120	60–120
	f	0.010–0.025	0.023–0.045	0.042–0.075	0.072–0.110	0.100–0.150
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					
	f					
O2	Vc					
	f					
O3	Vc					
	f					

**Art. 50840**

Mat.		ø 2.00–5.00	ø 5.10–8.00	ø 8.10–11.00	ø 11.10–14.00
P1	Vc	30–60	30–60	30–60	30–60
	f	0.020–0.050	0.045–0.090	0.080–0.150	0.130–0.200
P2	Vc	25–50	25–50	25–50	25–50
	f	0.015–0.045	0.040–0.080	0.075–0.120	0.100–0.150
P3	Vc				
	f				
M1	Vc	20–45	20–45	20–45	20–45
	f	0.150–0.040	0.035–0.070	0.065–0.100	0.090–0.130
M2	Vc	15–35	15–35	15–35	15–35
	f	0.010–0.035	0.030–0.060	0.055–0.085	0.080–0.110
K1	Vc	30–60	30–60	30–60	30–60
	f	0.020–0.050	0.450–0.090	0.080–0.150	0.130–0.200
K2	Vc	25–50	25–50	25–50	25–50
	f	0.015–0.045	0.040–0.080	0.075–0.120	0.100–0.150
N1	Vc	30–60	30–60	30–60	30–60
	f	0.020–0.050	0.045–0.090	0.080–0.150	0.130–0.200
N2	Vc	60–100	60–100	60–100	60–100
	f	0.030–0.080	0.070–0.150	0.140–0.220	0.200–0.300
N3	Vc	50–90	50–90	50–90	50–90
	f	0.025–0.070	0.060–0.130	0.120–0.190	0.180–0.250
N4	Vc	50–90	50–90	50–90	50–90
	f	0.030–0.090	0.080–0.150	0.130–0.200	0.180–0.300
N5	Vc				
	f				
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				
	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.