

Schnittdaten

Données de coupe

Parametri di lavoro

Cutting data

Art. 73200 / 73300

Mat.	ϕ 0.30-0.70	ϕ 0.70-1.50	ϕ 1.50-2.90	a_p	a_e
P1	Vc 60-80 fz 0.005-0.010	60-80	60-80	0.9 × d1	1 × d1
P2	Vc 50-70 fz 0.005-0.010	50-70	50-70	0.8 × d1	1 × d1
P3	Vc 40-60 fz 0.004-0.010	40-60	40-60	0.7 × d1	1 × d1
M1	Vc 30-50 fz 0.004-0.010	30-50	30-50	0.6 × d1	1 × d1
M2	Vc 25-40 fz 0.004-0.008	25-40	25-40	0.5 × d1	1 × d1
K1	Vc 40-70 fz 0.005-0.010	40-70	40-70	1.0 × d1	1 × d1
K2	Vc 30-60 fz 0.004-0.010	30-60	30-60	0.9 × d1	1 × d1
N1	Vc 70-100 fz 0.004-0.01	70-100	70-100	0.9 × d1	1 × d1
N2	Vc 80-120 fz 0.005-0.010	80-120	80-120	0.9 × d1	1 × d1
N3	Vc 60-100 fz 0.005-0.010	60-100	60-100	0.9 × d1	1 × d1
N4	Vc fz				
N5	Vc 40-80 fz 0.005-0.010	40-80	40-80	1 × d1	1 × d1
N6	Vc 25-50 fz 0.004-0.010	25-50	25-50	0.8 × d1	1 × d1
N7	Vc fz				
N8	Vc fz				
S1	Vc 25-50 fz 0.003-0.008	25-50	25-50	0.7 × d1	1 × d1
S2	Vc fz				
H1	Vc fz				
H2	Vc fz				
H3	Vc fz				
O1	Vc fz				
O2	Vc fz				
O3	Vc fz				

Art. 73800

Mat.	ϕ 0.50-1.00	ϕ 1.00-2.00	ϕ 2.00-2.50	a_p	a_e
P1	Vc 60-80 fz 0.003-0.008	60-80	60-80	0.30 × d1	1 × d1
P2	Vc 50-70 fz 0.003-0.008	50-70	50-70	0.15 × d1	1 × d1
P3	Vc 40-60 fz 0.002-0.007	40-60	40-60	0.10 × d1	1 × d1
M1	Vc 30-50 fz 0.002-0.007	30-50	30-50	0.20 × d1	1 × d1
M2	Vc 25-40 fz 0.002-0.006	25-40	25-40	0.10 × d1	1 × d1
K1	Vc 40-70 fz 0.003-0.008	40-70	40-70	0.40 × d1	1 × d1
K2	Vc 30-60 fz 0.002-0.007	30-60	30-60	0.20 × d1	1 × d1
N1	Vc 70-100 fz 0.002-0.007	70-100	70-100	0.40 × d1	1 × d1
N2	Vc 80-120 fz 0.003-0.008	80-120	80-120	0.25 × d1	1 × d1
N3	Vc 60-100 fz 0.003-0.008	60-100	60-100	0.25 × d1	1 × d1
N4	Vc fz				
N5	Vc 40-80 fz 0.003-0.008	40-80	40-80	0.40 × d1	1 × d1
N6	Vc 25-50 fz 0.002-0.007	25-50	25-50	0.20 × d1	1 × d1
N7	Vc fz				
N8	Vc fz				
S1	Vc 25-50 fz 0.002-0.006	25-50	25-50	0.20 × d1	1 × d1
S2	Vc fz				
H1	Vc fz				
H2	Vc fz				
H3	Vc fz				
O1	Vc fz				
O2	Vc fz				
O3	Vc fz				

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.