

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	V_c 60-80	60-80	60-80	0.9 × d1	1 × d1
	f_z 0.005-0.010	0.008-0.020	0.018-0.040		
P2	V_c 50-70	50-70	50-70	0.8 × d1	1 × d1
	f_z 0.005-0.010	0.008-0.020	0.018-0.040		
P3	V_c 40-60	40-60	40-60	0.7 × d1	1 × d1
	f_z 0.004-0.010	0.006-0.020	0.015-0.035		
M1	V_c 30-50	30-50	30-50	0.6 × d1	1 × d1
	f_z 0.004-0.010	0.006-0.020	0.015-0.035		
M2	V_c 25-40	25-40	25-40	0.5 × d1	1 × d1
	f_z 0.004-0.008	0.005-0.016	0.014-0.028		
K1	V_c 40-70	40-70	40-70	1.0 × d1	1 × d1
	f_z 0.005-0.010	0.008-0.020	0.018-0.040		
K2	V_c 30-60	30-60	30-60	0.9 × d1	1 × d1
	f_z 0.004-0.010	0.006-0.020	0.015-0.035		
N1	V_c 70-100	70-100	70-100	0.9 × d1	1 × d1
	f_z 0.004-0.01	0.006-0.020	0.015-0.035		
N2	V_c 80-120	80-120	80-120	0.9 × d1	1 × d1
	f_z 0.005-0.010	0.008-0.020	0.018-0.040		
N3	V_c 60-100	60-100	60-100	0.9 × d1	1 × d1
	f_z 0.005-0.010	0.008-0.020	0.018-0.040		
N4	V_c				
	f_z				
N5	V_c 40-80	40-80	40-80	1 × d1	1 × d1
	f_z 0.005-0.010	0.008-0.020	0.018-0.040		
N6	V_c 25-50	25-50	25-50	0.8 × d1	1 × d1
	f_z 0.004-0.010	0.006-0.020	0.015-0.035		
N7	V_c				
	f_z				
N8	V_c				
	f_z				
S1	V_c 25-50	25-50	25-50	0.7 × d1	1 × d1
	f_z 0.003-0.008	0.006-0.015	0.012-0.030		
S2	V_c				
	f_z				
H1	V_c				
	f_z				
H2	V_c				
	f_z				
H3	V_c				
	f_z				
O1	V_c				
	f_z				
O2	V_c				
	f_z				
O3	V_c				
	f_z				

Art. 73800

Mat.	ϕ 0.50-1.00	ϕ 1.00-2.00	ϕ 2.00-2.50	a_p	a_e
P1	V_c 60-80	60-80	60-80	0.30 × d1	1 × d1
	f_z 0.003-0.008	0.008-0.016	0.016-0.030		
P2	V_c 50-70	50-70	50-70	0.15 × d1	1 × d1
	f_z 0.003-0.008	0.008-0.016	0.016-0.030		
P3	V_c 40-60	40-60	40-60	0.10 × d1	1 × d1
	f_z 0.002-0.007	0.007-0.014	0.014-0.026		
M1	V_c 30-50	30-50	30-50	0.20 × d1	1 × d1
	f_z 0.002-0.007	0.007-0.014	0.014-0.026		
M2	V_c 25-40	25-40	25-40	0.10 × d1	1 × d1
	f_z 0.002-0.006	0.006-0.012	0.012-0.022		
K1	V_c 40-70	40-70	40-70	0.40 × d1	1 × d1
	f_z 0.003-0.008	0.008-0.016	0.016-0.030		
K2	V_c 30-60	30-60	30-60	0.20 × d1	1 × d1
	f_z 0.002-0.007	0.007-0.014	0.014-0.026		
N1	V_c 70-100	70-100	70-100	0.40 × d1	1 × d1
	f_z 0.002-0.007	0.007-0.014	0.014-0.026		
N2	V_c 80-120	80-120	80-120	0.25 × d1	1 × d1
	f_z 0.003-0.008	0.008-0.016	0.016-0.030		
N3	V_c 60-100	60-100	60-100	0.25 × d1	1 × d1
	f_z 0.003-0.008	0.008-0.016	0.016-0.030		
N4	V_c				
	f_z				
N5	V_c 40-80	40-80	40-80	0.40 × d1	1 × d1
	f_z 0.003-0.008	0.008-0.016	0.016-0.030		
N6	V_c 25-50	25-50	25-50	0.20 × d1	1 × d1
	f_z 0.002-0.007	0.007-0.014	0.014-0.026		
N7	V_c				
	f_z				
N8	V_c				
	f_z				
S1	V_c 25-50	25-50	25-50	0.20 × d1	1 × d1
	f_z 0.002-0.006	0.006-0.012	0.012-0.020		
S2	V_c				
	f_z				
H1	V_c				
	f_z				
H2	V_c				
	f_z				
H3	V_c				
	f_z				
O1	V_c				
	f_z				
O2	V_c				
	f_z				
O3	V_c				
	f_z				

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.