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

## Art. 73725

| Mat. | | ø 0.30–0.70 | ø 0.70–1.50 | ø 1.50–2.90 | $a_p$ | $a_e$ |
|---|---|---|---|---|---|---|
| P1 | $v_c$ | 60–80 | 60–80 | 60–80 | | |
| | $f_z$ | 0.003–0.008 | 0.008–0.016 | 0.016–0.030 | 0.45 × d1 | 1 × d1 |
| P2 | $v_c$ | 50–70 | 50–70 | 50–70 | | |
| | $f_z$ | 0.003–0.008 | 0.008–0.016 | 0.016–0.030 | 0.25 × d1 | 1 × d1 |
| P3 | $v_c$ | 40–60 | 40–60 | 40–60 | | |
| | $f_z$ | 0.002–0.007 | 0.007–0.014 | 0.014–0.026 | 0.15 × d1 | 1 × d1 |
| M1 | $v_c$ | 30–50 | 30–50 | 30–50 | | |
| | $f_z$ | 0.002–0.007 | 0.007–0.014 | 0.014–0.026 | 0.35 × d1 | 1 × d1 |
| M2 | $v_c$ | 25–40 | 25–40 | 25–40 | | |
| | $f_z$ | 0.002–0.006 | 0.006–0.012 | 0.012–0.022 | 0.2 × d1 | 1 × d1 |
| K1 | $v_c$ | 40–70 | 40–70 | 40–70 | | |
| | $f_z$ | 0.003–0.008 | 0.008–0.016 | 0.016–0.030 | 0.8 × d1 | 1 × d1 |
| K2 | $v_c$ | 30–60 | 30–60 | 30–60 | | |
| | $f_z$ | 0.002–0.007 | 0.007–0.014 | 0.014–0.026 | 0.35 × d1 | 1 × d1 |
| N1 | $v_c$ | 70–100 | 70–100 | 70–100 | | |
| | $f_z$ | 0.002–0.007 | 0.007–0.014 | 0.014–0.026 | 0.8 × d1 | 1 × d1 |
| N2 | $v_c$ | 80–120 | 80–120 | 80–120 | | |
| | $f_z$ | 0.003–0.008 | 0.008–0.016 | 0.016–0.030 | 0.7 × d1 | 1 × d1 |
| N3 | $v_c$ | 60–100 | 60–100 | 60–100 | | |
| | $f_z$ | 0.003–0.008 | 0.008–0.016 | 0.016–0.030 | 0.7 × d1 | 1 × d1 |
| N4 | $v_c$ | | | | | |
| | $f_z$ | | | | | |
| N5 | $v_c$ | 40–80 | 40–80 | 40–80 | | |
| | $f_z$ | 0.003–0.008 | 0.008–0.016 | 0.016–0.030 | 0.8 × d1 | 1 × d1 |
| N6 | $v_c$ | 25–50 | 25–50 | 25–50 | | |
| | $f_z$ | 0.002–0.007 | 0.007–0.014 | 0.014–0.026 | 0.45 × d1 | 1 × d1 |
| N7 | $v_c$ | | | | | |
| | $f_z$ | | | | | |
| N8 | $v_c$ | | | | | |
| | $f_z$ | | | | | |
| S1 | $v_c$ | 25–50 | 25–50 | 25–50 | | |
| | $f_z$ | 0.002–0.006 | 0.006–0.012 | 0.012–0.020 | 0.3 × d1 | 1 × d1 |
| 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. 43105

| Mat. | | ø 0.30–0.70 | ø 0.80–1.50 | ø 1.60–3.00 | $a_p$ | $a_e$ |
|---|---|---|---|---|---|---|
| P1 | $v_c$ | 80–120 | 80–120 | 80–120 | | |
| | $f_z$ | 0.002–0.005 | 0.003–0.015 | 0.005–0.030 | 0.8×d1 | 1×d1 |
| P2 | $v_c$ | 70–100 | 70–100 | 70–100 | | |
| | $f_z$ | 0.001–0.004 | 0.003–0.012 | 0.005–0.025 | 0.6×d1 | 1×d1 |
| P3 | $v_c$ | 40–70 | 40–70 | 40–70 | | |
| | $f_z$ | 0.001–0.003 | 0.002–0.012 | 0.003–0.018 | 0.5×d1 | 1×d1 |
| M1 | $v_c$ | 60–90 | 60–90 | 60–90 | | |
| | $f_z$ | 0.001–0.003 | 0.002–0.012 | 0.003–0.016 | 0.5×d1 | 1×d1 |
| M2 | $v_c$ | 30–60 | 30–60 | 30–60 | | |
| | $f_z$ | 0.001–0.003 | 0.002–0.010 | 0.003–0.013 | 0.4×d1 | 1×d1 |
| K1 | $v_c$ | 150–200 | 150–200 | 150–200 | | |
| | $f_z$ | 0.002–0.005 | 0.003–0.014 | 0.005–0.028 | 0.8×d1 | 1×d1 |
| K2 | $v_c$ | 60–100 | 60–100 | 60–100 | | |
| | $f_z$ | 0.001–0.006 | 0.003–0.012 | 0.005–0.023 | 0.8×d1 | 1×d1 |
| N1 | $v_c$ | 150–300 | 150–300 | 150–300 | | |
| | $f_z$ | 0.001–0.004 | 0.002–0.012 | 0.004–0.025 | 1×d1 | 1×d1 |
| N2 | $v_c$ | 150–300 | 150–300 | 150–300 | | |
| | $f_z$ | 0.002–0.005 | 0.003–0.014 | 0.005–0.028 | 1×d1 | 1×d1 |
| N3 | $v_c$ | 130–250 | 130–250 | 130–250 | | |
| | $f_z$ | 0.002–0.015 | 0.004–0.030 | 0.006–0.060 | 1×d1 | 1×d1 |
| N4 | $v_c$ | 60–100 | 60–100 | 60–100 | | |
| | $f_z$ | 0.001–0.009 | 0.003–0.018 | 0.004–0.036 | 0.8×d1 | 1×d1 |
| N5 | $v_c$ | 100–250 | 100–250 | 100–250 | | |
| | $f_z$ | 0.002–0.010 | 0.004–0.020 | 0.006–0.040 | 1×d1 | 1×d1 |
| N6 | $v_c$ | 80–150 | 80–150 | 80–150 | | |
| | $f_z$ | 0.001–0.008 | 0.002–0.018 | 0.004–0.035 | 0.8×d1 | 1×d1 |
| N7 | $v_c$ | 80–130 | 80–130 | 80–130 | | |
| | $f_z$ | 0.002–0.010 | 0.003–0.020 | 0.006–0.050 | 1×d1 | 1×d1 |
| N8 | $v_c$ | 80–130 | 80–130 | 80–130 | | |
| | $f_z$ | 0.002–0.010 | 0.003–0.020 | 0.006–0.050 | 1×d1 | 1×d1 |
| S1 | $v_c$ | 40–70 | 40–70 | 40–70 | | |
| | $f_z$ | 0.001–0.005 | 0.003–0.012 | 0.005–0.025 | 0.8×d1 | 1×d1 |
| S2 | $v_c$ | 20–40 | 20–40 | 20–40 | | |
| | $f_z$ | 0.001–0.002 | 0.001–0.004 | 0.002–0.008 | 0.2×d1 | 1×d1 |
| H1 | $v_c$ | 20–45 | 20–45 | 20–45 | | |
| | $f_z$ | 0.001–0.002 | 0.001–0.003 | 0.002–0.006 | 0.2×d1 | 1×d1 |
| H2 | $v_c$ | | | | | |
| | $f_z$ | | | | | |
| H3 | $v_c$ | | | | | |
| | $f_z$ | | | | | |
| O1 | $v_c$ | 100–150 | 100–150 | 100–150 | | |
| | $f_z$ | 0.003–0.025 | 0.006–0.055 | 0.010–0.095 | 1×d1 | 1×d1 |
| 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.