Schnittdaten
Données de coupe
Parametri di lavoro
Cutting data

Art. 76300

Mat.		ø 1.50–2.50	ø 2.50–4.00	ø 4.00–6.00	a_p	a_e
P1	v_c	60–80	60–80	60–80		
	f_z	0.010–0.020	0.020–0.040	0.040–0.060	1 × d1	1 × d1
P2	v_c	50–70	50–70	50–70		
	f_z	0.010–0.020	0.020–0.040	0.040–0.060	0.6 × d1	1 × d1
P3	v_c	40–60	40–60	40–60		
	f_z	0.008–0.015	0.015–0.035	0.035–0.050	0.5 × d1	1 × d1
M1	v_c	40–60	40–60	40–60		
	f_z	0.008–0.015	0.015–0.035	0.035–0.050	0.5 × d1	1 × d1
M2	v_c					
	f_z					
K1	v_c	60–80	60–80	60–80		
	f_z	0.010–0.020	0.020–0.040	0.040–0.060	1 × d1	1 × d1
K2	v_c	50–70	50–70	50–70		
	f_z	0.010–0.020	0.020–0.040	0.040–0.060	0.6 × d1	1 × d1
N1	v_c					
	f_z					
N2	v_c					
	f_z					
N3	v_c					
	f_z					
N4	v_c					
	f_z					
N5	v_c					
	f_z					
N6	v_c					
	f_z					
N7	v_c					
	f_z					
N8	v_c					
	f_z					
S1	v_c					
	f_z					
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. 73000

Mat.		ø 0.50–1.50	ø 2.00–3.00	ø 6.00–8.00
P1	v_c	70–120	70–120	70–120
	f_z	0.004–0.015	0.015–0.030	0.050–0.120
P2	v_c	60–100	60–100	60–100
	f_z	0.003–0.013	0.013–0.025	0.045–0.100
P3	v_c	40–80	40–80	40–80
	f_z	0.002–0.012	0.012–0.023	0.040–0.090
M1	v_c	40–80	40–80	40–80
	f_z	0.002–0.012	0.008–0.020	0.030–0.080
M2	v_c	30–70	30–70	30–70
	f_z	0.001–0.010	0.010–0.016	0.025–0.070
K1	v_c	120–150	100–150	100–150
	f_z	0.004–0.015	0.015–0.030	0.050–0.120
K2	v_c	100–130	100–130	100–130
	f_z	0.003–0.013	0.013–0.025	0.045–0.100
N1	v_c	150–200	150–200	150–200
	f_z	0.005–0.018	0.018–0.035	0.060–0.150
N2	v_c	150–200	150–200	150–200
	f_z	0.005–0.018	0.018–0.035	0.060–0.150
N3	v_c	150–200	150–200	150–200
	f_z	0.004–0.015	0.015–0.030	0.050–0.120
N4	v_c	150–200	150–200	150–200
	f_z	0.005–0.018	0.018–0.035	0.060–0.150
N5	v_c	150–200	150–200	150–200
	f_z	0.005–0.018	0.018–0.035	0.060–0.150
N6	v_c			
	f_z			
N7	v_c	80–120	80–120	80–120
	f_z	0.005–0.018	0.018–0.035	0.060–0.150
N8	v_c	80–120	80–120	80–120
	f_z	0.005–0.018	0.018–0.035	0.060–0.150
S1	v_c	40–70	40–70	40–70
	f_z	0.002–0.012	0.012–0.023	0.040–0.090
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.