

# 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 <sub>p</sub>	a <sub>e</sub>
<b>P1</b>	V <sub>c</sub> 60–80 f <sub>z</sub> 0.010–0.020	60–80 0.020–0.040	60–80 0.040–0.060	1 × d1	1 × d1
<b>P2</b>	V <sub>c</sub> 50–70 f <sub>z</sub> 0.010–0.020	50–70 0.020–0.040	50–70 0.040–0.060	0.6 × d1	1 × d1
<b>P3</b>	V <sub>c</sub> 40–60 f <sub>z</sub> 0.008–0.015	40–60 0.015–0.035	40–60 0.035–0.050	0.5 × d1	1 × d1
<b>M1</b>	V <sub>c</sub> 40–60 f <sub>z</sub> 0.008–0.015	40–60 0.015–0.035	40–60 0.035–0.050	0.5 × d1	1 × d1
<b>M2</b>	V <sub>c</sub> f <sub>z</sub>				
<b>K1</b>	V <sub>c</sub> 60–80 f <sub>z</sub> 0.010–0.020	60–80 0.020–0.040	60–80 0.040–0.060	1 × d1	1 × d1
<b>K2</b>	V <sub>c</sub> 50–70 f <sub>z</sub> 0.010–0.020	50–70 0.020–0.040	50–70 0.040–0.060	0.6 × d1	1 × d1
<b>N1</b>	V <sub>c</sub> f <sub>z</sub>				
<b>N2</b>	V <sub>c</sub> f <sub>z</sub>				
<b>N3</b>	V <sub>c</sub> f <sub>z</sub>				
<b>N4</b>	V <sub>c</sub> f <sub>z</sub>				
<b>N5</b>	V <sub>c</sub> f <sub>z</sub>				
<b>N6</b>	V <sub>c</sub> f <sub>z</sub>				
<b>N7</b>	V <sub>c</sub> f <sub>z</sub>				
<b>N8</b>	V <sub>c</sub> f <sub>z</sub>				
<b>S1</b>	V <sub>c</sub> f <sub>z</sub>				
<b>S2</b>	V <sub>c</sub> f <sub>z</sub>				
<b>H1</b>	V <sub>c</sub> f <sub>z</sub>				
<b>H2</b>	V <sub>c</sub> f <sub>z</sub>				
<b>H3</b>	V <sub>c</sub> f <sub>z</sub>				
<b>O1</b>	V <sub>c</sub> f <sub>z</sub>				
<b>O2</b>	V <sub>c</sub> f <sub>z</sub>				
<b>O3</b>	V <sub>c</sub> f <sub>z</sub>				

#### Art. 73000

Mat.	ø 0.50–1.50	ø 2.00–3.00	ø 6.00–8.00
<b>P1</b>	V <sub>c</sub> 70–120 f <sub>z</sub> 0.004–0.015	70–120 0.015–0.030	70–120 0.050–0.120
<b>P2</b>	V <sub>c</sub> 60–100 f <sub>z</sub> 0.003–0.013	60–100 0.013–0.025	60–100 0.045–0.100
<b>P3</b>	V <sub>c</sub> 40–80 f <sub>z</sub> 0.002–0.012	40–80 0.012–0.023	40–80 0.040–0.090
<b>M1</b>	V <sub>c</sub> 40–80 f <sub>z</sub> 0.002–0.012	40–80 0.008–0.020	40–80 0.030–0.080
<b>M2</b>	V <sub>c</sub> 30–70 f <sub>z</sub> 0.001–0.010	30–70 0.010–0.016	30–70 0.025–0.070
<b>K1</b>	V <sub>c</sub> 120–150 f <sub>z</sub> 0.004–0.015	100–150 0.015–0.030	100–150 0.050–0.120
<b>K2</b>	V <sub>c</sub> 100–130 f <sub>z</sub> 0.003–0.013	100–130 0.013–0.025	100–130 0.045–0.100
<b>N1</b>	V <sub>c</sub> 150–200 f <sub>z</sub> 0.005–0.018	150–200 0.018–0.035	150–200 0.060–0.150
<b>N2</b>	V <sub>c</sub> 150–200 f <sub>z</sub> 0.005–0.018	150–200 0.018–0.035	150–200 0.060–0.150
<b>N3</b>	V <sub>c</sub> 150–200 f <sub>z</sub> 0.004–0.015	150–200 0.015–0.030	150–200 0.050–0.120
<b>N4</b>	V <sub>c</sub> 150–200 f <sub>z</sub> 0.005–0.018	150–200 0.018–0.035	150–200 0.060–0.150
<b>N5</b>	V <sub>c</sub> 150–200 f <sub>z</sub> 0.005–0.018	150–200 0.018–0.035	150–200 0.060–0.150
<b>N6</b>	V <sub>c</sub> f <sub>z</sub>		
<b>N7</b>	V <sub>c</sub> 80–120 f <sub>z</sub> 0.005–0.018	80–120 0.018–0.035	80–120 0.060–0.150
<b>N8</b>	V <sub>c</sub> 80–120 f <sub>z</sub> 0.005–0.018	80–120 0.018–0.035	80–120 0.060–0.150
<b>S1</b>	V <sub>c</sub> 40–70 f <sub>z</sub> 0.002–0.012	40–70 0.012–0.023	40–70 0.040–0.090
<b>S2</b>	V <sub>c</sub> f <sub>z</sub>		
<b>H1</b>	V <sub>c</sub> f <sub>z</sub>		
<b>H2</b>	V <sub>c</sub> f <sub>z</sub>		
<b>H3</b>	V <sub>c</sub> f <sub>z</sub>		
<b>O1</b>	V <sub>c</sub> f <sub>z</sub>		
<b>O2</b>	V <sub>c</sub> f <sub>z</sub>		
<b>O3</b>	V <sub>c</sub> f <sub>z</sub>		

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.