Schnittdaten
Données de coupe
Parametri di lavoro
Cutting data

Art. 50806 / 50809

Mat.		ø 0.50–1.00	ø 1.10–2.90	ø 3.00–6.00
P1	v_c	15–25	25–40	25–40
	f	0.020–0.080	0.060–0.140	0.120–0.250
P2	v_c	12–20	20–35	20–35
	f	0.010–0.060	0.040–0.120	0.100–0.220
P3	v_c	8–18	12–30	12–30
	f	0.010–0.040	0.030–0.090	0.080–0.200
M1	v_c	6–12	10–20	10–20
	f	0.020–0.050	0.030–0.070	0.050–0.150
M2	v_c	5–10	8–16	8–16
	f	0.010–0.040	0.030–0.060	0.040–0.080
K1	v_c	15–25	25–40	25–40
	f	0.010–0.050	0.030–0.080	0.070–0.150
K2	v_c	12–20	20–35	20–35
	f	0.010–0.040	0.030–0.060	0.050–0.100
N1	v_c	30–45	45–60	45–60
	f	0.030–0.080	0.060–0.120	0.100–0.250
N2	v_c	20–35	30–45	30–45
	f	0.040–0.080	0.070–0.150	0.130–0.300
N3	v_c	15–30	25–40	25–40
	f	0.020–0.070	0.060–0.120	0.100–0.250
N4	v_c	15–25	25–40	25–40
	f	0.010–0.050	0.030–0.080	0.060–0.150
N5	v_c	30–45	45–60	45–60
	f	0.040–0.080	0.070–0.130	0.100–0.250
N6	v_c	15–30	25–40	25–40
	f	0.010–0.040	0.038–0.065	0.060–0.090
N7	v_c	15–25	25–40	25–40
	f	0.010–0.040	0.030–0.080	0.050–0.130
N8	v_c	8–18	12–30	12–30
	f	0.010–0.040	0.020–0.050	0.030–0.100
S1	v_c	20–35	30–45	30–45
	f	0.010–0.040	0.020–0.056	0.040–0.100
S2	v_c			
	f			
H1	v_c			
	f			
H2	v_c			
	f			
H3	v_c			
	f			
O1	v_c	20–35	30–45	30–45
	f	0.020–0.060	0.050–0.120	0.100–0.250
O2	v_c			
	f			
O3	v_c			
	f			

Art. 50808

Mat.		ø 0.50–1.00	ø 1.10–2.00	ø 2.10–3.00
P1	v_c	20–35	35–50	35–50
	f	0.010–0.030	0.030–0.050	0.050–0.070
P2	v_c	15–30	30–45	30–45
	f	0.010–0.025	0.025–0.045	0.045–0.065
P3	v_c	12–25	25–40	25–40
	f	0.010–0.020	0.020–0.040	0.040–0.060
M1	v_c	10–20	20–35	20–35
	f	0.010–0.020	0.020–0.035	0.035–0.045
M2	v_c	8–16	16–30	16–30
	f	0.010–0.020	0.020–0.030	0.030–0.040
K1	v_c	20–35	35–50	35–50
	f	0.010–0.035	0.035–0.055	0.055–0.075
K2	v_c	15–30	30–45	30–45
	f	0.010–0.030	0.030–0.050	0.050–0.070
N1	v_c	35–50	50–65	50–65
	f	0.020–0.040	0.040–0.060	0.060–0.080
N2	v_c	25–40	40–55	40–55
	f	0.020–0.050	0.050–0.070	0.070–0.090
N3	v_c	20–35	35–50	35–50
	f	0.020–0.040	0.040–0.060	0.060–0.080
N4	v_c	15–30	30–45	30–45
	f	0.010–0.030	0.030–0.050	0.050–0.070
N5	v_c	35–50	50–65	50–65
	f	0.020–0.050	0.050–0.070	0.070–0.090
N6	v_c	20–35	35–50	35–50
	f	0.010–0.030	0.030–0.050	0.050–0.070
N7	v_c	15–30	30–45	30–45
	f	0.010–0.025	0.025–0.045	0.045–0.065
N8	v_c	10–20	20–35	20–35
	f	0.010–0.020	0.020–0.030	0.030–0.040
S1	v_c	25–35	35–50	35–50
	f	0.010–0.030	0.030–0.050	0.050–0.070
S2	v_c	10–15	15–25	15–25
	f	0.010–0.020	0.020–0.035	0.035–0.050
H1	v_c	10–15	15–25	15–25
	f	0.010–0.020	0.020–0.030	0.030–0.040
H2	v_c			
	f			
H3	v_c			
	f			
O1	v_c	20–35	30–45	30–45
	f	0.020–0.050	0.050–0.075	0.075–0.100
O2	v_c	20–35	30–45	30–45
	f	0.015–0.035	0.035–0.055	0.055–0.080
O3	v_c			
	f			

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.