

Schnittdaten

Données de coupe

Parametri di lavoro

Cutting data

Art. 50810 / 50812 / 50814 / 50818

Mat.		ø 3.00–6.00	ø 6.00–12.00	ø 12.00–20.00
P1	Vc	25–40	25–40	25–40
	f	0.120–0.250	0.250–0.300	0.300–0.400
P2	Vc	20–35	20–35	20–35
	f	0.100–0.200	0.200–0.250	0.250–0.300
P3	Vc	10–30	10–30	10–30
	f	0.008–0.150	0.150–0.220	0.220–0.300
M1	Vc	10–20	10–20	10–20
	f	0.050–0.150	0.150–0.200	0.200–0.250
M2	Vc	8–16	8–16	8–16
	f	0.040–0.080	0.080–0.140	0.140–0.200
K1	Vc	25–40	25–40	25–40
	f	0.070–0.150	0.150–0.200	0.200–0.350
K2	Vc	20–35	20–35	20–35
	f	0.050–0.100	0.100–0.150	0.150–0.250
N1	Vc	45–60	45–60	45–60
	f	0.100–0.250	0.250–0.350	0.350–0.400
N2	Vc	30–45	30–45	30–45
	f	0.150–0.300	0.300–0.400	0.400–0.600
N3	Vc	25–40	25–40	25–40
	f	0.100–0.250	0.250–0.350	0.350–0.550
N4	Vc	25–40	25–40	25–40
	f	0.060–0.150	0.150–0.250	0.250–0.400
N5	Vc	45–60	45–60	45–60
	f	0.100–0.250	0.250–0.350	0.350–0.450
N6	Vc	25–40	25–40	25–40
	f	0.060–0.100	0.100–0.150	0.150–0.250
N7	Vc	25–40	25–40	25–40
	f	0.050–0.150	0.150–0.250	0.250–0.350
N8	Vc	12–30	12–30	12–30
	f	0.030–0.100	0.100–0.150	0.150–0.200
S1	Vc	30–45	30–45	30–45
	f	0.040–0.150	0.150–0.200	0.200–0.300
S2	Vc			
	f			
H1	Vc			
	f			
H2	Vc			
	f			
H3	Vc			
	f			
O1	Vc	30–45	30–45	30–45
	f	0.100–0.250	0.250–0.400	0.400–0.800
O2	Vc			
	f			
O3	Vc			
	f			

Art. 50811 / 50813 / 50815

Mat.		ø 2.00–4.00	ø 4.00–6.00	ø 6.00–12.00
P1	Vc	40–60	40–60	40–60
	f	0.120–0.250	0.250–0.300	0.300–0.400
P2	Vc	35–55	35–55	35–55
	f	0.100–0.200	0.200–0.250	0.250–0.300
P3	Vc	30–45	30–45	30–45
	f	0.008–0.150	0.150–0.220	0.220–0.300
M1	Vc	25–40	25–40	25–40
	f	0.050–0.150	0.150–0.200	0.200–0.250
M2	Vc	20–35	20–35	20–35
	f	0.040–0.080	0.080–0.140	0.140–0.200
K1	Vc	35–50	35–50	35–50
	f	0.070–0.150	0.150–0.200	0.200–0.350
K2	Vc	30–45	30–45	30–45
	f	0.050–0.100	0.100–0.150	0.150–0.250
N1	Vc	60–70	60–70	60–70
	f	0.100–0.250	0.250–0.350	0.350–0.400
N2	Vc	50–60	50–60	50–60
	f	0.150–0.300	0.300–0.400	0.400–0.600
N3	Vc	40–55	40–55	40–55
	f	0.100–0.250	0.250–0.350	0.350–0.550
N4	Vc	35–50	35–50	35–50
	f	0.060–0.150	0.150–0.250	0.250–0.400
N5	Vc	60–70	60–70	60–70
	f	0.100–0.250	0.250–0.350	0.350–0.450
N6	Vc	40–55	40–55	40–55
	f	0.060–0.100	0.100–0.150	0.150–0.250
N7	Vc	35–50	35–50	35–50
	f	0.050–0.150	0.150–0.250	0.250–0.350
N8	Vc	25–40	25–40	25–40
	f	0.030–0.100	0.100–0.150	0.150–0.200
S1	Vc	35–50	35–50	35–50
	f	0.040–0.150	0.150–0.200	0.200–0.300
S2	Vc	15–25	15–25	15–25
	f	0.030–0.100	0.100–0.150	0.150–0.200
H1	Vc	15–25	15–25	15–25
	f	0.040–0.060	0.060–0.080	0.080–0.120
H2	Vc			
	f			
H3	Vc			
	f			
O1	Vc	30–45	30–45	30–45
	f	0.100–0.250	0.250–0.400	0.400–0.800
O2	Vc	30–45	30–45	30–45
	f	0.080–0.200	0.200–0.350	0.350–0.600
O3	Vc			
	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.