

# Schnittdaten

## Données de coupe

### Parametri di lavoro

### Cutting data

#### Art. 56005

Mat.		ø 0.10–0.30	ø 0.35–0.80	ø 0.85–1.50
P1	Vc	8–18	15–30	30–60
	f	0.001–0.003	0.002–0.010	0.010–0.020
P2	Vc	6–16	12–25	20–40
	f	0.001–0.002	0.002–0.008	0.006–0.015
P3	Vc	6–13	10–20	18–35
	f	0.001–0.002	0.002–0.005	0.004–0.012
M1	Vc	5–12	10–18	15–30
	f	0.001–0.002	0.002–0.005	0.004–0.010
M2	Vc	5–10	8–15	13–25
	f	0.001–0.002	0.002–0.004	0.003–0.009
K1	Vc	8–18	15–30	30–60
	f	0.003–0.008	0.006–0.010	0.008–0.025
K2	Vc	6–16	12–25	20–40
	f	0.002–0.004	0.005–0.008	0.007–0.020
N1	Vc	12–20	18–35	35–65
	f	0.001–0.004	0.003–0.008	0.006–0.015
N2	Vc	10–18	15–30	25–50
	f	0.002–0.005	0.004–0.010	0.008–0.025
N3	Vc	8–18	15–30	30–60
	f	0.002–0.005	0.004–0.008	0.006–0.020
N4	Vc	8–18	15–30	30–60
	f	0.001–0.004	0.003–0.006	0.005–0.015
N5	Vc	12–20	18–35	35–65
	f	0.002–0.005	0.004–0.010	0.009–0.025
N6	Vc	8–18	15–30	30–60
	f	0.002–0.005	0.004–0.008	0.007–0.020
N7	Vc	8–18	15–30	30–60
	f	0.002–0.005	0.004–0.008	0.007–0.020
N8	Vc	6–13	10–20	18–35
	f	0.001–0.004	0.002–0.007	0.005–0.015
S1	Vc	15–30	28–45	30–45
	f	0.002–0.006	0.005–0.010	0.008–0.020
S2	Vc			
	f			
H1	Vc			
	f			
H2	Vc			
	f			
H3	Vc			
	f			
O1	Vc	8–18	15–30	30–60
	f	0.005–0.010	0.008–0.015	0.013–0.035
O2	Vc			
	f			
O3	Vc			
	f			

#### Art. 56033

Mat.		ø 0.03–0.10	ø 0.11–0.50	ø 0.51–1.00	ø 1.01–2.00	ø 2.01–3.00
P1	Vc	1.5–5	4–10	10–30	30–60	30–60
	f	0.001–0.003	0.002–0.010	0.010–0.018	0.018–0.028	0.028–0.045
P2	Vc	1.2–4	3.5–8	8–25	25–50	25–50
	f	0.001–0.002	0.002–0.008	0.008–0.016	0.016–0.026	0.026–0.040
P3	Vc	1–3	3–6	6–20	20–45	20–45
	f	0.001–0.002	0.002–0.007	0.007–0.013	0.013–0.024	0.024–0.035
M1	Vc	1.2–4	3.5–8	8–20	20–45	20–45
	f	0.001–0.002	0.002–0.007	0.007–0.013	0.013–0.023	0.023–0.033
M2	Vc	1–3	3–6	5–15	15–30	15–30
	f	0.001–0.002	0.002–0.005	0.005–0.010	0.010–0.020	0.020–0.030
K1	Vc	1.5–5	4–10	10–30	30–60	30–60
	f	0.001–0.004	0.004–0.008	0.008–0.015	0.015–0.030	0.030–0.045
K2	Vc	1.2–4	3.5–8	8–25	25–50	25–50
	f	0.001–0.003	0.003–0.007	0.007–0.013	0.013–0.025	0.025–0.040
N1	Vc	2–6	5–15	15–40	40–70	40–70
	f	0.001–0.003	0.003–0.006	0.006–0.012	0.012–0.023	0.023–0.035
N2	Vc	1.8–5.5	5–15	15–40	40–65	40–65
	f	0.001–0.003	0.003–0.007	0.007–0.013	0.013–0.025	0.025–0.040
N3	Vc	1.5–5	4–12	12–30	30–60	30–60
	f	0.001–0.002	0.002–0.006	0.006–0.011	0.011–0.022	0.022–0.035
N4	Vc	1.5–5	4–12	12–30	30–60	30–60
	f	0.001–0.002	0.002–0.005	0.005–0.010	0.010–0.020	0.020–0.030
N5	Vc	2–6	5–15	15–35	35–65	35–65
	f	0.001–0.003	0.003–0.006	0.006–0.013	0.013–0.025	0.025–0.040
N6	Vc	1.5–5	4–12	12–30	30–60	30–60
	f	0.001–0.002	0.002–0.004	0.004–0.010	0.010–0.022	0.022–0.035
N7	Vc	1.5–5	4–12	12–30	30–60	30–60
	f	0.001–0.002	0.002–0.004	0.004–0.009	0.009–0.020	0.020–0.031
N8	Vc	1–3	3–6	6–20	20–45	20–45
	f	0.001–0.002	0.002–0.004	0.004–0.008	0.008–0.016	0.016–0.027
S1	Vc	0.8–5	4–7	7–15	15–30	15–30
	f	0.001–0.002	0.002–0.004	0.004–0.009	0.009–0.018	0.018–0.030
S2	Vc					
	f					
H1	Vc					
	f					
H2	Vc					
	f					
H3	Vc					
	f					
O1	Vc	1.5–5	4–10	10–25	20–35	30–60
	f	0.001–0.003	0.003–0.008	0.008–0.014	0.014–0.035	0.035–0.060
O2	Vc					
	f					
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.