Schnittdaten
Données de coupe
Parametri di lavoro
Cutting data

Art. 56036

Mat.		ø 0.30–0.95	ø 1.00–1.95	ø 2.00–2.95	ø 3.00–3.95	ø 4.00–6.00
P1	v_c	40–60	60–90	60–90	60–90	60–90
	f	0.010–0.025	0.025–0.040	0.040–0.055	0.055–0.070	0.070–0.100
P2	v_c	30–50	50–70	50–70	50–70	50–70
	f	0.009–0.023	0.023–0.036	0.036–0.050	0.050–0.065	0.065–0.080
P3	v_c	20–40	40–60	40–60	40–60	40–60
	f	0.006–0.015	0.015–0.025	0.025–0.040	0.040–0.055	0.055–0.070
M1	v_c	20–35	35–50	35–50	35–50	35–50
	f	0.005–0.013	0.013–0.023	0.023–0.035	0.035–0.050	0.050–0.065
M2	v_c	20–30	30–45	30–45	30–45	30–45
	f	0.004–0.010	0.010–0.020	0.020–0.032	0.032–0.046	0.046–0.060
K1	v_c	60–100	100–150	100–150	100–150	100–150
	f	0.015–0.025	0.025–0.038	0.038–0.055	0.055–0.075	0.075–0.130
K2	v_c	40–80	80–130	80–130	80–130	80–130
	f	0.012–0.022	0.022–0.035	0.035–0.050	0.050–0.070	0.070–0.090
N1	v_c	60–90	90–120	90–120	90–120	90–120
	f	0.015–0.025	0.025–0.035	0.035–0.050	0.050–0.070	0.070–0.085
N2	v_c	70–120	120–150	120–150	120–150	120–150
	f	0.016–0.027	0.027–0.042	0.042–0.060	0.060–0.080	0.080–0.110
N3	v_c	70–120	120–150	120–150	120–150	120–150
	f	0.015–0.025	0.025–0.035	0.035–0.050	0.050–0.070	0.070–0.085
N4	v_c	40–70	70–100	70–100	70–100	70–100
	f	0.013–0.023	0.023–0.033	0.033–0.045	0.045–0.060	0.060–0.080
N5	v_c	70–120	120–150	120–150	120–150	120–150
	f	0.015–0.025	0.025–0.035	0.035–0.050	0.050–0.070	0.070–0.100
N6	v_c					
	f					
N7	v_c					
	f					
N8	v_c					
	f					
S1	v_c	30–40	40–70	40–70	40–70	40–70
	f	0.010–0.022	0.022–0.035	0.035–0.050	0.050–0.070	0.070–0.090
S2	v_c					
	f					
H1	v_c	15–25	20–35	20–35	20–35	20–35
	f	0.005–0.010	0.010–0.020	0.020–0.030	0.030–0.040	0.040–0.055
H2	v_c					
	f					
H3	v_c					
	f					
O1	v_c					
	f					
O2	v_c					
	f					
O3	v_c					
	f					

Art. 16004

Mat.		ø 0.10–0.30	ø 0.35–0.50	ø 0.55–0.80	ø 0.85–1.50
P1	v_c	1.0–2.0	2.0–5.5	3.5–11	9.0–15
	f	0.001–0.005	0.004–0.007	0.006–0.011	0.010–0.015
P2	v_c	0.8–1.5	1.2–4.0	3.5–8.0	7.0–12
	f	0.001–0.003	0.002–0.006	0.005–0.007	0.006–0.010
P3	v_c				
	f				
M1	v_c	0.8–1.5	1.2–4.0	3.5–8.0	7.0–12
	f	0.001–0.002	0.002–0.004	0.003–0.006	0.005–0.010
M2	v_c	0.5–1.2	1.0–3.5	2.0–5.0	3.0–7.5
	f	0.001–0.002	0.002–0.004	0.003–0.005	0.004–0.008
K1	v_c	1.0–2.0	2.0–5.5	3.5–11	9.0–15
	f	0.001–0.005	0.004–0.008	0.007–0.011	0.010–0.015
K2	v_c	0.8–1.5	1.2–4.0	3.5–8.0	7.0–12
	f	0.001–0.003	0.002–0.006	0.005–0.007	0.006–0.010
N1	v_c	1.0–2.0	2.0–5.5	3.5–11	9.0–15
	f	0.001–0.006	0.005–0.010	0.008–0.015	0.013–0.025
N2	v_c	0.8–1.5	1.2–4.0	3.5–8.0	7.0–12
	f	0.002–0.006	0.005–0.010	0.008–0.015	0.013–0.025
N3	v_c				
	f				
N4	v_c				
	f				
N5	v_c	1.0–2.0	2.0–5.5	3.5–11	9.0–15
	f	0.002–0.006	0.005–0.010	0.008–0.015	0.013–0.020
N6	v_c				
	f				
N7	v_c				
	f				
N8	v_c				
	f				
S1	v_c				
	f				
S2	v_c				
	f				
H1	v_c				
	f				
H2	v_c				
	f				
H3	v_c				
	f				
O1	v_c				
	f				
O2	v_c				
	f				
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.