

**Schnittdaten**  
**Données de coupe**  
**Parametri di lavoro**  
**Cutting data**

**Art. 51201**

Mat.		ø 0.30-0.50	ø 0.51-1.00	ø 1.01-2.00	ø 2.01-3.00
P1	Vc	5-12	12-35	35-65	35-60
	f	0.003-0.008	0.007-0.015	0.014-0.025	0.023-0.035
P2	Vc	4-9	9-28	28-55	28-55
	f	0.002-0.007	0.006-0.014	0.012-0.023	0.021-0.032
P3	Vc	3.3-7	7-23	23-50	23-50
	f	0.002-0.006	0.005-0.013	0.011-0.020	0.018-0.030
M1	Vc	4-9	9-28	28-55	28-55
	f	0.002-0.005	0.004-0.011	0.010-0.018	0.016-0.028
M2	Vc	3-8	8-20	18-35	18-35
	f	0.002-0.004	0.003-0.009	0.008-0.016	0.016-0.028
K1	Vc	5-12	12-35	35-65	35-60
	f	0.003-0.008	0.007-0.015	0.014-0.025	0.023-0.035
K2	Vc	4-10	10-30	30-55	30-50
	f	0.002-0.007	0.006-0.014	0.012-0.022	0.020-0.032
N1	Vc	6-19	19-45	45-80	45-80
	f	0.002-0.006	0.005-0.013	0.012-0.020	0.018-0.030
N2	Vc	5.5-17	17-45	45-70	45-70
	f	0.003-0.007	0.006-0.015	0.014-0.022	0.020-0.035
N3	Vc	5.5-15	15-35	35-65	35-65
	f	0.003-0.006	0.006-0.013	0.012-0.020	0.018-0.032
N4	Vc	5.5-15	15-35	35-65	35-65
	f	0.002-0.005	0.004-0.010	0.009-0.016	0.015-0.025
N5	Vc	6.5-18	18-40	40-70	40-70
	f	0.003-0.006	0.005-0.013	0.012-0.020	0.018-0.032
N6	Vc	5.5-15	15-35	35-65	35-65
	f	0.002-0.005	0.004-0.010	0.009-0.016	0.015-0.020
N7	Vc	5.5-15	15-35	35-65	35-65
	f	0.003-0.006	0.005-0.012	0.011-0.018	0.016-0.025
N8	Vc	3-7	7-23	23-50	23-50
	f	0.002-0.005	0.004-0.009	0.008-0.013	0.012-0.018
S1	Vc	5-8	8.0-18	18-35	18-35
	f	0.002-0.006	0.005-0.013	0.012-0.020	0.018-0.030
S2	Vc	2.5-7	6-12	11-20	11-20
	f	0.002-0.004	0.003-0.007	0.006-0.011	0.010-0.018
H1	Vc	2.5-7	6-12	11-20	11-20
	f	0.002-0.004	0.003-0.007	0.006-0.011	0.010-0.018
H2	Vc				
	f				
H3	Vc				
	f				
O1	Vc	5-12	12-35	35-65	35-60
	f	0.003-0.010	0.009-0.018	0.016-0.028	0.026-0.040
O2	Vc	2.5-6	6-20	20-45	20-45
	f	0.002-0.009	0.008-0.016	0.015-0.025	0.022-0.035
O3	Vc				
	f				

**Art. 50621**

Mat.		ø 0.20-0.50	ø 0.51-1.00	ø 1.01-2.00	ø 2.01-3.00
P1	Vc	6-15	15-35	15-35	15-35
	f	0.001-0.010	0.010-0.020	0.020-0.030	0.030-0.045
P2	Vc	5-13	13-30	13-30	13-30
	f	0.001-0.008	0.008-0.018	0.018-0.028	0.028-0.042
P3	Vc	4-12	12-25	12-25	12-25
	f	0.001-0.007	0.007-0.016	0.016-0.025	0.025-0.038
M1	Vc	4-12	12-25	12-25	12-25
	f	0.001-0.007	0.007-0.016	0.016-0.025	0.025-0.038
M2	Vc				
	f				
K1	Vc	6-15	15-35	15-35	15-35
	f	0.001-0.010	0.010-0.020	0.020-0.030	0.030-0.045
K2	Vc	5-13	13-30	13-30	13-30
	f	0.001-0.008	0.008-0.018	0.018-0.028	0.028-0.042
N1	Vc				
	f				
N2	Vc	8-20	20-45	20-45	20-45
	f	0.001-0.010	0.010-0.020	0.020-0.030	0.030-0.045
N3	Vc	6-18	18-40	18-40	18-40
	f	0.001-0.008	0.008-0.018	0.018-0.028	0.028-0.042
N4	Vc				
	f				
N5	Vc	6-18	18-40	18-40	18-40
	f	0.001-0.010	0.010-0.020	0.020-0.035	0.035-0.060
N6	Vc				
	f				
N7	Vc				
	f				
N8	Vc				
	f				
S1	Vc				
	f				
S2	Vc				
	f				
H1	Vc				
	f				
H2	Vc				
	f				
H3	Vc				
	f				
O1	Vc				
	f				
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.