

# Schnittdaten

## Données de coupe

## Parametri di lavoro

## Cutting data

### Art. 50720

Mat.		ø 0.20-0.50	ø 0.55-0.80	ø 0.85-1.20	ø 1.25-2.00
P1	Vc	8-20	20-40	20-40	20-40
	f	0.001-0.010	0.010-0.018	0.018-0.025	0.025-0.035
P2	Vc	6-18	18-38	18-38	18-38
	f	0.001-0.008	0.008-0.016	0.016-0.023	0.023-0.033
P3	Vc	5-14	14-30	14-30	14-30
	f	0.001-0.007	0.007-0.015	0.015-0.020	0.020-0.030
M1	Vc	5-14	14-30	14-30	14-30
	f	0.001-0.008	0.008-0.016	0.016-0.023	0.023-0.033
M2	Vc	3-12	12-25	12-25	12-25
	f	0.001-0.005	0.005-0.010	0.010-0.016	0.016-0.020
K1	Vc	8-20	20-40	20-40	20-40
	f	0.001-0.010	0.010-0.018	0.018-0.025	0.025-0.035
K2	Vc	6-18	6-18	6-18	6-18
	f	0.001-0.008	0.008-0.016	0.016-0.023	0.023-0.033
N1	Vc	6-18	18-38	18-38	18-38
	f	0.001-0.007	0.007-0.015	0.015-0.020	0.020-0.030
N2	Vc	10-25	25-55	25-55	25-55
	f	0.001-0.010	0.010-0.018	0.018-0.025	0.025-0.035
N3	Vc	8-22	22-50	22-50	22-50
	f	0.001-0.008	0.008-0.016	0.016-0.023	0.023-0.033
N4	Vc	5-14	14-30	14-30	14-30
	f	0.001-0.005	0.005-0.010	0.010-0.016	0.016-0.020
N5	Vc	10-25	25-55	25-55	25-55
	f	0.001-0.010	0.010-0.018	0.018-0.025	0.025-0.035
N6	Vc	5-15	15-30	15-30	15-30
	f	0.001-0.005	0.005-0.010	0.010-0.016	0.016-0.020
N7	Vc				
	f				
N8	Vc				
	f				
S1	Vc	6-10	10-20	10-20	10-20
	f	0.001-0.005	0.005-0.010	0.010-0.016	0.016-0.020
S2	Vc				
	f				
H1	Vc				
	f				
H2	Vc				
	f				
H3	Vc				
	f				
O1	Vc	15-30	15-30	15-30	15-30
	f	0.005-0.015	0.015-0.030	0.030-0.045	0.045-0.060
O2	Vc				
	f				
O3	Vc				
	f				

### Art. 50740 / 50760 / 50780

Mat.		ø 0.20-0.50	ø 0.55-0.80	ø 0.85-1.20	ø 1.25-2.00
P1	Vc	6-10	10-25	10-25	10-25
	f	0.001-0.006	0.006-0.010	0.010-0.022	0.022-0.030
P2	Vc	5-8	8-20	8-20	8-20
	f	0.001-0.005	0.005-0.008	0.008-0.015	0.015-0.020
P3	Vc	4-7	7-18	7-18	7-18
	f	0.001-0.004	0.004-0.007	0.007-0.012	0.012-0.015
M1	Vc	4-5	5-15	5-15	5-15
	f	0.001-0.003	0.003-0.006	0.006-0.012	0.012-0.018
M2	Vc	2-4	4-12	4-12	4-12
	f	0.001-0.003	0.003-0.005	0.005-0.010	0.010-0.015
K1	Vc	6-10	10-25	10-25	10-25
	f	0.001-0.006	0.006-0.010	0.010-0.022	0.022-0.030
K2	Vc	5-8	8-20	8-20	8-20
	f	0.001-0.005	0.005-0.008	0.008-0.015	0.015-0.020
N1	Vc	4-6	6-18	6-18	6-18
	f	0.001-0.004	0.004-0.007	0.007-0.012	0.012-0.015
N2	Vc	6-10	10-25	10-25	10-25
	f	0.001-0.006	0.006-0.010	0.010-0.022	0.022-0.030
N3	Vc	5-8	8-20	8-20	8-20
	f	0.001-0.005	0.005-0.008	0.008-0.015	0.015-0.020
N4	Vc	3-5	5-15	5-15	5-15
	f	0.001-0.004	0.004-0.007	0.007-0.012	0.012-0.015
N5	Vc	6-10	10-25	10-25	10-25
	f	0.001-0.006	0.006-0.010	0.010-0.022	0.022-0.030
N6	Vc	4-6	6-18	6-18	6-18
	f	0.001-0.003	0.003-0.005	0.005-0.010	0.010-0.015
N7	Vc				
	f				
N8	Vc				
	f				
S1	Vc	3-5	5-12	5-12	5-12
	f	0.001-0.003	0.003-0.005	0.005-0.010	0.010-0.015
S2	Vc				
	f				
H1	Vc				
	f				
H2	Vc				
	f				
H3	Vc				
	f				
O1	Vc	10-20	10-20	10-20	10-20
	f	0.005-0.010	0.010-0.015	0.015-0.020	0.020-0.025
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.