

Schnittdaten

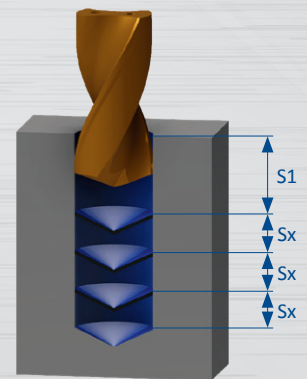
Données de coupe

Parametri di lavoro

Cutting data

Art. 51609

Mat.		ø 0.30–0.95	ø 1.00–1.95	ø 2.00–3.00	S1	Sx
P1	Vc	60–80	60–80	60–80	1xd–2xd	0.50xd–1xd
	f	0.015–0.035	0.035–0.050	0.050–0.075		
P2	Vc	50–70	50–70	50–70	1xd–2xd	0.50xd–1xd
	f	0.015–0.030	0.030–0.045	0.045–0.070		
P3	Vc	40–60	40–60	40–60	1xd–2xd	0.50xd–1xd
	f	0.010–0.025	0.025–0.040	0.040–0.065		
M1	Vc	30–40	30–40	30–40	0.50xd–1xd	0.25xd–0.50xd
	f	0.010–0.025	0.025–0.035	0.035–0.050		
M2	Vc	25–35	25–35	25–35	0.50xd–1xd	0.25xd–0.50xd
	f	0.010–0.025	0.025–0.035	0.035–0.050		
K1	Vc	100–120	100–120	100–120	4.50xd–9xd	0.25xd–0.50xd
	f	0.040–0.060	0.060–0.080	0.080–0.110		
K2	Vc	80–100	80–100	80–100	4.50xd–9xd	4.50xd–9xd
	f	0.040–0.060	0.060–0.080	0.080–0.110		
N1	Vc	120–150	120–150	120–150	2xd–4xd	1xd–2xd
	f	0.050–0.080	0.080–0.100	0.100–0.130		
N2	Vc	140–170	140–170	140–170	2xd–4xd	1xd–2xd
	f	0.050–0.080	0.080–0.100	0.100–0.130		
N3	Vc	140–170	140–170	140–170	2xd–4xd	1xd–2xd
	f	0.050–0.080	0.080–0.100	0.100–0.130		
N4	Vc	100–120	100–120	100–120	2xd–4xd	1xd–2xd
	f	0.040–0.060	0.060–0.080	0.080–0.110		
N5	Vc	100–140	100–140	100–140	2xd–4xd	1xd–2xd
	f	0.030–0.050	0.050–0.080	0.080–0.120		
N6	Vc					
	f					
N7	Vc					
	f					
N8	Vc					
	f					
S1	Vc	20–30	20–30	20–30	0.50xd–1xd	0.25xd–0.50xd
	f	0.010–0.020	0.020–0.040	0.040–0.060		
S2	Vc	15–25	15–25	15–25	0.50xd–1xd	0.25xd–0.50xd
	f	0.008–0.020	0.020–0.030	0.030–0.050		
H1	Vc	25–40	25–40	25–40	0.25xd–0.50xd	0.25xd–0.50xd
	f	0.005–0.015	0.015–0.025	0.025–0.035		
H2	Vc	15–20	15–20	15–20	0.25xd–0.50xd	0.125xd–0.25xd
	f	0.003–0.008	0.008–0.015	0.015–0.020		
H3	Vc					
	f					
O1	Vc	60–100	70–110	70–110	2xd–4xd	1xd–2xd
	f	0.010–0.020	0.020–0.030	0.030–0.040		
O2	Vc					
	f					
O3	Vc					
	f					



S1 = Erste Zustellung
Sx = Zustelltiefe

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.