

Schnittdaten

Données de coupe

Parametri di lavoro

Cutting data

Art. 52912 / 52916

Mat.	1.00-2.40	2.50-5.00	5.10-8.00	8.10-10.00
P1 Vc	70-110	70-110	70-110	70-110
f	0.030-0.080	0.060-0.130	0.125-0.170	0.170-0.240
P2 Vc	60-100	60-100	60-100	60-100
f	0.020-0.060	0.050-0.120	0.115-0.150	0.150-0.220
P3 Vc	50-90	50-90	50-90	50-90
f	0.015-0.050	0.040-0.100	0.080-0.130	0.140-0.200
M1 Vc	50-90	50-90	50-90	50-90
f	0.015-0.050	0.040-0.100	0.080-0.130	0.140-0.190
M2 Vc	40-80	40-80	40-80	40-80
f	0.010-0.045	0.030-0.090	0.070-0.120	0.120-0.170
K1 Vc	90-140	90-140	90-140	90-140
f	0.030-0.080	0.080-0.150	0.150-0.280	0.280-0.350
K2 Vc	80-120	80-120	80-120	80-120
f	0.040-0.100	0.060-0.130	0.130-0.220	0.220-0.300
N1 Vc	150-200	150-200	150-200	150-200
f	0.050-0.110	0.100-0.250	0.240-0.340	0.320-0.420
N2 Vc	150-200	150-200	150-200	150-200
f	0.050-0.110	0.100-0.250	0.240-0.340	0.320-0.420
N3 Vc	150-200	150-200	150-200	150-200
f	0.050-0.110	0.100-0.250	0.240-0.340	0.320-0.420
N4 Vc	120-170	120-170	120-170	120-170
f	0.030-0.080	0.060-0.130	0.140-0.190	0.165-0.210
N5 Vc	120-170	120-170	120-170	120-170
f	0.040-0.100	0.100-0.250	0.240-0.300	0.280-0.360
N6 Vc	80-120	80-120	80-120	80-120
f	0.040-0.100	0.100-0.250	0.240-0.300	0.280-0.360
N7 Vc				
f				
N8 Vc				
f				
S1 Vc	50-90	50-90	50-90	50-90
f	0.020-0.060	0.040-0.100	0.100-0.200	0.100-0.135
S2 Vc	30-55	30-55	30-55	30-55
f	0.010-0.040	0.030-0.070	0.080-0.130	0.100-0.170
H1 Vc	30-60	30-60	30-60	30-60
f	0.015-0.050	0.040-0.100	0.090-0.140	0.120-0.150
H2 Vc				
f				
H3 Vc				
f				
O1 Vc	70-110	70-110	70-110	70-110
f	0.025-0.050	0.050-0.130	0.130-0.170	0.170-0.220
O2 Vc				
f				
O3 Vc				
f				

Art. 52920 / 52930

Mat.	ø 3.00-5.00	ø 5.10-8.00	ø 8.10-10.00
P1 Vc			
f			
P2 Vc			
f			
P3 Vc	40-80	40-80	40-80
f	0.050-0.085	0.080-0.110	0.100-0.150
M1 Vc	30-70	30-70	30-70
f	0.045-0.070	0.065-0.085	0.080-0.120
M2 Vc	25-55	25-55	25-55
f	0.035-0.050	0.045-0.065	0.080-0.110
K1 Vc	70-110	70-110	70-110
f	0.100-0.200	0.180-0.250	0.230-0.280
K2 Vc	60-100	60-100	60-100
f	0.090-0.180	0.170-0.240	0.220-0.260
N1 Vc	60-100	60-100	60-100
f	0.130-0.250	0.230-0.340	0.320-0.380
N2 Vc	65-100	65-100	65-100
f	0.130-0.250	0.230-0.340	0.320-0.380
N3 Vc	70-110	70-110	70-110
f	0.130-0.250	0.230-0.340	0.320-0.380
N4 Vc			
f			
N5 Vc			
f			
N6 Vc			
f			
N7 Vc			
f			
N8 Vc			
f			
S1 Vc	30-60	30-60	30-60
f	0.035-0.070	0.065-0.085	0.080-0.110
S2 Vc	20-50	20-50	20-50
f	0.030-0.060	0.050-0.080	0.070-0.100
H1 Vc	20-40	20-40	20-40
f	0.010-0.035	0.030-0.040	0.035-0.060
H2 Vc			
f			
H3 Vc			
f			
O1 Vc	60-100	60-100	60-100
f	0.090-0.180	0.170-0.240	0.220-0.260
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.