

Schnittdaten

Données de coupe

Parametri di lavoro

Cutting data

Art. 50938

Mat.		ø 1.00–2.40	ø 2.50–5.00	ø 5.10–8.00	ø 8.10–12.70
P1	Vc	50–80	60–100	60–100	60–100
	f	0.030–0.070	0.045–0.120	0.110–0.150	0.150–0.200
P2	Vc	45–70	55–90	55–90	55–90
	f	0.030–0.060	0.040–0.115	0.100–0.140	0.140–0.180
P3	Vc	40–60	55–90	55–90	55–90
	f	0.020–0.050	0.040–0.115	0.100–0.140	0.140–0.180
M1	Vc	20–45	50–90	50–90	50–90
	f	0.010–0.040	0.040–0.100	0.090–0.130	0.120–0.150
M2	Vc	20–40	40–80	40–80	40–80
	f	0.010–0.035	0.035–0.090	0.075–0.110	0.110–0.130
K1	Vc	60–80	80–120	80–120	80–120
	f	0.050–0.080	0.090–0.250	0.240–0.300	0.280–0.360
K2	Vc	50–70	70–100	70–100	70–100
	f	0.040–0.070	0.080–0.230	0.220–0.280	0.265–0.320
N1	Vc				
	f				
N2	Vc	80–110	140–190	140–190	140–190
	f	0.040–0.130	0.090–0.230	0.220–0.300	0.300–0.360
N3	Vc	90–130	180–220	180–220	180–220
	f	0.040–0.140	0.090–0.230	0.220–0.300	0.300–0.360
N4	Vc				
	f				
N5	Vc				
	f				
N6	Vc				
	f				
N7	Vc				
	f				
N8	Vc				
	f				
S1	Vc	20–40	25–55	25–55	25–55
	f	0.010–0.030	0.025–0.050	0.040–0.070	0.060–0.100
S2	Vc				
	f				
H1	Vc	25–45	35–55	35–55	35–55
	f	0.010–0.020	0.015–0.040	0.030–0.060	0.050–0.090
H2	Vc				
	f				
H3	Vc				
	f				
O1	Vc				
	f				
O2	Vc				
	f				
O3	Vc				
	f				

Art. 50940

Mat.		ø 1.00–1.90	ø 2.00–5.00	ø 5.10–8.00	ø 8.10–12.70
P1	Vc	60–100	60–100	60–100	60–100
	f	0.020–0.050	0.045–0.120	0.110–0.150	0.150–0.200
P2	Vc	55–90	55–90	55–90	55–90
	f	0.015–0.045	0.040–0.115	0.100–0.140	0.140–0.180
P3	Vc	55–90	55–90	55–90	55–90
	f	0.015–0.045	0.040–0.115	0.100–0.140	0.140–0.180
M1	Vc	50–90	50–90	50–90	50–90
	f	0.015–0.045	0.040–0.100	0.090–0.130	0.120–0.150
M2	Vc	40–80	40–80	40–80	40–80
	f	0.010–0.040	0.035–0.090	0.075–0.110	0.110–0.130
K1	Vc	80–120	80–120	80–120	80–120
	f	0.040–0.100	0.090–0.250	0.240–0.300	0.280–0.360
K2	Vc	70–100	70–100	70–100	70–100
	f	0.030–0.090	0.080–0.230	0.220–0.280	0.265–0.320
N1	Vc				
	f				
N2	Vc	140–190	140–190	140–190	140–190
	f	0.040–0.100	0.090–0.230	0.220–0.300	0.300–0.360
N3	Vc	180–220	180–220	180–220	180–220
	f	0.040–0.100	0.090–0.230	0.220–0.300	0.300–0.360
N4	Vc				
	f				
N5	Vc				
	f				
N6	Vc				
	f				
N7	Vc				
	f				
N8	Vc				
	f				
S1	Vc	25–55	25–55	25–55	25–55
	f	0.010–0.030	0.025–0.050	0.040–0.070	0.060–0.100
S2	Vc				
	f				
H1	Vc	30–50	30–50	30–50	30–50
	f	0.005–0.015	0.010–0.040	0.030–0.050	0.050–0.065
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.