Schnittdaten
Données de coupe
Parametri di lavoro
Cutting data

Art. 50830

Mat.		ø 0.30–1.00	ø 1.10–5.00	ø 5.10–10.00	ø 10.10–15.00	ø 15.10–20.00
P1	v_c	30–60	50–90	50–90	50–90	50–90
	f	0.010–0.040	0.038–0.080	0.076–0.110	0.100–0.180	0.170–0.260
P2	v_c	20–35	30–60	30–60	30–60	30–60
	f	0.010–0.030	0.028–0.070	0.065–0.090	0.085–0.160	0.150–0.230
P3	v_c	15–30	25–50	25–50	25–50	25–50
	f	0.005–0.020	0.018–0.060	0.057–0.085	0.080–0.130	0.125–0.200
M1	v_c	15–30	25–50	25–50	25–50	25–50
	f	0.005–0.020	0.018–0.060	0.057–0.085	0.080–0.130	0.125–0.200
M2	v_c	10–20	15–40	15–40	15–40	15–40
	f	0.004–0.018	0.016–0.050	0.048–0.090	0.085–0.120	0.110–0.160
K1	v_c	40–80	70–120	70–120	70–120	70–120
	f	0.010–0.060	0.055–0.090	0.085–0.110	0.100–0.280	0.260–0.500
K2	v_c	30–50	40–80	40–80	40–80	40–80
	f	0.010–0.030	0.028–0.070	0.067–0.100	0.095–0.180	0.170–0.300
N1	v_c	30–60	50–90	50–90	50–90	50–90
	f	0.012–0.045	0.042–0.085	0.080–0.140	0.135–0.250	0.230–0.300
N2	v_c	40–80	70–120	70–120	70–120	70–120
	f	0.015–0.050	0.480–0.100	0.095–0.180	0.170–0.280	0.260–0.450
N3	v_c	30–70	60–110	60–110	60–110	60–110
	f	0.010–0.045	0.040–0.085	0.080–0.160	0.150–0.260	0.240–0.400
N4	v_c	20–40	30–70	30–70	30–70	30–70
	f	0.005–0.030	0.028–0.070	0.065–0.090	0.085–0.160	0.150–0.230
N5	v_c					
	f					
N6	v_c	15–30	25–50	25–50	25–50	25–50
	f	0.012–0.045	0.042–0.085	0.080–0.140	0.135–0.250	0.230–0.300
N7	v_c	15–30	25–50	25–50	25–50	25–50
	f	0.012–0.045	0.042–0.085	0.080–0.140	0.135–0.250	0.230–0.300
N8	v_c	10–20	15–35	15–35	15–35	15–35
	f	0.004–0.018	0.016–0.050	0.048–0.090	0.085–0.120	0.110–0.180
S1	v_c	20–30	25–50	25–50	25–50	25–50
	f	0.020–0.040	0.038–0.070	0.065–0.100	0.095–0.150	0.145–0.200
S2	v_c	10–20	15–35	15–35	15–35	15–35
	f	0.004–0.018	0.016–0.050	0.048–0.090	0.085–0.120	0.110–0.180
H1	v_c					
	f					
H2	v_c					
	f					
H3	v_c					
	f					
O1	v_c	20–40	30–70	30–70	30–70	30–70
	f	0.015–0.050	0.048–0.100	0.095–0.180	0.170–0.280	0.260–0.450
O2	v_c					
	f					
O3	v_c					
	f					

Art. 50838

Mat.		ø 0.30–1.00	ø 1.05–3.00	ø 3.105–6.00
P1	v_c	30–60	50–90	50–90
	f	0.010–0.040	0.038–0.050	0.045–0.060
P2	v_c	20–35	30–60	30–60
	f	0.010–0.030	0.028–0.045	0.040–0.055
P3	v_c	15–30	25–50	25–50
	f	0.005–0.020	0.018–0.035	0.030–0.050
M1	v_c	15–30	25–50	25–50
	f	0.005–0.020	0.018–0.035	0.030–0.050
M2	v_c	10–20	15–40	15–40
	f	0.004–0.018	0.016–0.030	0.028–0.040
K1	v_c	40–80	70–120	70–120
	f	0.010–0.060	0.055–0.070	0.065–0.100
K2	v_c	30–50	40–80	40–80
	f	0.010–0.030	0.028–0.055	0.050–0.080
N1	v_c	30–60	50–90	50–90
	f	0.012–0.045	0.042–0.060	0.055–0.090
N2	v_c	40–80	70–120	70–120
	f	0.015–0.050	0.048–0.070	0.065–0.110
N3	v_c	30–70	60–110	60–110
	f	0.010–0.045	0.040–0.065	0.060–0.100
N4	v_c	20–40	30–70	30–70
	f	0.005–0.030	0.028–0.050	0.048–0.075
N5	v_c	30–60	50–90	50–90
	f	0.015–0.050	0.048–0.070	0.065–0.110
N6	v_c	15–30	25–50	25–50
	f	0.012–0.045	0.040–0.065	0.060–0.100
N7	v_c			
	f			
N8	v_c			
	f			
S1	v_c	20–35	30–60	30–60
	f	0.010–0.030	0.028–0.045	0.040–0.055
S2	v_c			
	f			
H1	v_c			
	f			
H2	v_c			
	f			
H3	v_c			
	f			
O1	v_c	20–40	30–70	30–70
	f	0.015–0.050	0.048–0.070	0.065–0.120
O2	v_c			
	f			
O3	v_c			
	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.