Schnittdaten
Données de coupe
Parametri di lavoro
Cutting data

Art. 55654 / 55338

Mat.		ø 1.00–2.00	ø 2.10–5.00	ø 5.10–8.00	ø 8.10–11.00	ø 11.10–14.00
P1	V_c	40–60	40–60	40–60	40–60	40–60
	f	0.015–0.040	0.035–0.080	0.075–0.170	0.160–0.230	0.200–0.300
P2	V_c	30–50	30–50	30–50	30–50	30–50
	f	0.010–0.035	0.030–0.075	0.070–0.155	0.150–0.210	0.190–0.250
P3	V_c					
	f					
M1	V_c	25–40	25–40	25–40	25–40	25–40
	f	0.010–0.030	0.025–0.070	0.060–0.100	0.090–0.140	0.120–0.200
M2	V_c					
	f					
K1	V_c	60–100	60–100	60–100	60–100	60–100
	f	0.020–0.050	0.040–0.090	0.080–0.180	0.160–0.280	0.250–0.350
K2	V_c	40–80	40–80	40–80	40–80	40–80
	f	0.015–0.040	0.035–0.080	0.700–0.170	0.150–0.230	0.210–0.300
N1	V_c					
	f					
N2	V_c	80–120	80–120	80–120	80–120	80–120
	f	0.020–0.060	0.050–0.120	0.100–0.230	0.210–0.340	0.330–0.450
N3	V_c	60–100	60–100	60–100	60–100	60–100
	f	0.020–0.060	0.050–0.120	0.100–0.230	0.210–0.340	0.330–0.450
N4	V_c					
	f					
N5	V_c					
	f					
N6	V_c					
	f					
N7	V_c					
	f					
N8	V_c					
	f					
S1	V_c	30–50	30–50	30–50	30–50	30–50
	f	0.010–0.030	0.025–0.070	0.060–0.130	0.100–0.160	0.150–0.200
S2	V_c					
	f					
H1	V_c					
	f					
H2	V_c					
	f					
H3	V_c					
	f					
O1	V_c	30–50	30–50	30–50	30–50	30–50
	f	0.013–0.035	0.035–0.045	0.045–0.060	0.060–0.080	0.080–0.100
O2	V_c					
	f					
O3	V_c					
	f					

Art. 55652

Mat.		ø 0.20–0.50	ø 0.51–1.00	ø 1.01–2.00	ø 2.01–2.99
P1	V_c	10–25	25–40	40–60	40–60
	f	0.005–0.008	0.007–0.015	0.013–0.040	0.035–0.050
P2	V_c	8.0–20	20–30	30–50	30–50
	f	0.004–0.007	0.006–0.015	0.013–0.035	0.030–0.045
P3	V_c				
	f				
M1	V_c	8–15	15–25	25–40	25–40
	f	0.003–0.006	0.005–0.012	0.010–0.020	0.018–0.030
M2	V_c				
	f				
K1	V_c	20–45	45–60	60–100	60–100
	f	0.004–0.008	0.007–0.015	0.013–0.040	0.035–0.050
K2	V_c	15–30	30–40	40–80	40–80
	f	0.002–0.006	0.005–0.013	0.011–0.032	0.030–0.045
N1	V_c				
	f				
N2	V_c	20–50	50–80	80–120	80–120
	f	0.005–0.010	0.008–0.020	0.018–0.050	0.040–0.080
N3	V_c	10–30	30–60	60–100	60–100
	f	0.005–0.010	0.008–0.020	0.018–0.050	0.040–0.080
N4	V_c				
	f				
N5	V_c				
	f				
N6	V_c				
	f				
N7	V_c				
	f				
N8	V_c				
	f				
S1	V_c	10–20	20–30	30–50	30–50
	f	0.002–0.005	0.004–0.010	0.008–0.030	0.028–0.040
S2	V_c				
	f				
H1	V_c				
	f				
H2	V_c				
	f				
H3	V_c				
	f				
O1	V_c	8.0–20	20–30	30–50	30–50
	f	0.004–0.007	0.006–0.015	0.013–0.035	0.030–0.045
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.

swiss made by SPHINX◆TOOLS