

# 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	Vc	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	Vc	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	Vc					
	f					
M1	Vc	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	Vc					
	f					
K1	Vc	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	Vc	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	Vc					
	f					
N2	Vc	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	Vc	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	Vc					
	f					
N5	Vc					
	f					
N6	Vc					
	f					
N7	Vc					
	f					
N8	Vc					
	f					
S1	Vc	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	Vc					
	f					
H1	Vc					
	f					
H2	Vc					
	f					
H3	Vc					
	f					
O1	Vc	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	Vc					
	f					
O3	Vc					
	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	Vc	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	Vc	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	Vc				
	f				
M1	Vc	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	Vc				
	f				
K1	Vc	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	Vc	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	Vc				
	f				
N2	Vc	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	Vc	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	Vc				
	f				
N5	Vc				
	f				
N6	Vc				
	f				
N7	Vc				
	f				
N8	Vc				
	f				
S1	Vc	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	Vc				
	f				
H1	Vc				
	f				
H2	Vc				
	f				
H3	Vc				
	f				
O1	Vc	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	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.