

**Schnittdaten**  
**Données de coupe**  
**Parametri di lavoro**  
**Cutting data**

**Art. 58000 / 58500**

Mat.	∅ 0.99–2.00	∅ 2.01–3.00	∅ 3.01–4.00	∅ 4.01–5.00	∅ 5.01–6.00
P1	Vc 20–30 f 0.050–0.100	20–30	20–30	20–30	20–30
P2	Vc 15–25 f 0.040–0.080	15–25	15–25	15–25	15–25
P3	Vc 10–20 f 0.035–0.070	10–20	10–20	10–20	10–20
M1	Vc 10–20 f 0.040–0.080	10–20	10–20	10–20	10–20
M2	Vc 10–15 f 0.035–0.070	10–15	10–15	10–15	10–15
K1	Vc 20–30 f 0.050–0.100	20–30	20–30	20–30	20–30
K2	Vc 15–25 f 0.050–0.090	15–25	15–25	15–25	15–25
N1	Vc f				
N2	Vc 30–40 f 0.060–0.120	30–40	30–40	30–40	30–40
N3	Vc 25–35 f 0.060–0.120	25–35	25–35	25–35	25–35
N4	Vc 15–25 f 0.035–0.070	15–25	15–25	15–25	15–25
N5	Vc 30–40 f 0.035–0.070	30–40	30–40	30–40	30–40
N6	Vc f				
N7	Vc f				
N8	Vc f				
S1	Vc 10–15 f 0.035–0.070	10–15	10–15	10–15	10–15
S2	Vc f				
H1	Vc f				
H2	Vc f				
H3	Vc f				
O1	Vc f				
O2	Vc f				
O3	Vc f				

**Art. 70030 – 70090 / 70130 – 70190**

Mat.		
P1	Vc 180–280 Vf 80–180	mm/min
P2	Vc 180–280 Vf 70–160	mm/min
P3	Vc 180–280 Vf 70–150	mm/min
M1	Vc 180–280 Vf 70–150	mm/min
M2	Vc 180–280 Vf 70–150	mm/min
K1	Vc 180–280 Vf 80–180	mm/min
K2	Vc 180–280 Vf 70–160	mm/min
N1	Vc 180–280 Vf 60–140	mm/min
N2	Vc 180–280 Vf 80–180	mm/min
N3	Vc 180–280 Vf 70–160	mm/min
N4	Vc 180–280 Vf 60–120	mm/min
N5	Vc 180–280 Vf 80–200	mm/min
N6	Vc 180–280 Vf 60–150	mm/min
N7	Vc 180–280 Vf 80–200	mm/min
N8	Vc 180–280 Vf 80–200	mm/min
S1	Vc 180–280 Vf 50–120	mm/min
S2	Vc Vf	
H1	Vc Vf	
H2	Vc Vf	
H3	Vc Vf	
O1	Vc 180–280 Vf 80–200	mm/min
O2	Vc Vf	
O3	Vc Vf	

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.