

Schnittdaten
Données de coupe
Parametri di lavoro
Cutting data

Art. 58000 / 58500

Mat.	φ 0.99–2.00	φ 2.01–3.00	φ 3.01–4.00	φ 4.01–5.00	φ 5.01–6.00
P1	Vc 20–30 f 0.050–0.100	Vc 20–30 f 0.080–0.130	Vc 20–30 f 0.120–0.180	Vc 20–30 f 0.170–0.230	Vc 20–30 f 0.220–0.280
P2	Vc 15–25 f 0.040–0.080	Vc 15–25 f 0.070–0.120	Vc 15–25 f 0.110–0.170	Vc 15–25 f 0.160–0.220	Vc 15–25 f 0.210–0.260
P3	Vc 10–20 f 0.035–0.070	Vc 10–20 f 0.060–0.100	Vc 10–20 f 0.090–0.150	Vc 10–20 f 0.130–0.180	Vc 10–20 f 0.170–0.200
M1	Vc 10–20 f 0.040–0.080	Vc 10–20 f 0.070–0.120	Vc 10–20 f 0.110–0.170	Vc 10–20 f 0.160–0.220	Vc 10–20 f 0.200–0.260
M2	Vc 10–15 f 0.035–0.070	Vc 10–15 f 0.060–0.100	Vc 10–15 f 0.090–0.150	Vc 10–15 f 0.130–0.180	Vc 10–15 f 0.170–0.200
K1	Vc 20–30 f 0.050–0.100	Vc 20–30 f 0.080–0.150	Vc 20–30 f 0.140–0.220	Vc 20–30 f 0.200–0.260	Vc 20–30 f 0.030–0.280
K2	Vc 15–25 f 0.050–0.090	Vc 15–25 f 0.750–0.140	Vc 15–25 f 0.130–0.200	Vc 15–25 f 0.180–0.240	Vc 15–25 f 0.200–0.260
N1	Vc f				
N2	Vc 30–40 f 0.060–0.120	Vc 30–40 f 0.110–0.160	Vc 30–40 f 0.150–0.220	Vc 30–40 f 0.200–0.260	Vc 30–40 f 0.240–0.300
N3	Vc 25–35 f 0.060–0.120	Vc 25–35 f 0.110–0.160	Vc 25–35 f 0.150–0.220	Vc 25–35 f 0.200–0.260	Vc 25–35 f 0.240–0.300
N4	Vc 15–25 f 0.035–0.070	Vc 15–25 f 0.060–0.100	Vc 15–25 f 0.090–0.150	Vc 15–25 f 0.130–0.180	Vc 15–25 f 0.170–0.200
N5	Vc 30–40 f 0.035–0.070	Vc 30–40 f 0.060–0.100	Vc 30–40 f 0.090–0.150	Vc 30–40 f 0.130–0.180	Vc 30–40 f 0.170–0.200
N6	Vc f				
N7	Vc f				
N8	Vc f				
S1	Vc 10–15 f 0.035–0.070	Vc 10–15 f 0.060–0.100	Vc 10–15 f 0.090–0.150	Vc 10–15 f 0.130–0.180	Vc 10–15 f 0.170–0.200
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.