

# Schnittdaten

## Données de coupe

## Parametri di lavoro

## Cutting data

### Art. 72075 / 72150

Mat.	ø 0.10-0.30	ø 0.40-1.50	ø 1.50-3.0	a <sub>p</sub>	a <sub>e</sub>
<b>P1</b>	V <sub>c</sub> 60-80 f <sub>z</sub> 0.001-0.005	60-80 0.004-0.020	60-80 0.018-0.040	0.5 x d1	1 x d1
<b>P2</b>	V <sub>c</sub> 50-70 f <sub>z</sub> 0.001-0.005	50-70 0.004-0.020	50-70 0.018-0.040	0.3 x d1	1 x d1
<b>P3</b>	V <sub>c</sub> 40-60 f <sub>z</sub> 0.001-0.004	40-60 0.003-0.200	40-60 0.015-0.035	0.2 x d1	1 x d1
<b>M1</b>	V <sub>c</sub> 30-50 f <sub>z</sub> 0.001-0.004	30-50 0.003-0.020	30-50 0.015-0.035	0.4 x d1	1 x d1
<b>M2</b>	V <sub>c</sub> 25-40 f <sub>z</sub> 0.001-0.004	25-40 0.003-0.016	25-40 0.014-0.028	0.25 x d1	1 x d1
<b>K1</b>	V <sub>c</sub> 40-70 f <sub>z</sub> 0.001-0.005	40-70 0.004-0.020	40-70 0.018-0.040	1 x d1	1 x d1
<b>K2</b>	V <sub>c</sub> 30-60 f <sub>z</sub> 0.001-0.004	30-60 0.003-0.020	30-60 0.015-0.035	0.4 x d1	1 x d1
<b>N1</b>	V <sub>c</sub> 70-100 f <sub>z</sub> 0.001-0.004	70-100 0.003-0.020	70-100 0.015-0.035	1 x d1	1 x d1
<b>N2</b>	V <sub>c</sub> 80-120 f <sub>z</sub> 0.001-0.005	80-120 0.004-0.020	80-120 0.018-0.040	0.9 x d1	1 x d1
<b>N3</b>	V <sub>c</sub> 60-100 f <sub>z</sub> 0.001-0.005	60-100 0.004-0.020	60-100 0.018-0.040	0.9 x d1	1 x d1
<b>N4</b>	V <sub>c</sub> f <sub>z</sub>				
<b>N5</b>	V <sub>c</sub> 40-80 f <sub>z</sub> 0.001-0.005	40-80 0.004-0.020	40-80 0.018-0.040	1 x d1	1 x d1
<b>N6</b>	V <sub>c</sub> 25-50 f <sub>z</sub> 0.001-0.004	25-50 0.003-0.020	25-50 0.015-0.035	0.5 x d1	1 x d1
<b>N7</b>	V <sub>c</sub> f <sub>z</sub>				
<b>N8</b>	V <sub>c</sub> f <sub>z</sub>				
<b>S1</b>	V <sub>c</sub> 25-50 f <sub>z</sub> 0.001-0.003	25-50 0.002-0.015	25-50 0.012-0.030	0.4 x d1	1 x d1
<b>S2</b>	V <sub>c</sub> f <sub>z</sub>				
<b>H1</b>	V <sub>c</sub> f <sub>z</sub>				
<b>H2</b>	V <sub>c</sub> f <sub>z</sub>				
<b>H3</b>	V <sub>c</sub> f <sub>z</sub>				
<b>O1</b>	V <sub>c</sub> 80-120 f <sub>z</sub> 0.001-0.006	80-120 0.005-0.025	80-120 0.020-0.045	1 x d1	1 x d1
<b>O2</b>	V <sub>c</sub> f <sub>z</sub>				
<b>O3</b>	V <sub>c</sub> f <sub>z</sub>				

### Art. 42000

Mat.	ø 0.30-0.70	ø 0.70-1.50	ø 1.50-2.50	a <sub>p</sub>	a <sub>e</sub>
<b>P1</b>	V <sub>c</sub> 60-80 f <sub>z</sub> 0.005-0.010	60-80 0.008-0.020	60-80 0.018-0.040	0.30 x d1	1 x d1
<b>P2</b>	V <sub>c</sub> 50-70 f <sub>z</sub> 0.005-0.010	50-70 0.008-0.020	50-70 0.018-0.040	0.15 x d1	1 x d1
<b>P3</b>	V <sub>c</sub> 40-60 f <sub>z</sub> 0.004-0.010	40-60 0.006-0.020	40-60 0.0015-0.035	0.10 x d1	1 x d1
<b>M1</b>	V <sub>c</sub> 30-50 f <sub>z</sub> 0.004-0.010	30-50 0.006-0.020	30-50 0.015-0.035	0.10 x d1	1 x d1
<b>M2</b>	V <sub>c</sub> 25-40 f <sub>z</sub> 0.004-0.008	25-40 0.005-0.016	25-40 0.014-0.028	0.10 x d1	1 x d1
<b>K1</b>	V <sub>c</sub> 40-70 f <sub>z</sub> 0.005-0.010	40-70 0.008-0.020	40-70 0.018-0.040	0.40 x d1	1 x d1
<b>K2</b>	V <sub>c</sub> 30-60 f <sub>z</sub> 0.004-0.010	30-60 0.006-0.020	30-60 0.015-0.035	0.20 x d1	1 x d1
<b>N1</b>	V <sub>c</sub> 70-100 f <sub>z</sub> 0.004-0.01	70-100 0.006-0.020	70-100 0.015-0.035	0.40 x d1	1 x d1
<b>N2</b>	V <sub>c</sub> 80-120 f <sub>z</sub> 0.005-0.010	80-120 0.008-0.020	80-120 0.018-0.040	0.25 x d1	1 x d1
<b>N3</b>	V <sub>c</sub> 60-100 f <sub>z</sub> 0.005-0.010	60-100 0.008-0.020	60-100 0.018-0.040	0.25 x d1	1 x d1
<b>N4</b>	V <sub>c</sub> f <sub>z</sub>				
<b>N5</b>	V <sub>c</sub> 40-80 f <sub>z</sub> 0.005-0.010	40-80 0.008-0.020	40-80 0.018-0.040	0.40 x d1	1 x d1
<b>N6</b>	V <sub>c</sub> 25-50 f <sub>z</sub> 0.004-0.010	25-50 0.006-0.020	25-50 0.015-0.035	0.20 x d1	1 x d1
<b>N7</b>	V <sub>c</sub> f <sub>z</sub>				
<b>N8</b>	V <sub>c</sub> f <sub>z</sub>				
<b>S1</b>	V <sub>c</sub> 25-50 f <sub>z</sub> 0.003-0.008	25-50 0.006-0.015	25-50 0.012-0.030	0.20 x d1	1 x d1
<b>S2</b>	V <sub>c</sub> f <sub>z</sub>				
<b>H1</b>	V <sub>c</sub> f <sub>z</sub>				
<b>H2</b>	V <sub>c</sub> f <sub>z</sub>				
<b>H3</b>	V <sub>c</sub> f <sub>z</sub>				
<b>O1</b>	V <sub>c</sub> 80-120 f <sub>z</sub> 0.006-0.012	80-120 0.010-0.025	80-120 0.020-0.045	0.20 x d1	1 x d1
<b>O2</b>	V <sub>c</sub> f <sub>z</sub>				
<b>O3</b>	V <sub>c</sub> f <sub>z</sub>				

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.