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_p	a_e
P1	v_c	60–80	60–80	60–80		
	f_z	0.001–0.005	0.004–0.020	0.018–0.040	0.5×d1	1×d1
P2	v_c	50–70	50–70	50–70		
	f_z	0.001–0.005	0.004–0.020	0.018–0.040	0.3×d1	1×d1
P3	v_c	40–60	40–60	40–60		
	f_z	0.001–0.004	0.003–0.200	0.015–0.035	0.2×d1	1×d1
M1	v_c	30–50	30–50	30–50		
	f_z	0.001–0.004	0.003–0.020	0.015–0.035	0.4×d1	1×d1
M2	v_c	25–40	25–40	25–40		
	f_z	0.001–0.004	0.003–0.016	0.014–0.028	0.25×d1	1×d1
K1	v_c	40–70	40–70	40–70		
	f_z	0.001–0.005	0.004–0.020	0.018–0.040	1×d1	1×d1
K2	v_c	30–60	30–60	30–60		
	f_z	0.001–0.004	0.003–0.020	0.015–0.035	0.4×d1	1×d1
N1	v_c	70–100	70–100	70–100		
	f_z	0.001–0.004	0.003–0.020	0.015–0.035	1×d1	1×d1
N2	v_c	80–120	80–120	80–120		
	f_z	0.001–0.005	0.004–0.020	0.018–0.040	0.9×d1	1×d1
N3	v_c	60–100	60–100	60–100		
	f_z	0.001–0.005	0.004–0.020	0.018–0.040	0.9×d1	1×d1
N4	v_c					
	f_z					
N5	v_c	40–80	40–80	40–80		
	f_z	0.001–0.005	0.004–0.020	0.018–0.040	1×d1	1×d1
N6	v_c	25–50	25–50	25–50		
	f_z	0.001–0.004	0.003–0.020	0.015–0.035	0.5×d1	1×d1
N7	v_c					
	f_z					
N8	v_c					
	f_z					
S1	v_c	25–50	25–50	25–50		
	f_z	0.001–0.003	0.002–0.015	0.012–0.030	0.4×d1	1×d1
S2	v_c					
	f_z					
H1	v_c					
	f_z					
H2	v_c					
	f_z					
H3	v_c					
	f_z					
O1	v_c	80–120	80–120	80–120		
	f_z	0.001–0.006	0.005–0.025	0.020–0.045	1×d1	1×d1
O2	v_c					
	f_z					
O3	v_c					
	f_z					

Art. 42000

Mat.		ø 0.30–0.70	ø 0.70–1.50	ø 1.50–2.50	a_p	a_e
P1	v_c	60–80	60–80	60–80		
	f_z	0.005–0.010	0.008–0.020	0.018–0.040	0.30 x d1	1 x d1
P2	v_c	50–70	50–70	50–70		
	f_z	0.005–0.010	0.008–0.020	0.018–0.040	0.15 x d1	1 x d1
P3	v_c	40–60	40–60	40–60		
	f_z	0.004–0.010	0.006–0.020	0.0015–0.035	0.10 x d1	1 x d1
M1	v_c	30–50	30–50	30–50		
	f_z	0.004–0.010	0.006–0.020	0.015–0.035	0.10 x d1	1 x d1
M2	v_c	25–40	25–40	25–40		
	f_z	0.004–0.008	0.005–0.016	0.014–0.028	0.10 x d1	1 x d1
K1	v_c	40–70	40–70	40–70		
	f_z	0.005–0.010	0.008–0.020	0.018–0.040	0.40 x d1	1 x d1
K2	v_c	30–60	30–60	30–60		
	f_z	0.004–0.010	0.006–0.020	0.015–0.035	0.20 x d1	1 x d1
N1	v_c	70–100	70–100	70–100		
	f_z	0.004–0.01	0.006–0.020	0.015–0035	0.40 x d1	1 x d1
N2	v_c	80–120	80–120	80–120		
	f_z	0.005–0.010	0.008–0.020	0.018–0.040	0.25 x d1	1 x d1
N3	v_c	60–100	60–100	60–100		
	f_z	0.005–0.010	0.008–0.020	0.018–0.040	0.25 x d1	1 x d1
N4	v_c					
	f_z					
N5	v_c	40–80	40–80	40–80		
	f_z	0.005–0.010	0.008–0.020	0.018–0.040	0.40 x d1	1 x d1
N6	v_c	25–50	25–50	25–50		
	f_z	0.004–0.010	0.006–0.020	0.015–0.035	0.20 x d1	1 x d1
N7	v_c					
	f_z					
N8	v_c					
	f_z					
S1	v_c	25–50	25–50	25–50		
	f_z	0.003–0.008	0.006–0.015	0.012–0.030	0.20 x d1	1 x d1
S2	v_c					
	f_z					
H1	v_c					
	f_z					
H2	v_c					
	f_z					
H3	v_c					
	f_z					
O1	v_c	80–120	80–120	80–120		
	f_z	0.006–0.012	0.010–0.025	0.020–0.045	0.20 x d1	1 x d1
O2	v_c					
	f_z					
O3	v_c					
	f_z					

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.