

Schnittdaten
Données de coupe
Parametri di lavoro
Cutting data

Art. 43400

Mat.		ø 1.00–2.00	ø 3.00–4.00	ø 5.00–6.00
P1	V _c	80–120	80–120	80–120
	f _z	0.020–0.030	0.030–0.040	0.040–0.050
P2	V _c	80–100	80–100	80–100
	f _z	0.010–0.020	0.020–0.030	0.030–0.040
P3	V _c	50–80	50–80	50–80
	f _z	0.005–0.015	0.015–0.025	0.025–0.035
M1	V _c	60–100	60–100	60–100
	f _z	0.010–0.015	0.015–0.025	0.025–0.035
M2	V _c	40–70	40–70	40–70
	f _z	0.015–0.025	0.025–0.035	0.035–0.045
K1	V _c	100–150	100–150	100–150
	f _z	0.010–0.020	0.020–0.030	0.030–0.040
K2	V _c	60–100	60–100	60–100
	f _z	0.005–0.015	0.015–0.025	0.025–0.035
N1	V _c	150–200	150–200	150–200
	f _z	0.020–0.030	0.030–0.040	0.040–0.050
N2	V _c	150–200	150–200	150–200
	f _z	0.020–0.030	0.030–0.050	0.050–0.060
N3	V _c	130–200	130–200	130–200
	f _z	0.020–0.030	0.030–0.050	0.050–0.060
N4	V _c	60–150	60–150	60–150
	f _z	0.015–0.025	0.025–0.035	0.035–0.045
N5	V _c	100–200	100–200	100–200
	f _z	0.015–0.025	0.025–0.035	0.035–0.045
N6	V _c	80–150	80–150	80–150
	f _z	0.010–0.020	0.020–0.030	0.030–0.040
N7	V _c	80–150	80–150	80–150
	f _z	0.010–0.020	0.020–0.030	0.030–0.040
N8	V _c	80–150	80–150	80–150
	f _z	0.010–0.020	0.020–0.030	0.030–0.040
S1	V _c	40–70	40–70	40–70
	f _z	0.010–0.025	0.020–0.035	0.030–0.045
S2	V _c	20–40	20–40	20–40
	f _z	0.005–0.015	0.015–0.025	0.020–0.035
H1	V _c	20–45	25–40	25–40
	f _z	0.005–0.015	0.015–0.025	0.025–0.035
H2	V _c	20–30	15–25	15–25
	f _z	0.005–0.010	0.010–0.015	0.015–0.020
H3	V _c			
	f _z			
O1	V _c	100–150	70–110	70–110
	f _z	0.010–0.020	0.020–0.030	0.030–0.040
O2	V _c			
	f _z			
O3	V _c			
	f _z			

Art. 71330

Mat.		ø 0.20–1.00	ø 1.00–2.00	ø 2.00–3.00	a _p	a _e
P1	V _c	40–60	40–60	40–60		
	f _z	0.002–0.013	0.013–0.020	0.020–0.030	1×d	0.2×d
P2	V _c	30–50	30–50	30–50		
	f _z	0.002–0.012	0.012–0.018	0.018–0.025	1×d	0.2×d
P3	V _c					
	f _z					
M1	V _c	25–40	25–40	24–40		
	f _z	0.002–0.011	0.011–0.016	0.016–0.022	1×d	0.1×d
M2	V _c	20–35	20–35	20–35		
	f _z	0.002–0.010	0.010–0.015	0.015–0.020	1×d	0.1×d
K1	V _c	40–60	40–60	40–60		
	f _z	0.002–0.013	0.013–0.020	0.020–0.030	1×d	0.2×d
K2	V _c	35–55	35–55	35–55		
	f _z	0.002–0.012	0.012–0.018	0.018–0.025	1×d	0.2×d
N1	V _c					
	f _z					
N2	V _c	150–200	150–200	150–200		
	f _z	0.003–0.015	0.015–0.030	0.030–0.050	1×d	0.2×d
N3	V _c	150–200	150–200	150–200		
	f _z	0.002–0.013	0.013–0.020	0.020–0.030	1×d	0.1×d
N4	V _c					
	f _z					
N5	V _c	100–130	100–130	100–130		
	f _z	0.003–0.015	0.015–0.030	0.030–0.050	1×d	0.2×d
N6	V _c					
	f _z					
N7	V _c	120–150	120–150	120–150		
	f _z	0.003–0.015	0.015–0.030	0.030–0.050	1×d	0.2×d
N8	V _c	120–150	120–150	120–150		
	f _z	0.002–0.013	0.013–0.020	0.020–0.030	1×d	0.1×d
S1	V _c	30–50	30–50	30–50		
	f _z	0.002–0.012	0.012–0.018	0.018–0.025	1×d	0.2×d
S2	V _c					
	f _z					
H1	V _c					
	f _z					
H2	V _c					
	f _z					
H3	V _c					
	f _z					
O1	V _c	150–200	150–200	150–200		
	f _z	0.003–0.015	0.015–0.030	0.030–0.050	1×d	0.2×d
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.