

## Schnittdaten

## Données de coupe

## Parametri di lavoro

## Cutting data

### Art. 50941

Mat.	$\phi$ 0.50–0.90	$\phi$ 1.00–1.90	$\phi$ 2.00–3.00	
P1	Vc f	50–70 0.020–0.040	70–100 0.035–0.060	70–100 0.060–0.120
P2	Vc f	40–60 0.010–0.030	60–80 0.025–0.045	60–80 0.045–0.100
P3	Vc f	30–50 0.010–0.020	50–70 0.015–0.040	50–70 0.040–0.080
M1	Vc f	20–35 0.005–0.008	30–45 0.008–0.020	30–45 0.020–0.030
M2	Vc f	20–30 0.005–0.008	25–35 0.008–0.015	25–35 0.015–0.025
K1	Vc f	50–100 0.020–0.050	100–150 0.040–0.080	100–150 0.080–0.120
K2	Vc f	50–90 0.015–0.040	90–130 0.030–0.060	90–130 0.060–0.100
N1	Vc f			
N2	Vc f	60–120 0.020–0.040	120–150 0.040–0.080	120–150 0.080–0.120
N3	Vc f	80–120 0.020–0.040	130–170 0.040–0.080	130–170 0.080–0.120
N4	Vc f			
N5	Vc f			
N6	Vc f			
N7	Vc f			
N8	Vc f			
S1	Vc f	30–40 0.005–0.008	30–40 0.008–0.020	30–40 0.020–0.035
S2	Vc f			
H1	Vc f	10–20 0.003–0.006	15–30 0.005–0.015	15–30 0.015–0.020
H2	Vc f			
H3	Vc f			
O1	Vc f			
O2	Vc f			
O3	Vc f			

### Art. 52100 / 52200

Mat.	$\phi$ 3.00–4.00	$\phi$ 4.10–8.00	$\phi$ 8.10–12.00	$\phi$ 12.10–16.00	$\phi$ 16.10–20.00	
P1	Vc f					
P2	Vc f					
P3	Vc f					
M1	Vc f					
M2	Vc f					
K1	Vc f	60–110 0.040–0.060	60–110 0.050–0.200	60–110 0.160–0.300	60–110 0.280–0.400	60–110 0.380–0.500
K2	Vc f	50–100 0.020–0.050	50–100 0.040–0.160	50–100 0.140–0.250	50–100 0.220–0.350	50–100 0.320–0.400
N1	Vc f					
N2	Vc f	200–250 0.040–0.060	200–250 0.050–0.150	200–250 0.140–0.260	200–250 0.250–0.400	200–250 0.380–0.600
N3	Vc f	220–280 0.040–0.060	220–280 0.050–0.150	220–280 0.140–0.260	220–280 0.250–0.400	220–280 0.380–0.600
N4	Vc f					
N5	Vc f	80–120 0.040–0.060	80–120 0.050–0.150	80–120 0.140–0.250	80–120 0.230–0.330	80–120 0.300–0.400
N6	Vc f					
N7	Vc f					
N8	Vc f					
S1	Vc f					
S2	Vc f					
H1	Vc f					
H2	Vc f					
H3	Vc f					
O1	Vc f	20–40 0.030–0.050	20–40 0.040–0.100	20–40 0.080–0.150	20–40 0.130–0.180	20–40 0.160–0.200
O2	Vc f					
O3	Vc f					

Genannte Werte sind Richtwerte, die je nach Maschine, Aufspannung, Kühlenschmierstoff 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.