

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 f	20–30 0.050–0.100	20–30 0.080–0.130	20–30 0.120–0.180	20–30 0.170–0.230
P2	Vc f	15–25 0.040–0.080	15–25 0.070–0.120	15–25 0.110–0.170	15–25 0.160–0.220
P3	Vc f	10–20 0.035–0.070	10–20 0.060–0.100	10–20 0.090–0.150	10–20 0.130–0.180
M1	Vc f	10–20 0.040–0.080	10–20 0.070–0.120	10–20 0.110–0.170	10–20 0.160–0.220
M2	Vc f	10–15 0.035–0.070	10–15 0.060–0.100	10–15 0.090–0.150	10–15 0.130–0.180
K1	Vc f	20–30 0.050–0.100	20–30 0.080–0.150	20–30 0.140–0.220	20–30 0.200–0.260
K2	Vc f	15–25 0.050–0.090	15–25 0.750–0.140	15–25 0.130–0.200	15–25 0.180–0.240
N1	Vc f				
N2	Vc f	30–40 0.060–0.120	30–40 0.110–0.160	30–40 0.150–0.220	30–40 0.200–0.260
N3	Vc f	25–35 0.060–0.120	25–35 0.110–0.160	25–35 0.150–0.220	25–35 0.200–0.260
N4	Vc f	15–25 0.035–0.070	15–25 0.060–0.100	15–25 0.090–0.150	15–25 0.130–0.180
N5	Vc f	30–40 0.035–0.070	30–40 0.060–0.100	30–40 0.090–0.150	30–40 0.130–0.180
N6	Vc f				
N7	Vc f				
N8	Vc f				
S1	Vc f	10–15 0.035–0.070	10–15 0.060–0.100	10–15 0.090–0.150	10–15 0.130–0.180
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 Vf	180–280 80–180
P2	Vc Vf	180–280 70–160
P3	Vc Vf	180–280 70–150
M1	Vc Vf	180–280 70–150
M2	Vc Vf	180–280 70–150
K1	Vc Vf	180–280 80–180
K2	Vc Vf	180–280 70–160
N1	Vc Vf	180–280 60–140
N2	Vc Vf	180–280 80–180
N3	Vc Vf	180–280 70–160
N4	Vc Vf	180–280 60–120
N5	Vc Vf	180–280 80–200
N6	Vc Vf	180–280 60–150
N7	Vc Vf	180–280 80–200
N8	Vc Vf	180–280 80–200
S1	Vc Vf	180–280 50–120
S2	Vc Vf	
H1	Vc Vf	
H2	Vc Vf	
H3	Vc Vf	
O1	Vc Vf	180–280 80–200
O2	Vc Vf	
O3	Vc Vf	

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.