

Materialgruppen Material groups Groupes matières	P		H				M		K		N					
	Wenig legierter Stahl Low-alloyed steel Acier faible allié		Stahl 30-38HRC Steel 30-38HRC Acier 30-38HRC		Stahl 38-48 HRC Steel 38-48 HRC Acier 38-48 HRC		Edelstahl Stainless Steel Acier inoxydable		GGusseisen Cast Iron Fonte		Graphit Graphite Graphite		Aluminium Aluminium Aluminium		Hitzeresistenter Stahl Heat resistant steel Acier thermostable	
	60-120m/min		60-120m/min		40-70m/min		25-40m/min		60-120m/min		50-100m/min		60-140m/min		15-25m/min	
Vc "0 (mm)"	"n (min-1)"	"f (mm/r)"	"n (min-1)"	"f (mm/r)"	"n (min-1)"	"f (mm/r)"	"n (min-1)"	"f (mm/r)"	"n (min-1)"	"f (mm/r)"	"n (min-1)"	"f (mm/r)"	"n (min-1)"	"f (mm/r)"	"n (min-1)"	"f (mm/r)"
2	14000	"0.06-0.08"	14000	"0.06-0.08"	9500	"0.06-0.08"	5500	"0.02-0.05"	14000	"0.06-0.08"	11000	"0.06-0.08"	16000	"0.06-0.08"	3200	"0.02-0.04"
3	9500	"0.09-0.12"	9500	"0.09-0.12"	6300	"0.09-0.12"	3700	"0.03-0.07"	9500	"0.09-0.12"	7400	"0.09-0.12"	10600	"0.09-0.12"	2100	"0.03-0.06"
4	7000	"0.10-0.15"	7000	"0.10-0.15"	4700	"0.10-0.15"	2700	"0.04-0.08"	7000	"0.10-0.15"	5600	"0.10-0.15"	8000	"0.10-0.15"	1600	"0.04-0.07"
5	5700	"0.12-0.18"	5700	"0.12-0.18"	3800	"0.12-0.18"	2200	"0.05-0.10"	5700	"0.12-0.18"	4500	"0.12-0.18"	6400	"0.12-0.18"	1250	"0.05-0.09"
6	4700	"0.14-0.20"	4700	"0.14-0.20"	3100	"0.14-0.20"	1850	"0.06-0.12"	4700	"0.14-0.20"	3700	"0.14-0.20"	5300	"0.14-0.20"	1050	"0.06-0.11"
8	3600	"0.16-0.24"	3600	"0.16-0.24"	2400	"0.16-0.24"	1400	"0.08-0.16"	3600	"0.16-0.24"	2800	"0.16-0.24"	4000	"0.16-0.24"	800	"0.08-0.14"
10	2800	"0.18-0.27"	2800	"0.18-0.27"	1900	"0.18-0.27"	1100	"0.10-0.18"	2800	"0.18-0.27"	2200	"0.18-0.27"	3200	"0.18-0.27"	600	"0.10-0.16"
12	2400	"0.20-0.30"	2400	"0.20-0.30"	1600	"0.20-0.30"	930	"0.12-0.20"	2400	"0.20-0.30"	1900	"0.20-0.30"	2700	"0.20-0.30"	500	"0.12-0.18"
14	2100	"0.22-0.35"	2100	"0.22-0.35"	1400	"0.22-0.35"	800	"0.13-0.22"	2100	"0.22-0.35"	1600	"0.22-0.35"	2300	"0.22-0.35"	450	"0.13-0.20"
16	1800	"0.25-0.36"	1800	"0.25-0.36"	1200	"0.25-0.36"	700	"0.14-0.25"	1800	"0.25-0.36"	1400	"0.25-0.36"	2000	"0.25-0.36"	400	"0.14-0.23"
18	1600	"0.28-0.38"	1600	"0.28-0.38"	1100	"0.28-0.38"	620	"0.15-0.28"	1600	"0.28-0.38"	1200	"0.28-0.38"	1800	"0.28-0.38"	350	"0.15-0.25"
20	1400	"0.30-0.40"	1400	"0.30-0.40"	950	"0.30-0.40"	550	"0.16-0.30"	1400	"0.30-0.40"	1100	"0.30-0.40"	1600	"0.30-0.40"	320	"0.16-0.28"

1. Beim ersten Einsatz 90% der empfohlenen Schnittgeschwindigkeit oder 85% des Vorschubes wählen. Bei stabiler Bearbeitung die Schnitt-daten entsprechend erhöhen.
2. Die obigen Schnitt-datenempfehlungen basieren auf dem Einsatz von Emulsion.
3. Keine defekte Werkzeugaufnahme wählen. Die Rundlaufgenauigkeit muss unter 0,02mm liegen.
4. Die obigen Schnitt-daten sind für Bohrungstiefen unter 5xD ausgelegt.

1. When the tool is used for the first time, please make a test cutting with 90% of cutting speed or 85% feed rate mentioned above. If the cutting conditions remain stable, gradually increase the cutting speed and feed rate.
2. The cutting conditions above are for drilling with emulsion.
3. Use a collet without any defect or dust. The radial run-out of drill must be under 0.02mm.
4. These conditions above are for cutting depth under 5xD.

1. La première fois que vous utilisez sélectionner 90% de la vitesse de coupe recommandée ou 85% de l'alimentation. Avec stable traitement des données de coupe augmentent en conséquence.
2. Les recommandations de données de coupe ci-dessus sont basées sur l'utilisation de l'émulsion.
3. Ne composez jamais un porte-outil défectueux. La concentricité doit être inférieure à 0,02 mm.
4. Les données ci-dessus en coupe sont conçus pour des profondeurs de forage sous 5xD.