

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 thermorésistant	
	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)"
3	12700	"0.09-0.12"	12700	"0.09-0.12"	7400	"0.09-0.12"	6300	"0.03-0.07"	12700	"0.09-0.12"	9500	"0.09-0.12"	15000	"0.09-0.12"	2100	"0.03-0.06"
4	9600	"0.10-0.15"	9600	"0.10-0.15"	5600	"0.10-0.15"	4700	"0.04-0.08"	9600	"0.10-0.15"	7000	"0.10-0.15"	11100	"0.10-0.15"	1600	"0.04-0.07"
5	7600	"0.12-0.18"	7600	"0.12-0.18"	4500	"0.12-0.18"	3800	"0.05-0.10"	7600	"0.12-0.18"	5700	"0.12-0.18"	9000	"0.12-0.18"	1250	"0.05-0.09"
6	6400	"0.14-0.20"	6400	"0.14-0.20"	3700	"0.14-0.20"	3200	"0.06-0.12"	6400	"0.14-0.20"	4700	"0.14-0.20"	7400	"0.14-0.20"	1050	"0.06-0.11"
8	4800	"0.16-0.24"	4800	"0.16-0.24"	2800	"0.16-0.24"	2400	"0.08-0.16"	4800	"0.16-0.24"	3600	"0.16-0.24"	5600	"0.16-0.24"	800	"0.08-0.14"
10	3800	"0.18-0.27"	3800	"0.18-0.27"	2200	"0.18-0.27"	1900	"0.10-0.18"	3800	"0.18-0.27"	2800	"0.18-0.27"	4500	"0.18-0.27"	600	"0.10-0.16"
12	3200	"0.20-0.30"	3200	"0.20-0.30"	1900	"0.20-0.30"	1600	"0.12-0.20"	3200	"0.20-0.30"	2400	"0.20-0.30"	3700	"0.20-0.30"	500	"0.12-0.18"
14	2700	"0.22-0.35"	2700	"0.22-0.35"	1600	"0.22-0.35"	1350	"0.13-0.22"	2700	"0.22-0.35"	2100	"0.22-0.35"	3200	"0.22-0.35"	450	"0.13-0.20"
16	2400	"0.25-0.36"	2400	"0.25-0.36"	1400	"0.25-0.36"	1200	"0.14-0.25"	2400	"0.25-0.36"	1800	"0.25-0.36"	2800	"0.25-0.36"	400	"0.14-0.23"
18	2100	"0.28-0.38"	2100	"0.28-0.38"	1200	"0.28-0.38"	1050	"0.15-0.28"	2100	"0.28-0.38"	1600	"0.28-0.38"	2500	"0.28-0.38"	350	"0.15-0.25"
20	1900	"0.30-0.40"	1900	"0.30-0.40"	1100	"0.30-0.40"	950	"0.16-0.30"	1900	"0.30-0.40"	1400	"0.30-0.40"	2300	"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 Schnittdaten entsprechend erhöhen.
2. Die obigen Schnittdatenempfehlungen basieren auf dem Einsatz von Emulsion.
3. Keine defekte Werkzeugaufnahme wählen. Die Rundlaufgenauigkeit muss unter 0,02mm liegen.
4. Die obigen Schnittdaten 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.