

# Conditions de coupe DGR...IK

Parametro di taglio DGR...IK



|      |  |  |
|------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|
|      | vc = m/min                                                                        | vc = m/min                                                                        |
| P1.1 | 130                                                                               | 150                                                                               |
| P1.2 | 130                                                                               | 150                                                                               |
| P1.3 | 130                                                                               | 150                                                                               |
| P1.4 | 130                                                                               | 150                                                                               |
| P1.5 | 130                                                                               | 150                                                                               |
| P1.6 | 140                                                                               | 160                                                                               |
| P2.1 | 130                                                                               | 150                                                                               |
| P2.2 | 130                                                                               | 150                                                                               |
| P2.3 | 130                                                                               | 150                                                                               |
| P2.4 | 130                                                                               | 150                                                                               |
| P3.1 | 120                                                                               | 140                                                                               |
| P3.2 | 110                                                                               | 130                                                                               |
| P4.1 | 120                                                                               | 140                                                                               |
| P4.2 | 120                                                                               | 140                                                                               |
| P5.1 | 110                                                                               | 130                                                                               |

|      |  |  |
|------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|
|      | vc = m/min                                                                          | vc = m/min                                                                          |
| M1.1 | 90                                                                                  | 110                                                                                 |
| M1.2 | 70                                                                                  | 90                                                                                  |
| M1.3 | 60                                                                                  | 80                                                                                  |
| K1.1 | 130                                                                                 | 150                                                                                 |
| K1.2 | 130                                                                                 | 150                                                                                 |
| K2.1 | 120                                                                                 | 140                                                                                 |
| K2.2 | 110                                                                                 | 130                                                                                 |
| K3.1 | 110                                                                                 | 130                                                                                 |
| K3.2 | 110                                                                                 | 130                                                                                 |
| K4.1 | 100                                                                                 | 120                                                                                 |
| K4.2 | 90                                                                                  | 110                                                                                 |
| K4.3 | 90                                                                                  | 110                                                                                 |
| S1.1 | 90                                                                                  | 110                                                                                 |
| S1.2 | 80                                                                                  | 100                                                                                 |
| S2.1 | 60                                                                                  | 80                                                                                  |
| S2.2 | 50                                                                                  | 70                                                                                  |

| d <sub>1</sub> |  |  |                |                |  |                |                |
|----------------|------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|----------------|----------------|-----------------------------------------------------------------------------------|----------------|----------------|
|                | $\alpha$                                                                           | f <sub>z</sub>                                                                    | a <sub>e</sub> | a <sub>p</sub> | f <sub>z</sub>                                                                    | a <sub>e</sub> | a <sub>p</sub> |
| 10             | 5°                                                                                 | 0,05                                                                              | 10             | 5              | 0,07                                                                              | 4              | 5              |
| 10             | 5°                                                                                 | 0,05                                                                              | 10             | 5              | 0,07                                                                              | 4              | 5              |
| 10             | 4°                                                                                 | 0,05                                                                              | 10             | 5              | 0,06                                                                              | 4              | 5              |
| 10             | 4°                                                                                 | 0,05                                                                              | 10             | 5              | 0,06                                                                              | 4              | 5              |
| 12             | 5°                                                                                 | 0,06                                                                              | 12             | 6              | 0,09                                                                              | 5              | 6              |
| 16             | 3°                                                                                 | 0,08                                                                              | 16             | 8              | 0,11                                                                              | 6              | 8              |
| 16             | 3°                                                                                 | 0,08                                                                              | 16             | 8              | 0,11                                                                              | 6              | 8              |

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