

# TURN-Line

Paramètres de coupe indicatifs

Empfohlene Schnittwerte

Standard machining data

Matière Werkstoff Material	Tournage Drehen Turning		
	VC	Prof. de passe Schnitttiefe Depth of cut	Avance Vorschub Feed
	(m/min)	(mm)	(mm/U)
Acier de décolletage Automatenstahl Free-cutting steel <b>P</b>	120 - 200	0.05 - 1.0 1.0 - 4.0	0.01 - 0.15 0.05 - 0.25
Acier Stahl Steel < 600 N/mm <sup>2</sup> <b>P</b>	80 - 160	0.05 - 1.0 1.0 - 4.0	0.01 - 0.15 0.05 - 0.25
Acier Stahl Steel < 800 N/mm <sup>2</sup> <b>P</b>	60 - 120	0.05 - 1.0 1.0 - 4.0	0.01 - 0.10 0.05 - 0.20
Acier Stahl Steel > 800 N/mm <sup>2</sup> <b>P</b>	50 - 100	0.05 - 1.0 1.0 - 3.0	0.01 - 0.08 0.05 - 0.15
Acier inoxydable Rostfreistahl Stainless steel <b>M</b>	60 - 120	0.05 - 1.0 1.0 - 3.0	0.01 - 0.08 0.05 - 0.15
Aluminium Si <12% <b>N</b>	200 - 1000	0.05 - 1.0 1.0 - 4.0	0.01 - 0.20 0.05 - 0.40
Aluminium Si >12% <b>N</b>	180 - 800	0.05 - 1.0 1.0 - 4.0	0.01 - 0.20 0.05 - 0.40
Cuivre, laiton, bronze Kupfer, Messing, Bronze Copper, brass, bronze <b>N</b>	100 - 500	0.05 - 1.0 1.0 - 4.0	0.01 - 0.20 0.05 - 0.35
Titane Titan Titanium <b>S</b>	30 - 70	0.05 - 1.0 1.0 - 4.0	0.01 - 0.08 0.05 - 0.15