Paramètres de coupe indicatifs
Empfohlene Schnittwerte
Standard machining data

Matière Werkstoff Material			Tournage Drehen Turning VC (m/min)	Prof. de passe Schnitttiefe Depth of cut (mm)	Avance Vorschub Feed (mm/U)
Acier de décolletage Automatenstahl Free-cutting steel		P	120 - 200	0.05 - 1.0 1.0 - 4.0	0.01 - 0.15 0.05 - 0.25
Acier Stahl Steel	< 600 N/mm²	P	80 - 160	0.05 - 1.0 1.0 - 4.0	0.01 - 0.15 0.05 - 0.25
Acier Stahl Steel	< 800 N/mm²	P	60 - 120	0.05 - 1.0 1.0 - 4.0	0.01 - 0.10 0.05 - 0.20
Acier Stahl Steel	> 800 N/mm²	P	50 - 100	0.05 - 1.0 1.0 - 3.0	0.01 - 0.08 0.05 - 0.15
Acier inoxydable Rostfreistahl Stainless steel		M	60 - 120	0.05 - 1.0 1.0 - 3.0	0.01 - 0.08 0.05 - 0.15
Aluminium Si <12%		N	200 - 1000	0.05 - 1.0 1.0 - 4.0	0.01 - 0.20 0.05 - 0.40
Aluminium Si >12%		N	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		N	100 - 500	0.05 - 1.0 1.0 - 4.0	0.01 - 0.20 0.05 - 0.35
Titane Titan Titanium		S	30 - 70	0.05 - 1.0 1.0 - 4.0	0.01 - 0.08 0.05 - 0.15