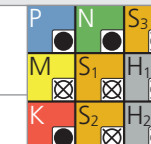


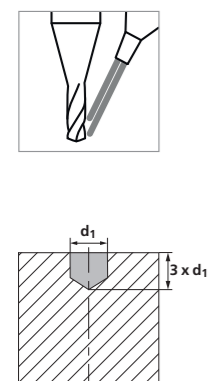
# Steel - 3 x d - revêtu / non revêtu

RECOMMANDATION D'UTILISATION

● Parfaitement recommandé | ● Recommandé | ○ Peu recommandé | ⊗ Non recommandé



## PERÇAGE AVEC REFROIDISSEMENT EXTERNE | VUE D'ENSEMBLE DES DONNÉES DE COUPE



Groupe matériaux	Matériau	Mat. no.	DIN	AISI/ASTM/UNS	v <sub>c</sub> [m/min]		f [mm/tour]																		
					Ød1 ≤ 0.4	Ød1 > 0.4	Ød <sub>1</sub>																		
							0.1 mm f	0.2 mm f	0.3 mm f	0.4 mm 1/64" f	0.6 mm f	0.8 mm 1/32" f	1.0 mm-1.2 mm f	1.5 mm-2.0 mm 1/16" f											
P	Aciers non alliés Rm < 800 N/mm²	1.0301	C10	AISI 1010	5 - 40	40 - 60	0.002	0.005	0.010	0.015	0.030	0.040	0.060	0.080											
		1.0401	C15	AISI 1015																					
		1.1191	C45E/CK45	AISI 1045																					
		1.0044	S275JR	AISI 1020																					
		1.0715	11SMn30	AISI 1215																					
		1.5752	15NiCr13	ASTM 3415 / AISI 3310																					
	Aciers faiblement alliés Rm > 900 N/mm²	1.7131	16MnCr5	AISI 5115	5 - 25	25 - 50	0.002	0.003 - 0.005	0.008 - 0.010	0.012 - 0.015	0.020 - 0.025	0.035	0.050	0.070											
		1.3505	100Cr6	AISI 52100																					
		1.7225	42CrMo4	AISI 4140																					
		1.2842	90MnCrV8	AISI O2																					
		1.2379	X153CrMoV12	AISI D2																					
		1.2436	X210CrW12	AISI D4/D6																					
Aciers à outil fortement alliés Rm < 1200 N/mm²	1.3343	HS6-5-2C	AISI M2 / UNS T11302	5 - 20	20 - 35	0.0005	0.004	0.008	0.010	0.015	0.025	0.040	0.060												
	1.3355	HS18-0-1	AISI T1 / UNS T12001																						
	Aciers inoxydables ferritiques	1.4016	X6Cr17											AISI 430 / UNS S43000											
		1.4105	X6CrMoS17											AISI 430F											
		1.4034	X46Cr13											AISI 420C											
		1.4112	X90CrMoV18											AISI 440B											
1.4542		X5CrNiCuNb 16-4	AISI 630 / ASTM 17-4 PH																						
1.4545		X5CrNiCuNb 15-5	ASTM 15-5 PH																						
Aciers inoxydables martensitiques	1.4301	X5CrNi 18-10	AISI 304																						
	1.4435	X2CrNiMo 18-14-3	AISI 316L																						
	1.4441	X2CrNiMo 18-15-3	AISI 316LM																						
	1.4539	X1NiCrMoCu 25-20-5	AISI 904L																						
	Aciers inoxydables austénitiques	1.4301	X5CrNi 18-10											AISI 304											
		1.4435	X2CrNiMo 18-14-3											AISI 316L											
1.4441		X2CrNiMo 18-15-3	AISI 316LM																						
1.4539		X1NiCrMoCu 25-20-5	AISI 904L																						
K		Fonte grise	0.6020	GG20	ASTM 30	5 - 40	50 - 100	0.002	0.005	0.010	0.015	0.020	0.035	0.050											0.070
			0.6030	GG30	ASTM 40B																				
	0.7040		GGG40	ASTM 60-40-18																					
	0.7060		GGG60	ASTM 80-60-03																					
	0.7060		GGG60	ASTM 80-60-03																					
N	Alliages d'aluminium corroyés	3.2315	AlMgSi1	ASTM 6351	5 - 40	60 - 120	0.003	0.015	0.040	0.050	0.080	0.100	0.120	0.150											
		3.4365	AlZnMgCu1.5	ASTM 7075																					
	Fonte d'aluminium	3.2163	GD-AlSi9Cu3	ASTM A380	5 - 40	50 - 80	0.003	0.015	0.040	0.050	0.080	0.100	0.120	0.150											
		3.2381	GD-AlSi10Mg	UNS A03590																					
	Cuivre	2.0040	Cu-OF / CW008A	UNS C10100																					
		2.0065	Cu-ETP / CW004A	UNS C11000																					
	Laiton sans plomb	2.0321	CuZn37 CW508L	UNS C27400																					
		2.0360	CuZn40 CW509L	UNS C28000																					
	Laiton, Bronze Rm < 400 N/mm²	2.0401	CuZn39Pb3 / CW614N	UNS C38500	5 - 40	60 - 100	0.004	0.010	0.030	0.040	0.060	0.080	0.100	0.120											
		2.1020	CuSn6	UNS C51900																					
	Bronze Rm < 600 N/mm²	2.0966	CuAl10Ni5Fe4	UNS C63000	5 - 20	20 - 40	0.002	0.004	0.006	0.010	0.015	0.025	0.040	0.060											
		2.0960	CuAl9Mn2	UNS C63200																					
S <sub>1</sub>	Super alliages	2.4856		Inconel 625																					
		2.4668		Inconel 718																					
		2.4617	NiMo28	Hastelloy B-2																					
		2.4665	NiCr22Fe18Mo	Hastelloy X																					
S <sub>2</sub>	Titane pur	3.7035	Gr.2	ASTM B348 / F67																					
		3.7065	Gr.4	ASTM B348 / F68																					
S <sub>3</sub>	Alliages de titane	3.7165	TiAl6V4	ASTM B348 / F136																					
		9.9367	TiAl6Nb7	ASTM F1295																					
H <sub>1</sub>	Aciers trempés < 55 HRC	1.2510	100MnCrMoW4	AISI O1																					
		2.4964	CoCr20W15Ni	Haynes 25																					
H <sub>2</sub>	Aciers trempés ≥ 55 HRC	2.4964	CrCoMo28	ASTM F1537																					
		1.2379	X153CrMoV12	AISI D2																					