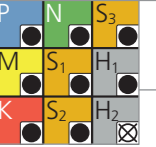


Type A - Rainurage classique

v_c [m/min]
 f_z [mm]

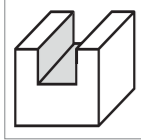
RECOMMANDATION D'UTILISATION

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

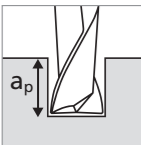
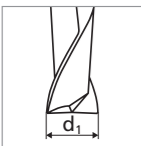
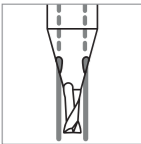


FRAISAGE AVEC REFOROIDISSEMENT INTÉGRÉ | VUE D'ENSEMBLE DES DONNÉES DE COUPE

Rainurage classique



$a_p = 1 \times d_1$



Groupe matériaux	Matériau	Mat. no.	DIN	AISI/ASTM/UNS	Ød1															
					0.3 mm–0.4 mm 1/64"		0.5 mm–0.8 mm 1/32"		1.0 mm–1.2 mm		1.5 mm–1.8 mm 1/16"		2.0 mm–2.5 mm 3/32"		3.0 mm 1/8"		4.0 mm–6.0 mm 5/32–3/16–7/32–1/4"			
					v_c	f_z	v_c	f_z	v_c	f_z	v_c	f_z	v_c	f_z	v_c	f_z	v_c	f_z		
P	Aciers non alliés Rm < 800 N/mm ²	1.0301	C10	AISI 1010	60	0.004–0.006			100	0.008–0.012	140	0.013–0.015	180	0.022–0.024	200	0.030–0.032	220	0.046	260	0.048
		1.0401	C15	AISI 1015																
		1.1191	C45E/CK45	AISI 1045																
		1.0044	S275JR	AISI 1020																
		1.0715	11SMn30	AISI 1215																
	Aciers faiblement alliés Rm > 900 N/mm ²	1.5752	15NiCr13	ASTM 3415 / AISI 3310	60	0.003–0.005			100	0.007–0.010	140	0.012–0.014	180	0.020–0.022	200	0.028–0.030	220	0.044	260	0.046
		1.7131	16MnCr5	AISI 5115																
		1.3505	100Cr6	AISI 52100																
		1.7225	42CrMo4	AISI 4140																
		1.2842	90MnCrV8	AISI O2																
	Aciers à outil fortement alliés Rm < 1200 N/mm ²	1.2379	X153CrMoV12	AISI D2	60	0.003–0.005			100	0.006–0.009	140	0.009–0.011	180	0.018–0.020	200	0.026–0.028	220	0.040	260	0.042
		1.2436	X210CrW12	AISI D4/D6																
1.3343		HS6-5-2C	AISI M2 / UNS T11302																	
1.3355		HS18-0-1	AISI T1 / UNS T12001																	
M	Aciers inoxydables ferritiques	1.4016	X6Cr17	AISI 430 / UNS S43000	60	0.004–0.006			100	0.008–0.012	140	0.014–0.016	180	0.022–0.024	200	0.030–0.032	220	0.044	260	0.046
		1.4105	X6CrMoS17	AISI 430F																
		1.4034	X46Cr13	AISI 420C																
	Aciers inoxydables martensitiques	1.4112	X90CrMoV18	AISI 440B	60	0.003–0.005			100	0.007–0.010	140	0.013–0.015	180	0.020–0.022	200	0.028–0.030	220	0.042	260	0.044
		1.4542	X5CrNiCuNb 16-4	AISI 630 / ASTM 17-4 PH																
		1.4545	X5CrNiCuNb 15-5	ASTM 15-5 PH																
	Aciers inoxydables martensitiques - PH	1.4301	X5CrNi 18-10	AISI 304	60	0.003–0.005			100	0.007–0.010	140	0.013–0.015	180	0.020–0.022	200	0.028–0.030	220	0.042	260	0.044
		1.4435	X2CrNiMo 18-14-3	AISI 316L																
Aciers inoxydables austénitiques	1.4441	X2CrNiMo 18-15-3	AISI 316LM	60	0.003–0.005			100	0.006–0.009	140	0.010–0.012	180	0.016–0.018	200	0.026–0.028	220	0.040	260	0.042	
	1.4539	X1NiCrMoCu 25-20-5	AISI 904L																	
	0.6020	GG20	ASTM 30																	
K	Fonte grise	0.6030	GG30	ASTM 40B	60	0.002–0.004			100	0.005–0.008	120	0.010–0.020	140	0.022–0.025	160	0.026–0.035	180	0.040–0.046	200	0.050–0.054
		0.7040	GG40	ASTM 60-40-18																
		0.7060	GGG60	ASTM 80-60-03																
		2.2315	AlMgSi1	ASTM 6351																
N	Alliages d'aluminium corroyés	3.4365	AlZnMgCu1.5	ASTM 7075	60	0.005–0.007			100	0.010–0.014	140	0.015–0.017	180	0.024–0.026	200	0.032–0.034	220	0.052	260	0.055
		3.2163	GD-AISI9Cu3	ASTM A380																
	Fonte d'aluminium	3.2381	GD-AISI10Mg	UNS A03590	60	0.005–0.007			100	0.010–0.014	140	0.015–0.017	180	0.024–0.026	200	0.032–0.034	220	0.050	260	0.053
		2.004	Cu-OF / CW008A	UNS C10100																
	Cuivre	2.0065	Cu-ETP / CW004A	UNS C11000	60	0.005–0.007			100	0.012–0.016	140	0.018–0.020	180	0.024–0.026	200	0.032–0.034	220	0.052	260	0.055
		2.0321	CuZn37 CW508L	UNS C27400																
	Laiton sans plomb	2.036	CuZn40 CW509L	UNS C28000	60	0.005–0.007			100	0.012–0.016	140	0.018–0.020	180	0.024–0.026	200	0.032–0.034	220	0.052	260	0.055
		2.0401	CuZn39Pb3 / CW614N	UNS C38500																
	Laiton, Bronze Rm < 400 N/mm ²	2.102	CuSn6	UNS C51900	60	0.005–0.007			100	0.012–0.016	140	0.018–0.020	180	0.024–0.026	200	0.032–0.034	220	0.052	260	0.055
		2.0966	CuAl10Ni5Fe4	UNS C63000																
	Bronze Rm < 600 N/mm ²	2.096	CuAl9Mn2	UNS C63200	60	0.005–0.007			100	0.010–0.014	140	0.016–0.018	180	0.024–0.026	200	0.032–0.034	220	0.052	260	0.055
		2.4856		Inconel 625																
S₁	Super alliages	2.4668		Inconel 718	60	0.002–0.003			100	0.004–0.006	120	0.007–0.008	130	0.009–0.010	140	0.010–0.012	150	0.015	170	0.020
		2.4617	NiMo28	Hastelloy B-2																
		2.4665	NiCr22Fe18Mo	Hastelloy X																
		3.7035	Gr.2	ASTM B348 / F67																
S₂	Titane pur	3.7065	Gr.4	ASTM B348 / F68	60	0.003–0.005			100	0.006–0.009	120	0.014–0.016	130	0.018–0.020	140	0.026–0.028	150	0.040	170	0.042
		3.7165	TiAl6V4	ASTM B348 / F136																
S₃	Alliages de titane	9.9367	TiAl6Nb7	ASTM F1295	60	0.003–0.005			100	0.006–0.009	120	0.014–0.016	130	0.018–0.020	140	0.026–0.028	150	0.040	170	0.042
		2.4964	CoCr20W15Ni CrCoMo28	Haynes 25 ASTM F1537																
H₁ H₂	Aciers trempés ≥ 55 HRC	1.2510	100MnCrMoW4	AISI O1	60	0.003–0.005			80	0.006–0.007	100	0.008–0.010	140	0.012–0.016	180	0.018–0.024	200	0.030	240	0.035
		1.2379	X153CrMoV12	AISI D2																