

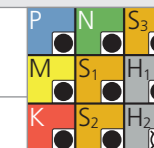
**NEW**

# Type B - Semi-finition

$v_c$  [m/min]  
 $f_z$  [mm]

RECOMMANDATION D'UTILISATION

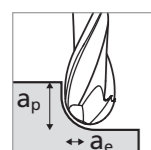
● Parfaitement recommandé | ● Recommandé | ○ Peu recommandé | ⊗ Non recommandé



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

**Possibilité 1**

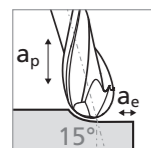
Inclinaison 0°



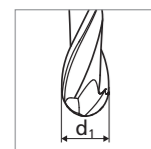
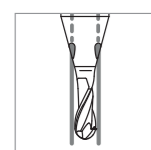
■  $a_p = 1 \times d_1$   
■  $a_e = 0.2 \times d_1$

**Possibilité 2**

Inclinaison 15°



■  $a_p = 0.5 \times d_1$   
■  $a_e = 0.2 \times d_1$



Groupe matériaux	Matériau	Mat. no.	DIN	AISI/ASTM/UNS	1.0 mm		1.2 mm		1.5 mm 1/16"		1.8 mm		Ød1 2.0 mm		2.5 mm 3/32"		3.0 mm 1/8"		4.0 mm 5/32"		5.0 mm 3/16"		6.0 mm-8.0 mm 7/32-1/4"																						
					$v_c$	$f_z$	$v_c$	$f_z$	$v_c$	$f_z$	$v_c$	$f_z$	$v_c$	$f_z$	$v_c$	$f_z$	$v_c$	$f_z$	$v_c$	$f_z$	$v_c$	$f_z$	$v_c$	$f_z$	$v_c$	$f_z$																			
					<b>P</b>	Aciers non alliés Rm < 800 N/mm²  Aciers faiblement alliés Rm > 900 N/mm²  Aciers à outil fortement alliés Rm < 1200 N/mm²	1.0301	C10	AISI 1010	140	0.013	140	0.014	200	0.020	200	0.022	220	0.029	220	0.031	240	0.037	260	0.040	260	0.040	260	0.043																
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																																											
1.7131	16MnCr5	AISI 5115																																											
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																																											
1.3343	HS6-5-2C	AISI M2 / UNS T11302																																											
1.3355	HS18-0-1	AISI T1 / UNS T12001																																											
<b>M</b>	Aciers inoxydables ferritiques Aciers inoxydables martensitiques Aciers inoxydables martensitiques - PH Aciers inoxydables austénitiques	1.4016	X6Cr17	AISI 430 / UNS S43000	140	0.014	140	0.015	200	0.020	200	0.022	220	0.029	220	0.031	240	0.035	260	0.038	260	0.038	260	0.041																					
1.4105		X6CrMoS17	AISI 430F																																										
1.4034		X46Cr13	AISI 420C																																										
1.4112		X90CrMoV18	AISI 440B																																										
1.4542		X5CrNiCuNb16-4	AISI 630 / ASTM 17-4 PH																																										
1.4545		X5CrNiCuNb15-5	ASTM 15-5 PH																																										
1.4301		X5CrNi18-10	AISI 304																																										
1.4435		X2CrNiMo18-14-3	AISI 316L																																										
1.4441		X2CrNiMo18-15-3	AISI 316LM																																										
1.4539		X1NiCrMoCu25-20-5	AISI 904L																																										
<b>K</b>		Fonte grise	0.6020	GG20																					ASTM 30	120	0.009	120	0.019	140	0.020	140	0.022	160	0.024	160	0.031	180	0.034	200	0.040	200	0.042	200	0.044
0.6030			GG30	ASTM 40B																																									
0.7040	GGG40		ASTM 60-40-18																																										
0.7060	GGG60		ASTM 80-60-03																																										
<b>N</b>	Alliages d'aluminium corroyés Fonte d'aluminium Cuivre Laiton sans plomb Laiton, Bronze Rm < 400 N/mm² Bronze Rm < 600 N/mm²		3.2315	AlMgSi1	ASTM 6351	140	0.015	140	0.017	200	0.022	200	0.024	220	0.031	220	0.034	240	0.046	260	0.048	260	0.048	260	0.051																				
3.4365		AlZnMgCu1.5	ASTM 7075																																										
3.2163		GD-AlSi9Cu3	ASTM A380																																										
3.2381		GD-AlSi10Mg	UNS A03590																																										
2.0040		Cu-OF / CW008A	UNS C10100																																										
2.0065		Cu-ETP / CW004A	UNS C11000																																										
2.0321		CuZn37 CW508L	UNS C27400																																										
2.0360		CuZn40 CW509L	UNS C28000																																										
2.0401		CuZn39Pb3 / CW614N	UNS C38500																																										
2.1020		CuSn6	UNS C51900																																										
2.0966		CuAl10Ni5Fe4	UNS C63000																																										
2.0960		CuAl9Mn2	UNS C63200																																										
<b>S1</b>	Superalliages	2.4856		Inconel 625	120	0.006	120	0.007	130	0.008	130	0.009	140	0.009	140	0.010	150	0.012	170	0.016	170	0.016	170	0.017																					
2.4668			Inconel 718																																										
2.4617		NiMo28	Hastelloy B-2																																										
2.4665		NiCr22Fe18Mo	Hastelloy X																																										
<b>S2</b>	Titane pur Alliages de titane	3.7035	Gr.2	ASTM B348 / F67	120	0.014	120	0.015	130	0.017	130	0.019	140	0.024	140	0.026	150	0.032	170	0.035	170	0.035	170	0.037																					
3.7065		Gr.4	ASTM B348 / F68																																										
3.7165		TiAl6V4	ASTM B348 / F136																																										
9.9367	TiAl6Nb7	ASTM F1295																																											
<b>S3</b>	Alliages CrCo	2.4964	CoCr20W15Ni	Haynes 25	140	0.006	140	0.007	180	0.008	180	0.009	200	0.009	200	0.010	220	0.012	240	0.016	240	0.016	240	0.017																					
		CrCoMo28	ASTM F1537																																										
<b>H1</b>	Aciers trempés < 55 HRC	1.2510	100MnCrMoW4	AISI O1	100	0.009	100	0.010	140	0.012	140	0.015	180	0.017	180	0.022	200	0.026	240	0.032	240	0.032	240	0.034																					
<b>H2</b>	Aciers trempés ≥ 55 HRC	1.2379	X153CrMoV12	AISI D2																																									