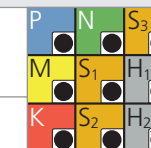


NEW Type C - Semi-finition

v_c [m/min]
 f_z [mm]

RECOMMANDATION D'UTILISATION

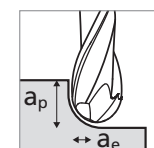
● Parfaitement recommandé | ● Recommandé | ○ Peu recommandé | ☒ Non recommandé



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

Possibilité 1

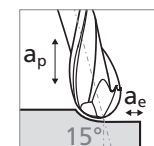
Inclinaison 0°



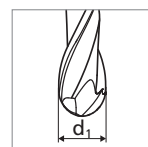
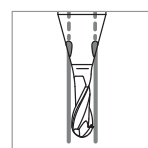
■ $a_p = 0.5 \times d_1$
■ $a_e = 0.2 \times d_1$

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
P	Aciers non alliés Rm < 800 N/mm²	1.0301	C10	AISI 1010																					
		1.0401	C15	AISI 1015																					
		1.1191	C45E/CK45	AISI 1045		140	0.013	140	0.014																
		1.0044	S275JR	AISI 1020																					
		1.0715	11SMn30	AISI 1215																					
	Aciers faiblement alliés Rm > 900 N/mm²	1.5752	15NiCr13	ASTM 3415 / AISI 3310																					
		1.7131	16MnCr5	AISI 5115																					
		1.3505	100Cr6	AISI 52100		140	0.012	140	0.014																
		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		140	0.009	140	0.011																	
	1.3355	HS18-0-1	AISI T1 / UNS T12001																						
M	Aciers inoxydables ferritiques	1.4016	X6Cr17	AISI 430 / UNS S43000		140	0.014	140	0.015																
		1.4105	X6CrMoS17	AISI 430F																					
	Aciers inoxydables martensitiques	1.4034	X46Cr13	AISI 420C		140	0.013	140	0.014																
		1.4112	X90CrMoV18	AISI 440B																					
	Aciers inoxydables martensitiques - PH	1.4542	X5CrNiCuNb16-4	AISI 630 / ASTM 17-4 PH		140	0.013	140	0.014																
		1.4545	X5CrNiCuNb15-5	ASTM 15-5 PH																					
	Aciers inoxydables austénitiques	1.4301	X5CrNi18-10	AISI 304																					
		1.4435	X2CrNiMo18-14-3	AISI 316L		140	0.010	140	0.012																
1.4441		X2CrNiMo18-15-3	AISI 316LM																						
1.4539	X1NiCrMoCu25-20-5	AISI 904L																							
K	Fonte grise	0.6020	GG20	ASTM 30																					
		0.6030	GG30	ASTM 40B																					
		0.7040	GGG40	ASTM 60-40-18		120	0.009	120	0.019																
		0.7060	GGG60	ASTM 80-60-03																					
N	Alliages d'aluminium corroyés	3.2315	AlMgSi1	ASTM 6351		140	0.015	140	0.017																
		3.4365	AlZnMgCu1.5	ASTM 7075																					
	Fonte d'aluminium	3.2163	GD-AlSi9Cu3	ASTM A380		140	0.015	140	0.017																
		3.2381	GD-AlSi10Mg	UNS A03590																					
	Cuivre	2.0040	Cu-OF / CW008A	UNS C10100		140	0.017	140	0.019																
		2.0065	Cu-ETP / CW004A	UNS C11000																					
	Laiton sans plomb	2.0321	CuZn37 CW508L	UNS C27400		140	0.017	140	0.019																
		2.0360	CuZn40 CW509L	UNS C28000																					
	Laiton, Bronze Rm < 400 N/mm²	2.0401	CuZn39Pb3 / CW614N	UNS C38500		140	0.017	140	0.019																
		2.1020	CuSn6	UNS C51900																					
Bronze Rm < 600 N/mm²	2.0966	CuAl10Ni5Fe4	UNS C63000		140	0.015	140	0.017																	
	2.0960	CuAl9Mn2	UNS C63200																						
S1	Superalliages	2.4856		Inconel 625																					
		2.4668		Inconel 718																					
		2.4617	NiMo28	Hastelloy B-2		120	0.006	120	0.007																
		2.4665	NiCr22Fe18Mo	Hastelloy X																					
S2	Titane pur	3.7035	Gr.2	ASTM B348 / F67		120	0.014	120	0.015																
		3.7065	Gr.4	ASTM B348 / F68																					
S3	Alliages de titane	3.7165	TiAl6V4	ASTM B348 / F136		120	0.014	120	0.015																
		9.9367	TiAl6Nb7	ASTM F1295																					
H1	Aciers trempés < 55 HRC	2.4964	CoCr20W15Ni	Haynes 25		140	0.006	140	0.007																
			CrCoMo28	ASTM F1537																					
H2	Aciers trempés ≥ 55 HRC	1.2510	100MnCrMoW4	AISI O1		100	0.009	100	0.010																
		1.2379	X153CrMoV12	AISI D2																					