

NEW

Type M - Finition

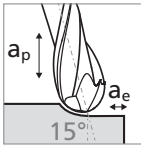
v_c [m/min]
 f_z [mm]

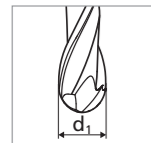
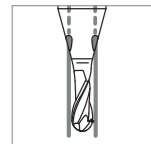
RECOMMANDATION D'UTILISATION

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

P	N	S ₃
M	S ₁	H ₁
K	S ₂	H ₂

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

Inclinaison 15°

 $a_p = 0.1 \times d$
 $a_e = 0.05 - 0.1 \times d$
 $n_{max} = 60'000$ rpm



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
P	Aciers non alliés Rm < 800 N/mm ²	1.0301	C10	AISI 1010																						
		1.0401	C15	AISI 1015																						
		1.1191	C45E/CK45	AISI 1045		140	0.015	140	0.017																	
		1.0044	S275JR	AISI 1020																						
		1.0715	11Mn30	AISI 1215																						
	Aciers faiblement alliés Rm > 900 N/mm ²	1.5752	15NiCr13	ASTM 3415 / AISI 3310																						
		1.7131	16MnCr5	AISI 5115																						
		1.3505	100Cr6	AISI 52100		140	0.014	140	0.016																	
		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																						
		1.2436	X210CrW12	AISI D4/D6																						
1.3343		HS6-5-2C	AISI M2 / UNS T11302		140	0.011	140	0.013																		
1.3355		HS18-0-1	AISI T1 / UNS T12001																							
1.4016		X6Cr17	AISI 430 / UNS S43000		140	0.016	140	0.018																		
1.4105		X6CrMoS17	AISI 430F																							
1.4034		X46Cr13	AISI 420C		140	0.015	140	0.017																		
Aciers inoxydables martensitiques - PH	1.4112	X90CrMoV18	AISI 440B																							
	1.4542	X5CrNiCuNb16-4	AISI 630 / ASTM 17-4 PH		140	0.015	140	0.017																		
	1.4545	X5CrNiCuNb15-5	ASTM 15-5 PH																							
	1.4301	X5CrNi18-10	AISI 304																							
	1.4435	X2CrNiMo18-14-3	AISI 316L		140	0.012	140	0.014																		
Aciers inoxydables austénitiques	1.4441	X2CrNiMo18-15-3	AISI 316LM																							
	1.4539	X1NiCrMoCu25-20-5	AISI 904L																							
	Fonte grise	0.6020	GG20	ASTM 30																						
		0.6030	GG30	ASTM 40B																						
0.7040		GGG40	ASTM 60-40-18		120	0.011	120	0.022																		
0.7060		GGG60	ASTM 80-60-03																							
N	Alliages d'aluminium corroyés	3.2315	AlMgSi1	ASTM 6351																						
		3.4365	AlZnMgCu1.5	ASTM 7075		140	0.018	140	0.020																	
	Fonte d'aluminium	3.2163	GD-AlSi9Cu3	ASTM A380																						
		3.2381	GD-AlSi10Mg	UNS A03590		140	0.018	140	0.020																	
	Cuivre	2.0040	Cu-OF / CW008A	UNS C10100																						
		2.0065	Cu-ETP / CW004A	UNS C11000		140	0.020	140	0.022																	
	Laiton sans plomb	2.0321	CuZn37 CW508L	UNS C27400																						
		2.0360	CuZn40 CW509L	UNS C28000		140	0.020	140	0.022																	
	Laiton, Bronze Rm < 400 N/mm ²	2.0401	CuZn39Pb3 / CW614N	UNS C38500																						
		2.1020	CuSn6	UNS C51900		140	0.020	140	0.022																	
	Bronze Rm < 600 N/mm ²	2.0966	CuAl10Ni5Fe4	UNS C63000																						
		2.0960	CuAl9Mn2	UNS C63200		140	0.018	140	0.020																	
S ₁	Superalliages	2.4856		Inconel 625																						
		2.4668		Inconel 718																						
		2.4617	NiMo28	Hastelloy B-2		120	0.007	120	0.008																	
		2.4665	NiCr22Fe18Mo	Hastelloy X																						
S ₂	Titane pur	3.7035	Gr.2	ASTM B348 / F67																						
		3.7065	Gr.4	ASTM B348 / F68		120	0.016	120	0.018																	
S ₃	Alliages de titane	3.7165	TiAl6V4	ASTM B348 / F136																						
		9.9367	TiAl6Nb7	ASTM F1295		120	0.016	120	0.018																	
H ₁	Aciers trempés < 55 HRC	1.2510	100MnCrMoW4	AISI O1																						
		1.2379	X153CrMoV12	AISI D2		100	0.010	100	0.012																	
H ₂	Aciers trempés ≥ 55 HRC																									