

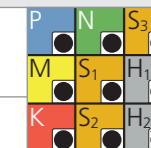
NEW

Type N - Semi-finition

v_c [m/min]
 f_z [mm]

RECOMMANDATION D'UTILISATION

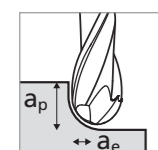
● Parfaitement recommandé | ● Recommandé | ○ Peu recommandé | ☒ Non recommandé



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

Possibilité 1

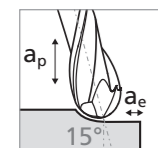
Inclinaison 0°



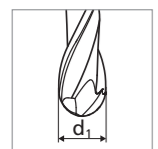
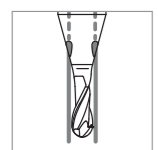
■ $a_p = 0.5 \times d$
■ $a_e = 0.2 \times d$

Possibilité 2

Inclinaison 15°



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



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/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	0.032	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																																											
	Aciers faiblement alliés Rm > 900 N/mm²	1.5752	15NiCr13	ASTM 3415 / AISI 3310	140	0.012	140	0.014		200	0.019	200	0.020	220	0.027	220	0.029	240	0.030	260	0.038	260	0.038	260	0.041																						
		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/mm²	1.2379	X153CrMoV12																						AISI D2	140	0.009	140	0.011		200	0.017	200	0.019	220	0.026	220	0.027	240	0.028	260	0.035	260	0.034	260	0.037
			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	140	0.014	140	0.015		200	0.020	200	0.022	220	0.029	220	0.031	240	0.032	260	0.038	260	0.038	260	0.041																						
		1.4105	X6CrMoS17	AISI 430F																																											
	Aciers inoxydables martensitiques	1.4034	X46Cr13	AISI 420C	140	0.013	140	0.014		200	0.019	200	0.020	220	0.027	220	0.029	240	0.029	260	0.037	260	0.037	260	0.039																						
		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		200	0.019	200	0.020	220	0.027	220	0.029	240	0.029	260	0.037	260	0.037	260	0.039																						
		1.4545	X5CrNiCuNb15-5	ASTM 15-5 PH																																											
	Aciers inoxydables austénitiques	1.4301	X5CrNi18-10	AISI 304	140	0.010	140	0.012		200	0.014	200	0.015	220	0.026	220	0.027	240	0.027	260	0.035	260	0.035	260	0.037																						
		1.4435	X2CrNiMo18-14-3	AISI 316L																																											
1.4441		X2CrNiMo18-15-3	AISI 316LM																																												
1.4539		X1NiCrMoCu25-20-5	AISI 904L																																												
K	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	0.042	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																																											
N	Alliages d'aluminium corroyés	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	0.044	260	0.048	260	0.047																						
		3.4365	AlZnMgCu1.5	ASTM 7075																																											
	Fonte d'aluminium	3.2163	GD-AlSi9Cu3	ASTM A380	140	0.015	140	0.017		200	0.022	200	0.024	220	0.031	220	0.034	240	0.046	260	0.044	260	0.048	260	0.047																						
		3.2381	GD-AlSi10Mg	UNS A03590																																											
	Cuivre	2.0040	Cu-OF / CW008A	UNS C10100	140	0.017	140	0.019		200	0.022	200	0.024	220	0.031	220	0.034	240	0.046	260	0.044	260	0.048	260	0.047																						
		2.0065	Cu-ETP / CW004A	UNS C11000																																											
	Laiton sans plomb	2.0321	CuZn37 CW508L	UNS C27400	140	0.017	140	0.019		200	0.022	200	0.024	220	0.031	220	0.034	240	0.046	260	0.044	260	0.048	260	0.047																						
		2.0360	CuZn40 CW509L	UNS C28000																																											
	Laiton, Bronze Rm < 400 N/mm²	2.0401	CuZn39Pb3 / CW614N	UNS C38500	140	0.017	140	0.019		200	0.022	200	0.024	220	0.031	220	0.034	240	0.046	260	0.044	260	0.048	260	0.047																						
		2.1020	CuSn6	UNS C51900																																											
Bronze Rm < 600 N/mm²	2.0966	CuAl10Ni5Fe4	UNS C63000	140	0.015	140	0.017		200	0.022	200	0.024	220	0.031	220	0.034	240	0.046	260	0.044	260	0.048	260	0.047																							
	2.0960	CuAl9Mn2	UNS C63200																																												
S1	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																																											
S2	Titane pur	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	0.027	170	0.034	170	0.035	170	0.036																						
		3.7065	Gr.4	ASTM B348 / F68																																											
S3	Alliages de titane	3.7165	TiAl6V4	ASTM B348 / F136	120	0.014	120	0.015		130	0.017	130	0.019	140	0.024	140	0.026	150	0.027	170	0.034	170	0.035	170	0.036																						
		9.9367	TiAl6Nb7	ASTM F1295																																											
H1	Aciers trempés < 55 HRC	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																																											
H2	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	0.024	240	0.026	240	0.032	240	0.027																						
		1.2379	X153CrMoV12	AISI D2																																											