

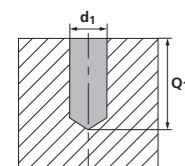
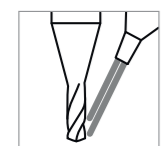
# CrazyDrill Alu 5 x d

RECOMMANDATION D'UTILISATION

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

P	N	S <sub>3</sub>
M	S <sub>1</sub>	H <sub>1</sub>
K	S <sub>2</sub>	H <sub>2</sub>

## PERÇAGE AVEC REFROIDISSEMENT EXTERNE | VUE D'ENSEMBLE DES DONNÉES DE COUPE



Groupe matériaux	Matériau	Mat. no.	DIN	AISI/ASTM/UNS	v <sub>c</sub> [m/min]	Q <sub>1</sub>	f [mm/tour]											
							Ød1 0.5 mm f	Ød1 1.0 mm f	Ød1 1.5 mm f	Ød1 2.0 mm f	Ød1 2.5 mm f	Ød1 3.0 mm f						
P	Aciers non alliés Rm < 800 N/mm²	1.0301	C10	AISI 1010														
		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														
		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														
		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												
1.4105	X6CrMoS17			AISI 430F														
Aciers inoxydables martensitiques	1.4034		X46Cr13	AISI 420C														
	1.4112		X90CrMoV18	AISI 440B														
Aciers inoxydables martensitiques - PH	1.4542		X5CrNiCuNb 16-4	AISI 630 / ASTM 17-4 PH														
	1.4545		X5CrNiCuNb 15-5	ASTM 15-5 PH														
Aciers inoxydables austénitiques	1.4301		X5CrNi 18-10	AISI 304														
	1.4435		X2CrNiMo 18-14-3	AISI 316L														
	1.4441		X2CrNiMo 18-15-3	AISI 316LM														
	1.4539		X1NiCrMoCu 25-20-5	AISI 904L														
	K	Fonte grise	0.6020	GG20	ASTM 30													
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	300	5xd1	0.03	0.05	0.10	0.20	0.25	0.30				
	3.4365	AlZnMgCu1.5		ASTM 7075														
	Fonte d'aluminium	3.2163	GD-AlSi9Cu3	ASTM A380	200	5xd1	0.10	0.20	0.25	0.30	0.40	0.50						
		3.2381	GD-AlSi10Mg	UNS A03590														
	Cuivre	2.004	Cu-OF / CW008A	UNS C10100														
		2.0065	Cu-ETP / CW004A	UNS C11000														
	Laiton sans plomb	2.0321	CuZn37 CW508L	UNS C27400														
		2.036	CuZn40 CW509L	UNS C28000														
	Laiton, Bronze Rm < 400 N/mm²	2.0401	CuZn39Pb3 / CW614N	UNS C38500														
		2.102	CuSn6	UNS C51900														
Bronze Rm < 600 N/mm²	2.0966	CuAl10Ni5Fe4	UNS C63000															
	2.096	CuAl9Mn2	UNS C63200															
S <sub>1</sub>	Super alliages	2.4856		Inconel 625														
		2.4668		Inconel 718														
		2.4617	NiMo28	Hastelloy B-2														
		2.4665	NiCr22Fe18Mo	Hastelloy X														
S <sub>2</sub>	Titane pur	3.7035	Gr.2	ASTM B348 / F67														
		3.7065	Gr.4	ASTM B348 / F68														
S <sub>3</sub>	Alliages de titane	3.7165	TiAl6V4	ASTM B348 / F136														
		9.9367	TiAl6Nb7	ASTM F1295														
H <sub>1</sub>	Aciers trempés < 55 HRC	2.4964	CoCr20W15Ni	Haynes 25														
			CrCoMo28	ASTM F1537														
H <sub>2</sub>	Aciers trempés ≥ 55 HRC	1.2510	100MnCrMoW4	AISI O1														
		1.2379	X153CrMoV12	AISI D2														