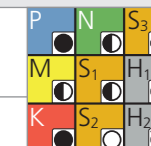


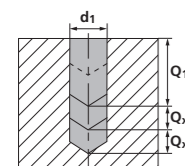
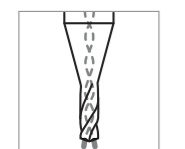
CrazyDrill Cool 10 x d - revêtu

RECOMMANDATION D'UTILISATION

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



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



Groupe matériaux	Matériau	Mat. no.	DIN	AISI/ASTM/UNS	v _c [m/min]	Q ₁	Q _x	f [mm/tour]																							
								Ød1																							
								0.8 mm 1/32" f	1.0 mm f	1.25 mm f	1.5 mm 1/16" f	2.0 mm f	2.5 mm 3/32" f	3.0 mm 1/8" f	4.0 mm 5/32" f	5.0 mm 3/16" - 7/32" f	6.0 mm f														
P	Aciers non alliés Rm < 800 N/mm²	1.0301	C10	AISI 1010	80	6xd1	2xd1	●	●	●	●	●	●	●	●	●	●	●													
		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																											
	Aciers faiblement alliés Rm > 900 N/mm²	1.7131	16MnCr5	AISI 5115	80	6xd1	2xd1	●	●	●	●	●	●	●	●	●	●	●													
		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																											
Aciers à outil fortement alliés Rm < 1200 N/mm²	1.3343	HS6-5-2C	AISI M2 / UNS T11302	60	6xd1	2xd1	●	●	●	●	●	●	●	●	●	●	●														
	1.3355	HS18-0-1	AISI T1 / UNS T12001																												
	1.4016	X6Cr17	AISI 430 / UNS S43000															50	0.5xd1	0.25xd1	●	●	●	●	●	●	●	●	●	●	●
	1.4105	X6CrMoS17	AISI 430F																												
	1.4034	X46Cr13	AISI 420C																												
	1.4112	X90CrMoV18	AISI 440B																												
1.4542	X5CrNiCuNb 16-4	AISI 630 / ASTM 17-4 PH																													
1.4545	X5CrNiCuNb 15-5	ASTM 15-5 PH																													
Aciers inoxydables martensitiques	1.4301	X5CrNi 18-10	AISI 304	40	0.5xd1	0.25xd1	●	●	●	●	●	●	●	●	●	●	●														
	1.4435	X2CrNiMo 18-14-3	AISI 316L																												
	1.4441	X2CrNiMo 18-15-3	AISI 316LM																												
	1.4539	X1NiCrMoCu 25-20-5	AISI 904L																												
	0.6020	GG20	ASTM 30															80	10xd1	-	●	●	●	●	●	●	●	●	●	●	●
	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	10xd1	-	●	●	●	●	●	●	●	●	●	●														
		3.4365	AlZnMgCu1.5	ASTM 7075																											
	Fonte d'aluminium	3.2163	GD-AlSi9Cu3	ASTM A380	200	10xd1	-	●	●	●	●	●	●	●	●	●	●														
		3.2381	GD-AlSi10Mg	UNS A03590																											
	Cuivre	2.004	Cu-OF / CW008A	UNS C10100	100	1.5xd1	1xd1	●	●	●	●	●	●	●	●	●	●														
		2.0065	Cu-ETP / CW004A	UNS C11000																											
	Laiton sans plomb	2.0321	CuZn37 CW508L	UNS C27400	140	1xd1	0.5xd1	●	●	●	●	●	●	●	●	●	●														
		2.036	CuZn40 CW509L	UNS C28000																											
	Laiton, Bronze Rm < 400 N/mm²	2.0401	CuZn39Pb3 / CW614N	UNS C38500	120	2xd1	1xd1	●	●	●	●	●	●	●	●	●	●														
		2.102	CuSn6	UNS C51900																											
Bronze Rm < 600 N/mm²	2.0966	CuAl10Ni5Fe4	UNS C63000	200	10xd1	-	●	●	●	●	●	●	●	●	●	●															
	2.096	CuAl9Mn2	UNS C63200																												
S ₁	Super alliages	2.4856		Inconel 625	20	0.5xd1	0.25xd1	●	●	●	●	●	●	●	●	●	●														
		2.4668		Inconel 718																											
		2.4617	NiMo28	Hastelloy B-2																											
		2.4665	NiCr22Fe18Mo	Hastelloy X																											
S ₂	Titane pur	3.7035	Gr.2	ASTM B348 / F67	20	0.5xd1	0.25xd1	●	●	●	●	●	●	●	●	●															
		3.7065	Gr.4	ASTM B348 / F68																											
S ₃	Alliages de titane	3.7165	TiAl6V4	ASTM B348 / F136	20	0.5xd1	0.25xd1	●	●	●	●	●	●	●	●	●															
		9.9367	TiAl6Nb7	ASTM F1295																											
H ₁	Aciers trempés < 55 HRC	2.4964	CoCr20W15Ni	Haynes 25	20	0.5xd1	0.25xd1	●	●	●	●	●	●	●	●	●															
			CrCoMo28	ASTM F1537																											
H ₂	Aciers trempés ≥ 55 HRC	1.2510	100MnCrMoW4	AISI O1	40	0.5xd1	0.25xd1	●	●	●	●	●	●	●	●	●															
		1.2379	X153CrMoV12	AISI D2																											