

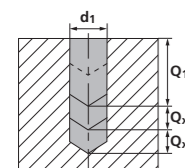
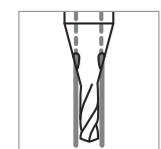
SST-Inox - 30 x d

RECOMMANDATION D'UTILISATION

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



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



Groupe matériaux	Matériau	Mat. no.	DIN	AISI/ASTM/UNS	v _c [m/min]		Q ₁	Q ₂	f [mm/tour]										
					Ød1 ≤ 0.4	Ød1 > 0.4			0.2 mm	0.4 mm 1/64"	0.6 mm	Ød1 0.8 mm 1/32"	1.0 mm	1.5 mm 1/16"	2.0 mm				
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															
		1.0044	S275JR	AISI 1020															
		1.0715	11SMn30	AISI 1215															
		1.5752	15NiCr13	ASTM 3415 / AISI 3310															
	Aciers faiblement alliés Rm > 900 N/mm ²	1.7131	16MnCr5	AISI 5115															
		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/mm ²	1.3343	HS6-5-2C	AISI M2 / UNS T11302															
1.3355		HS18-0-1	AISI T1 / UNS T12001																
Recommandé : CrazyDrill Flex Steel 30 x d1																			
Aciers inoxydables ferritiques		1.4016	X6Cr17	AISI 430 / UNS S43000	30 – 40	40 – 50		2xd1 – 3xd1	0.5xd1	0.015 – 0.020	0.015 – 0.020	0.020 – 0.030	0.020 – 0.030	0.030 – 0.040	0.040 – 0.050	0.050 – 0.060			
		1.4105	X6CrMoS17	AISI 430F															
	1.4034	X46Cr13	AISI 420C	20 – 30	30 – 40		2xd1 – 3xd1	0.5xd1	0.015 – 0.020	0.015 – 0.020	0.020 – 0.025	0.020 – 0.025	0.025 – 0.035	0.040 – 0.050	0.050 – 0.060				
	1.4112	X90CrMoV18	AISI 440B																
Aciers inoxydables martensitiques	1.4542	X5CrNiCuNb 16-4	AISI 630 / ASTM 17-4 PH	20 – 30	30 – 40		2xd1 – 3xd1	0.5xd1	0.015 – 0.020	0.015 – 0.020	0.020 – 0.025	0.020 – 0.025	0.025 – 0.035	0.040 – 0.050	0.050 – 0.060				
	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	20 – 30	30 – 40		2xd1 – 3xd1	0.5xd1	0.010 – 0.020	0.010 – 0.020	0.015 – 0.025	0.020 – 0.030	0.025 – 0.035	0.035 – 0.045	0.045 – 0.055				
	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															
		3.4365	AlZnMgCu1.5	ASTM 7075															
	Fonte d'aluminium	3.2163	GD-ALSi9Cu3	ASTM A380															
		3.2381	GD-ALSi10Mg	UNS A03590															
	Cuivre	2.004	Cu-OF / CW008A	UNS C10100	20 – 30	35 – 60		2xd1 – 3xd1	0.5xd1	0.040	0.045	0.050	0.060	0.070	0.080	0.100			
		2.0065	Cu-ETP / CW004A	UNS C11000															
	Laiton sans plomb	2.0321	CuZn37 CW508L	UNS C27400	20 – 30	35 – 60		2xd1 – 3xd1	0.5xd1	0.040	0.045	0.050	0.060	0.070	0.080	0.100			
		2.036	CuZn40 CW509L	UNS C28000															
	Laiton, Bronze Rm < 400 N/mm ²	2.0401	CuZn39Pb3 / CW614N	UNS C38500															
		2.102	CuSn6	UNS C51900															
Bronze Rm < 600 N/mm ²	2.0966	CuAl10Ni5Fe4	UNS C63000																
	2.096	CuAl9Mn2	UNS C63200																
S ₁	Super alliages	2.4856		Inconel 625	10 – 20	20 – 30		2xd1 – 3xd1	0.2xd1	0.010 – 0.020	0.010 – 0.020	0.015 – 0.025	0.020 – 0.030	0.025 – 0.035	0.035 – 0.045	0.045 – 0.055			
		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															
		3.7065	Gr.4	ASTM B348 / F68															
S ₃	Alliages de titane	3.7165	TiAl6V4	ASTM B348 / F136															
		9.9367	TiAl6Nb7	ASTM F1295															
H ₁	Aciers trempés < 55 HRC	1.2510	100MnCrMoW4	AISI O1															
		1.2379	X153CrMoV12	AISI D2															

Recommandé : CrazyDrill Flex Titanium 30 x d1

Recommandé : CrazyDrill Flex Steel 30 x d1

Recommandé : CrazyDrill Flex Steel 30 x d1

Recommandé : CrazyDrill Flex Steel 30 x d1