

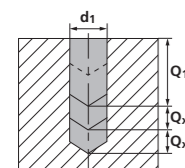
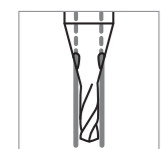
SST-Inox - 50 x d

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			0.3 mm	0.4 mm 1/64"	0.6 mm	Ød1 0.8 mm 1/32"	1.0 mm	1.2 mm
P	Aciers non alliés Rm < 800 N/mm ²	1.0301	C10	AISI 1010					Recommandé : CrazyDrill Flex Steel 50 x d1					
		1.0401	C15	AISI 1015					Recommandé : CrazyDrill Flex Steel 50 x d1					
		1.1191	C45E/CK45	AISI 1045					Recommandé : CrazyDrill Flex Steel 50 x d1					
		1.0044	S275JR	AISI 1020					Recommandé : CrazyDrill Flex Steel 50 x d1					
		1.0715	11SMn30	AISI 1215					Recommandé : CrazyDrill Flex Steel 50 x d1					
		1.5752	15NiCr13	ASTM 3415 / AISI 3310					Recommandé : CrazyDrill Flex Steel 50 x d1					
	Aciers faiblement alliés Rm > 900 N/mm ²	1.7131	16MnCr5	AISI 5115					Recommandé : CrazyDrill Flex Steel 50 x d1					
		1.3505	100Cr6	AISI 52100					Recommandé : CrazyDrill Flex Steel 50 x d1					
		1.7225	42CrMo4	AISI 4140					Recommandé : CrazyDrill Flex Steel 50 x d1					
		1.2842	90MnCrV8	AISI O2					Recommandé : CrazyDrill Flex Steel 50 x d1					
		1.2379	X153CrMoV12	AISI D2					Recommandé : CrazyDrill Flex Steel 50 x d1					
		1.2436	X210CrW12	AISI D4/D6					Recommandé : CrazyDrill Flex Steel 50 x d1					
Aciers à outil fortement alliés Rm < 1200 N/mm ²	1.3343	HS6-5-2C	AISI M2 / UNS T11302					Recommandé : CrazyDrill Flex Steel 50 x d1						
	1.3355	HS18-0-1	AISI T1 / UNS T12001					Recommandé : CrazyDrill Flex Steel 50 x d1						
	Aciers inoxydables ferritiques	1.4016	X6Cr17	AISI 430 / UNS S43000	25-35	35-40	2xd1 - 3xd1	0.2xd1 - 0.5xd1	0.010-0.015	0.010-0.015	0.015-0.020	0.015-0.020	0.030-0.040	0.040-0.050
		1.4105	X6CrMoS17	AISI 430F										
		1.4034	X46Cr13	AISI 420C	25-35	35-40	2xd1 - 3xd1	0.2xd1 - 0.5xd1	0.010-0.015	0.010-0.015	0.015-0.020	0.015-0.020	0.030-0.040	0.040-0.050
		1.4112	X90CrMoV18	AISI 440B										
Aciers inoxydables martensitiques	1.4542	X5CrNiCuNb 16-4	AISI 630 / ASTM 17-4 PH	25-35	35-40	2xd1 - 3xd1	0.2xd1 - 0.5xd1	0.010-0.015	0.010-0.015	0.015-0.020	0.015-0.020	0.030-0.040	0.040-0.050	
	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	25-35	35-40	2xd1 - 3xd1	0.2xd1 - 0.5xd1	0.005-0.010	0.005-0.010	0.010-0.015	0.010-0.015	0.020-0.030	0.030-0.040	
	1.4441	X2CrNiMo 18-15-3	AISI 316LM											
1.4539	X1NiCrMoCu 25-20-5	AISI 904L												
K	Fonte grise	0.6020	GG20	ASTM 30					Recommandé : CrazyDrill Flex Steel 50 x d1					
		0.6030	GG30	ASTM 40B					Recommandé : CrazyDrill Flex Steel 50 x d1					
		0.7040	GGG40	ASTM 60-40-18					Recommandé : CrazyDrill Flex Steel 50 x d1					
		0.7060	GGG60	ASTM 80-60-03					Recommandé : CrazyDrill Flex Steel 50 x d1					
N	Alliages d'aluminium corroyés	3.2315	AlMgSi1	ASTM 6351					Recommandé : CrazyDrill Flex Steel 50 x d1					
		3.4365	AlZnMgCu1.5	ASTM 7075					Recommandé : CrazyDrill Flex Steel 50 x d1					
	Fonte d'aluminium	3.2163	GD-AlSi9Cu3	ASTM A380					Recommandé : CrazyDrill Flex Steel 50 x d1					
		3.2381	GD-AlSi10Mg	UNS A03590					Recommandé : CrazyDrill Flex Steel 50 x d1					
	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
		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
		2.036	CuZn40 CW509L	UNS C28000										
	Laiton, Bronze	2.0401	CuZn39Pb3 / CW614N	UNS C38500					Recommandé : CrazyDrill Flex Steel 50 x d1					
	Bronze	2.102	CuSn6	UNS C51900					Recommandé : CrazyDrill Flex Steel 50 x d1					
2.0966		CuAl10Ni5Fe4	UNS C63000					Recommandé : CrazyDrill Flex Steel 50 x d1						
2.096	CuAl9Mn2	UNS C63200					Recommandé : CrazyDrill Flex Steel 50 x d1							
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
		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					Recommandé : CrazyDrill Flex Titanium 50 x d1					
		3.7065	Gr.4	ASTM B348 / F68					Recommandé : CrazyDrill Flex Titanium 50 x d1					
S ₃	Alliages de titane	3.7165	TiAl6V4	ASTM B348 / F136					Recommandé : CrazyDrill Flex Titanium 50 x d1					
		9.9367	TiAl6Nb7	ASTM F1295					Recommandé : CrazyDrill Flex Titanium 50 x d1					
H ₁	Aciers trempés < 55 HRC	2.4964	CoCr20W15Ni	Haynes 25	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
			CrCoMo28	ASTM F1537										
H ₂	Aciers trempés ≥ 55 HRC	1.2510	100MnCrMoW4	AISI O1					Recommandé : CrazyDrill Flex Steel 50 x d1					
		1.2379	X153CrMoV12	AISI D2					Recommandé : CrazyDrill Flex Steel 50 x d1					