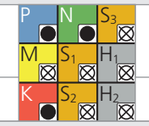
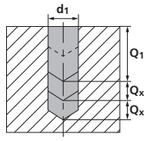
PERCER
CRAZYDRILL FLEX

Steel - 20 x d - revêtu

RECOMMANDATION D'UTILISATION
● Parfaitement recommandé | ◐ Recommandé | ○ Peu recommandé | ⊠ Non recommandé



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



Groupe matériaux	Matériau	Mat. no.	DIN	AISI/ASTM/UNS	v_c [m/min] Ød1 ≤ 0.4	v_c [m/min] Ød1 > 0.4	Q_1	Q_x	f [mm/tour] Ød1 0.2 mm f	0.3 mm f	0.4 mm 1/64" f	0.6 mm f	0.8 mm 1/32" f	1.0 mm – 1.2 mm f
P	Aciers non alliés Rm < 800 N/mm²	1.0301	C10	AISI 1010	5 – 40	40 – 60	7xd1	0.5xd1	0.005	0.010	0.015	0.030	0.040	0.060
		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	5 – 25	25 – 50	7xd1	0.5xd1	0.003 – 0.005	0.008 – 0.010	0.012 – 0.015	0.020 – 0.025	0.035	0.050
		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	5 – 20	20 – 35	7xd1	1xd1	0.004	0.008	0.010	0.015	0.025	0.040
		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					Recommandé : CrazyDrill Flex SST-Inox 30 x d1					
		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	5 – 40	50 – 100	7xd1	1xd1	0.005	0.010	0.015	0.020	0.035	0.050
		0.6030	GG30	ASTM 40B										
		0.7040	GGG40	ASTM 60-40-18		40 – 80								
		0.7060	GGG60	ASTM 80-60-03										
N	Alliages d'aluminium corroyés	3.2315	AlMgSi1	ASTM 6351	5 – 40	60 – 120	7xd1	1xd1	0.015	0.040	0.050	0.080	0.100	0.120
		3.4365	AlZnMgCu1.5	ASTM 7075										
	Fonte d'aluminium	3.2163	GD-AlSi9Cu3	ASTM A380	5 – 40	50 – 80	7xd1	1xd1	0.015	0.040	0.050	0.080	0.100	0.120
		3.2381	GD-AlSi10Mg	UNS A03590										
	Cuivre	2.004	Cu-OF / CW008A	UNS C10100					Recommandé : CrazyDrill Flex Titanium 30 x d1					
		2.0065	Cu-ETP / CW004A	UNS C11000										
	Laiton sans plomb	2.0321	CuZn37 CW508L	UNS C27400					Recommandé : CrazyDrill Flex SST-Inox 30 x d1					
		2.036	CuZn40 CW509L	UNS C28000										
	Laiton, Bronze Rm < 400 N/mm²	2.0401	CuZn39Pb3 / CW614N	UNS C38500	5 – 40	60 – 100	7xd1	1xd1	0.010	0.030	0.040	0.060	0.080	0.100
		2.102	CuSn6	UNS C51900		40 – 60								
	Bronze Rm < 600 N/mm²	2.0966	CuAl10Ni5Fe4	UNS C63000	5 – 20	20 – 40	2.5xd1	0.5xd1	0.004	0.006	0.010	0.015	0.025	0.040
		2.096	CuAl9Mn2	UNS C63200										
S_1	Super alliages	2.4856		Inconel 625					Recommandé : CrazyDrill Flex SST-Inox 30 x d1					
		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 30 x d1					
		3.7065	Gr.4	ASTM B348 / F68										
	Alliages de titane	3.7165	TiAl6V4	ASTM B348 / F136					Recommandé : CrazyDrill Flex Titanium 30 x d1					
		9.9367	TiAl6Nb7	ASTM F1295										
S_3	Alliages CrCo	2.4964	CoCr20W15Ni	Haynes 25					Recommandé : CrazyDrill Flex SST-Inox 30 x d1					
			CrCoMo28	ASTM F1537										
H_1	Aciers trempés < 55 HRC	1.2510	100MnCrMoW4	AISI O1										
H_2	Aciers trempés ≥ 55 HRC	1.2379	X153CrMoV12	AISI D2										