

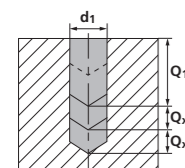
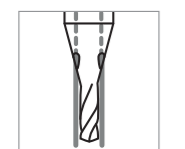
# Steel - 50 x d - revêtu

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 <sub>c</sub> [m/min]		Q <sub>1</sub>	Q <sub>2</sub>	f [mm/rev]														
					Ød1 ≤ 0.4	Ød1 > 0.4			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	0.010	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																			
		1.5752	15NiCr13	ASTM 3415 / AISI 3310																			
	Aciers faiblement alliés Rm > 900 N/mm²	1.7131	16MnCr5	AISI 5115	5 - 25	25 - 50	7xd1	0.5xd1	0.008 - 0.010	0.012 - 0.015	0.020 - 0.025	0.035	0.050										
		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	5 - 20	20 - 35	7xd1	0.5xd1	0.008	0.010	0.015	0.025	0.040											
	1.3355	HS18-0-1	AISI T1 / UNS T12001																				
	Recommandé : CrazyDrill Flex SST-Inox 50 x d1																						
	M	Aciers inoxydables ferritiques	1.4016										X6Cr17	AISI 430 / UNS S43000	5 - 40	50 - 100	7xd1	0.5xd1	0.010	0.015	0.020	0.035	0.050
			1.4105										X6CrMoS17	AISI 430F									
			1.4034										X46Cr13	AISI 420C									
1.4112			X90CrMoV18	AISI 440B																			
Aciers inoxydables martensitiques		1.4542	X5CrNiCuNb 16-4	AISI 630 / ASTM 17-4 PH																			
		1.4545	X5CrNiCuNb 15-5	ASTM 15-5 PH																			
		1.4301	X5CrNi 18-10	AISI 304																			
		1.4435	X2CrNiMo 18-14-3	AISI 316L																			
Aciers inoxydables austénitiques	1.4441	X2CrNiMo 18-15-3	AISI 316LM																				
	1.4539	X1NiCrMoCu 25-20-5	AISI 904L																				
	Recommandé : CrazyDrill Flex SST-Inox 50 x d1																						
	K	Fonte grise	0.6020	GG20	ASTM 30	5 - 40	40 - 80	7xd1	0.5xd1	0.010	0.015	0.020	0.035	0.050									
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	5 - 40	60 - 120	7xd1	1xd1	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	0.040	0.050	0.080	0.100	0.120										
		3.2381	GD-AlSi10Mg	UNS A03590																			
	Cuivre	2.004	Cu-OF / CW008A	UNS C10100	5 - 40	60 - 100	7xd1	1xd1	0.030	0.040	0.060	0.080	0.100										
		2.0065	Cu-ETP / CW004A	UNS C11000																			
	Laiton sans plomb	2.0321	CuZn37 CW508L	UNS C27400	5 - 40	40 - 60	7xd1	1xd1	0.030	0.040	0.060	0.080	0.100										
		2.036	CuZn40 CW509L	UNS C28000																			
	Laiton, Bronze Rm < 400 N/mm²	2.0401	CuZn39Pb3 / CW614N	UNS C38500	5 - 40	20 - 40	2.5xd1	0.5xd1	0.006	0.010	0.015	0.025	0.040										
		2.102	CuSn6	UNS C51900																			
Bronze Rm < 600 N/mm²	2.0966	CuAl10Ni5Fe4	UNS C63000	5 - 20	20 - 40	2.5xd1	0.5xd1	0.006	0.010	0.015	0.025	0.040											
	2.096	CuAl9Mn2	UNS C63200																				
S <sub>1</sub>	Super alliages	2.4856		Inconel 625	5 - 40	60 - 120	7xd1	1xd1	0.040	0.050	0.080	0.100	0.120										
		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	5 - 40	60 - 120	7xd1	1xd1	0.040	0.050	0.080	0.100	0.120										
		3.7065	Gr.4	ASTM B348 / F68																			
S <sub>3</sub>	Alliages de titane	3.7165	TiAl6V4	ASTM B348 / F136	5 - 40	60 - 120	7xd1	1xd1	0.040	0.050	0.080	0.100	0.120										
		9.9367	TiAl6Nb7	ASTM F1295																			
H <sub>1</sub>	Aciers trempés < 55 HRC	1.2510	100MnCrMoW4	AISI O1	5 - 40	60 - 120	7xd1	1xd1	0.040	0.050	0.080	0.100	0.120										
		2.4964	CoCr20W15Ni	Haynes 25																			
H <sub>2</sub>	Aciers trempés ≥ 55 HRC	1.2379	X153CrMoV12	AISI D2	5 - 40	60 - 120	7xd1	1xd1	0.040	0.050	0.080	0.100	0.120										
		2.4964	CrCoMo28	ASTM F1537																			