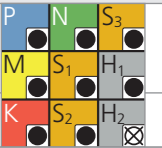


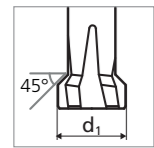
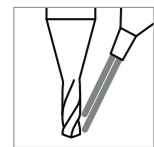
# CrazyMill Backchamfer 3 x d / 5 x d

RECOMMANDATION D'UTILISATION

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



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



Groupe matériaux	Matériau	Mat. no.	DIN	AISI/ASTM/UNS	v <sub>c</sub> [m/min]	f <sub>z</sub> [mm]				
						Ød1				
						0.36 - 1.90 mm f <sub>z</sub>	2.90 - 5.70 mm f <sub>z</sub>			
P	Aciers non alliés Rm < 800 N/mm <sup>2</sup>	1.0301	C10	AISI 1010	120	0.030	0.040			
		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 <sup>2</sup>	1.7131	16MnCr5	AISI 5115	100	0.020	0.030			
		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 <sup>2</sup>	1.3343	HS6-5-2C	AISI M2 / UNS T11302	80	0.015	0.030				
	1.3355	HS18-0-1	AISI T1 / UNS T12001							
	Aciers inoxydables ferritiques	1.4016	X6Cr17				AISI 430 / UNS S43000	50	0.010	0.030
		1.4105	X6CrMoS17				AISI 430F			
	Aciers inoxydables martensitiques	1.4034	X46Cr13				AISI 420C	80	0.015	0.030
		1.4112	X90CrMoV18				AISI 440B			
Aciers inoxydables martensitiques - PH	1.4542	X5CrNiCuNb 16-4	AISI 630 / ASTM 17-4 PH	50	0.015	0.030				
	1.4545	X5CrNiCuNb 15-5	ASTM 15-5 PH							
Aciers inoxydables austénitiques	1.4301	X5CrNi 18-10	AISI 304	50	0.015	0.030				
	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	60	0.015	0.030			
		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	200	0.030	0.040			
		3.4365	AlZnMgCu1.5	ASTM 7075						
	Fonte d'aluminium	3.2163	GD-AlSi9Cu3	ASTM A380	200	0.030	0.040			
		3.2381	GD-AlSi10Mg	UNS A03590						
	Cuivre	2.004	Cu-OF / CW008A	UNS C10100	40	0.020	0.030			
		2.0065	Cu-ETP / CW004A	UNS C11000						
	Laiton sans plomb	2.0321	CuZn37 CW508L	UNS C27400	40	0.020	0.030			
		2.036	CuZn40 CW509L	UNS C28000						
	Laiton, Bronze Rm < 400 N/mm <sup>2</sup>	2.0401	CuZn39Pb3 / CW614N	UNS C38500	200	0.030	0.040			
		2.102	CuSn6	UNS C51900						
Bronze Rm < 600 N/mm <sup>2</sup>	2.0966	CuAl10Ni5Fe4	UNS C63000	200	0.030	0.040				
	2.096	CuAl9Mn2	UNS C63200							
S <sub>1</sub>	Super alliages	2.4856		Inconel 625	40	0.020	0.030			
		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	40	0.020	0.030			
		3.7065	Gr.4	ASTM B348 / F68						
S <sub>3</sub>	Alliages de titane	3.7165	TiAl6V4	ASTM B348 / F136	40	0.020	0.030			
		9.9367	TiAl6Nb7	ASTM F1295						
H <sub>1</sub>	Aciers trempés < 55 HRC	2.4964	CoCr20W15Ni	Haynes 25	50	0.015	0.030			
			CrCoMo28	ASTM F1537						
H <sub>2</sub>	Aciers trempés ≥ 55 HRC	1.2510	100MnCrMoW4	AISI O1	60	0.015	0.020			
		1.2379	X153CrMoV12	AISI D2						