

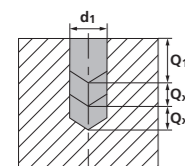
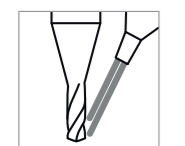
# MiquDrill 210 - revêtu

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 <sub>c</sub> [m/min]	Q <sub>1</sub>	Q <sub>2</sub>	f [mm/tour]													
								0.3-0.6 mm f	0.6-1.0 mm f	Ød1											
								1.0-1.5 mm f	1.5-2.0 mm f	2.0-3.0 mm f											
P	Aciers non alliés Rm < 800 N/mm²	1.0301	C10	AISI 1010	40 - 70	2xd1	1xd1	0.009	0.016	0.023	0.033	0.045									
		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	30 - 40	2xd1	1xd1	0.007	0.011	0.015	0.023	0.035									
		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	30 - 60	2xd1	1xd1	0.004	0.009	0.014	0.020	0.028										
	1.3355	HS18-0-1	AISI T1 / UNS T12001																		
	1.4016	X6Cr17	AISI 430 / UNS S43000																		
	1.4105	X6CrMoS17	AISI 430F																		
	1.4034	X46Cr13	AISI 420C																		
	1.4112	X90CrMoV18	AISI 440B																		
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																			
1.4441	X2CrNiMo 18-15-3	AISI 316LM																			
1.4539	X1NiCrMoCu 25-20-5	AISI 904L																			
K	Fonte grise	0.6020	GG20	ASTM 30	30 - 70	2xd1	1xd1	0.007	0.013	0.023	0.030	0.045									
		0.6030	GG30	ASTM 40B																	
		0.7040	GGG40	ASTM 60-40-18																	
		0.7060	GGG60	ASTM 80-60-03																	
		2.2315	AlMgSi1	ASTM 6351									80 - 150	2xd1	1xd1	0.010	0.023	0.038	0.050	0.070	
3.4365	AlZnMgCu1.5	ASTM 7075																			
3.2163	GD-AlSi9Cu3	ASTM A380																			
3.2381	GD-AlSi10Mg	UNS A03590																			
2.0040	Cu-OF / CW008A	UNS C10100																			
2.0065	Cu-ETP / CW004A	UNS C11000																			
2.0321	CuZn37 CW508L	UNS C27400																			
2.0360	CuZn40 CW509L	UNS C28000																			
2.0401	CuZn39Pb3 / CW614N	UNS C38500																			
2.1020	CuSn6	UNS C51900																			
2.0966	CuAl10Ni5Fe4	UNS C63000																			
2.0960	CuAl9Mn2	UNS C63200																			
S <sub>1</sub>	Super alliages	2.4856		Inconel 625																	
		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																	
		3.7065	Gr.4	ASTM B348 / F68																	
S <sub>3</sub>	Alliages de titane	3.7165	TiAl6V4	ASTM B348 / F136																	
		9.9367	TiAl6Nb7	ASTM F1295																	
H <sub>1</sub>	Aciers trempés < 55 HRC	1.2510	100MnCrMoW4	AISI O1	20 - 40	0.5xd1	0.5xd1	0.003	0.004	0.007	0.009	0.009									
		2.4964	CoCr20W15Ni	Haynes 25																	
H <sub>2</sub>	Aciers trempés ≥ 55 HRC	2.4964	CrCoMo28	ASTM F1537																	
		1.2379	X153CrMoV12	AISI D2																	