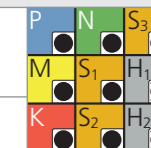


NEW Type C - Finition

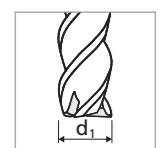
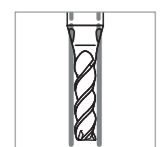
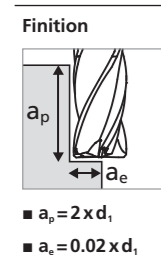
v_c [m/min]
 f_z [mm]

RECOMMANDATION D'UTILISATION

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



FRAISAGE AVEC REFROIDISSEMENT INTÉGRÉ | VUE D'ENSEMBLE DES DONNÉES DE COUPE



Groupe matériaux	Matériau	Mat. no.	DIN	AISI/ASTM/UNS	1.0 mm		1.5 mm 1/16"		2.0 mm 3/32"		3.0 mm 1/8"		Ød. 4.0 mm 5/32"		5.0 mm 3/16" - 7/32"		6.0 mm 1/4"		8.0 mm	
					v_c	f_z	v_c	f_z	v_c	f_z	v_c	f_z	v_c	f_z	v_c	f_z	v_c	f_z	v_c	f_z
P	Aciers non alliés Rm < 800 N/mm²	1.0301	C10	AISI 1010	130	0.008	180	0.012	200	0.017	210	0.023	220	0.025	220	0.028	220	0.033	220	0.042
		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	130	0.007	180	0.011	200	0.016	210	0.022	220	0.024	220	0.026	220	0.029	220	0.038
		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	130	0.006	180	0.010	200	0.015	210	0.020	220	0.021	220	0.023	220	0.025	220	0.034	
	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
1.4105			X6CrMoS17	AISI 430F																
1.4034			X46Cr13	AISI 420C																
Aciers inoxydables martensitiques		1.4112	X90CrMoV18	AISI 440B	130	0.008	180	0.011	200	0.016	210	0.022	220	0.023	220	0.025	220	0.028	260	0.037
		1.4542	X5CrNiCuNb16-4	AISI 630 / ASTM 17-4 PH																
		1.4545	X5CrNiCuNb15-5	ASTM 15-5 PH																
Aciers inoxydables martensitiques - PH		1.4301	X5CrNi18-10	AISI 304	130	0.008	180	0.011	200	0.016	210	0.022	220	0.023	220	0.025	220	0.028	260	0.037
		1.4435	X2CrNiMo18-14-3	AISI 316L																
		1.4441	X2CrNiMo18-15-3	AISI 316LM																
		1.4539	X1NiCrMoCu25-20-5	AISI 904L																
K	Fonte grise	0.6020	GG20	ASTM 30	110	0.006	130	0.012	150	0.014	160	0.022	170	0.025	170	0.029	170	0.031	200	0.040
		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																
3.4365	AlZnMgCu1.5			ASTM 7075																
Fonte d'aluminium	3.2163		GD-AlSi9Cu3	ASTM A380	130	0.009	180	0.013	200	0.018	210	0.029	220	0.030	220	0.033	220	0.036	270	0.045
	3.2381		GD-AlSi10Mg	UNS A03590																
Cuivre	2.0040		Cu-OF / CW008A	UNS C10100	130	0.010	180	0.013	200	0.018	210	0.029	220	0.030	220	0.033	220	0.036	270	0.045
	2.0065		Cu-ETP / CW004A	UNS C11000																
Laiton sans plomb	2.0321		CuZn37 CW508L	UNS C27400	130	0.010	180	0.013	200	0.018	210	0.029	220	0.030	220	0.033	220	0.036	270	0.045
	2.0360		CuZn40 CW509L	UNS C28000																
Laiton, Bronze Rm < 400 N/mm²	2.0401		CuZn39Pb3 / CW614N	UNS C38500	130	0.010	180	0.013	200	0.018	210	0.029	220	0.030	220	0.033	220	0.036	270	0.045
	2.1020		CuSn6	UNS C51900																
Bronze Rm < 600 N/mm²	2.0966	CuAl10Ni5Fe4	UNS C63000	130	0.009	180	0.013	200	0.018	210	0.029	220	0.030	220	0.033	220	0.036	270	0.045	
	2.0960	CuAl9Mn2	UNS C63200																	
S1	Superalliages	2.4856		Inconel 625	110	0.004	120	0.005	130	0.005	130	0.008	140	0.010	140	0.011	150	0.012	160	0.021
		2.4668		Inconel 718																
		2.4617	NiMo28	Hastelloy B-2																
		2.4665	NiCr22Fe18Mo	Hastelloy X																
S2	Titane pur	3.7035	Gr.2	ASTM B348 / F67	110	0.008	120	0.010	130	0.014	130	0.020	140	0.022	140	0.024	150	0.026	160	0.035
		3.7065	Gr.4	ASTM B348 / F68																
S3	Alliages de titane	3.7165	TiAl6V4	ASTM B348 / F136	110	0.008	120	0.010	130	0.014	130	0.020	140	0.022	140	0.024	150	0.026	160	0.035
		9.9367	TiAl6Nb7	ASTM F1295																
H1	Aciers trempés < 55 HRC	1.2510	100MnCrMoW4	AISI O1	110	0.004	120	0.005	130	0.005	130	0.008	140	0.010	140	0.011	150	0.012	160	0.021
		2.4964	CoCr20W15Ni CrCoMo28	Haynes 25 ASTM F1537																
H2	Aciers trempés ≥ 55 HRC	1.2379	X153CrMoV12	AISI D2																