

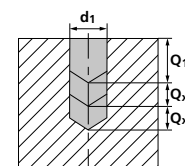
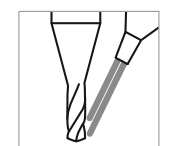
# Type IN 8 x d / 12 x d

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>	Q <sub>3</sub>	f [mm/tour]									
					Moyen	Haut				Ød1									
										0.2-0.5 mm 1/64"	0.6-0.8 mm 1/32"	0.9-1.1 mm	1.2-1.4 mm	1.5-1.7 mm 1/16"	1.8-2.0 mm				
P	Aciers non alliés Rm < 800 N/mm²	1.0301	C10	AISI 1010															
		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															
		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															
1.3355		HS18-0-1	AISI T1 / UNS T12001																
1.4016		X6Cr17	AISI 430 / UNS S43000	30	40	0.5xd1 - 1xd1			0.5xd1	0.010-0.015	0.015-0.025	0.025-0.030	0.030-0.040	0.040-0.050	0.050-0.060				
1.4105		X6CrMoS17	AISI 430F																
1.4034		X46Cr13	AISI 420C	30	40	0.5xd1 - 1xd1			0.5xd1	0.015-0.020	0.020-0.025	0.030-0.035	0.040-0.050	0.050-0.060	0.060-0.070				
Aciers inoxydables martensitiques	1.4112	X90CrMoV18	AISI 440B																
	1.4542	X5CrNiCuNb 16-4	AISI 630 / ASTM 17-4 PH	30	40	0.5xd1 - 1xd1			0.5xd1	0.010-0.015	0.015-0.020	0.020-0.030	0.030-0.040	0.040-0.050	0.050-0.060				
	1.4545	X5CrNiCuNb 15-5	ASTM 15-5 PH																
	1.4301	X5CrNi 18-10	AISI 304																
	1.4435	X2CrNiMo 18-14-3	AISI 316L	25	30	0.5xd1 - 1xd1			0.5xd1	0.010-0.015	0.015-0.020	0.020-0.030	0.030-0.040	0.040-0.045	0.040-0.060				
Aciers inoxydables austénitiques	1.4441	X2CrNiMo 18-15-3	AISI 316LM																
	1.4539	X1NiCrMoCu 25-20-5	AISI 904L																
	0.6020	GG20	ASTM 30																
	0.6030	GG30	ASTM 40B																
K	Fonte grise	0.7040	GGG40	ASTM 60-40-18															
		0.7060	GGG60	ASTM 80-60-03															
		3.2315	AlMgSi1	ASTM 6351															
		3.4365	AlZnMgCu1.5	ASTM 7075															
N	Alliages d'aluminium corroyés	3.2163	GD-AlSi9Cu3	ASTM A380															
		3.2381	GD-AlSi10Mg	UNS A03590															
	Fonte d'aluminium	2.0040	Cu-OF / CW008A	UNS C10100	30	100	2xd1 - 4xd1			2xd1	0.030-0.060	0.040-0.080	0.050-0.100	0.060-0.120	0.070-0.150	0.080-0.180			
		2.0065	Cu-ETP / CW004A	UNS C11000															
	Laiton sans plomb	2.0321	CuZn37 CW508L	UNS C27400	30	100	1xd1 - 4xd1			1xd1 - 2xd1	0.030-0.060	0.040-0.080	0.050-0.100	0.060-0.120	0.070-0.150	0.080-0.180			
		2.0360	CuZn40 CW509L	UNS C28000															
	Laiton, Bronze Rm < 400 N/mm²	2.0401	CuZn39Pb3 / CW614N	UNS C38500															
		2.1020	CuSn6	UNS C51900															
Bronze Rm < 600 N/mm²	2.0966	CuAl10Ni5Fe4	UNS C63000																
	2.0960	CuAl9Mn2	UNS C63200																
S <sub>1</sub>	Super alliages	2.4856		Inconel 625	15	25	0.25xd1 - 0.5xd1		0.25xd1	0.005-0.010	0.010-0.015	0.015-0.020	0.020-0.025	0.030-0.035	0.030-0.040				
		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	2.4964	CoCr20W15Ni	Haynes 25	25	35	0.5xd1 - 1xd1		0.5xd1	0.015-0.025	0.025-0.035	0.040-0.050	0.050-0.060	0.060-0.070	0.070-0.080				
		CrCoMo28	ASTM F1537																
H <sub>2</sub>	Aciers trempés ≥ 55 HRC	1.2510	100MnCrMoW4	AISI O1															
		1.2379	X153CrMoV12	AISI D2															