

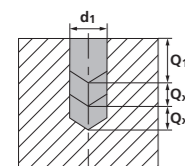
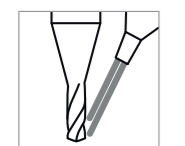
Type IN 8 x d / 12 x d

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 _c [m/min]	Q ₁	Q ₂	f [mm/tour]										
								0.2-0.5 mm 1/64" f	0.6-0.8 mm 1/32" f	0.9-1.1 mm f	Ød1 1.2-1.4 mm f		1.5-1.7 mm 1/16" f	1.8-2.0 mm f				
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															
Aciers inoxydables ferritiques		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														
Aciers inoxydables martensitiques		1.4034	X46Cr13	AISI 420C	30-40	0.5xd1-1xd1		0.5xd1	0.015-0.025	0.025-0.035	0.035-0.040	0.040-0.050	0.050-0.060	0.060-0.070				
		1.4112	X90CrMoV18	AISI 440B														
Aciers inoxydables martensitiques - PH	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															
Aciers inoxydables austénitiques	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					
	1.4441	X2CrNiMo 18-15-3	AISI 316LM															
	1.4539	X1NiCrMoCu 25-20-5	AISI 904L															
K	Fonte grise	0.6020	GG20	ASTM 30														
		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														
		3.4365	AlZnMgCu1.5	ASTM 7075														
	Fonte d'aluminium	3.2163	GD-AlSi9Cu3	ASTM A380														
		3.2381	GD-AlSi10Mg	UNS A03590														
	Cuivre	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 ₁	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 ₂	Titane pur	3.7035	Gr.2	ASTM B348 / F67														
		3.7065	Gr.4	ASTM B348 / F68														
S ₃	Alliages de titane	3.7165	TiAl6V4	ASTM B348 / F136														
		9.9367	TiAl6Nb7	ASTM F1295														
H ₁	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 ₂	Aciers trempés ≥ 55 HRC	1.2510	100MnCrMoW4	AISI O1														
		1.2379	X153CrMoV12	AISI D2														