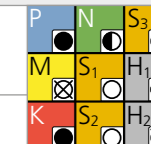


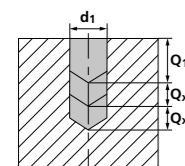
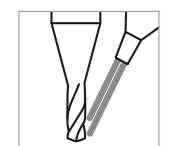
CrazyDrill Steel 4 x d

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 _x	f [mm/tour]																															
					Moyen	Haut			0.4 mm	0.8 mm	1.0 mm	1.25 mm	1.5 mm	2.0 mm	2.5 mm	3.0 mm	4.0 mm	5.0 mm	6.0 mm																					
									1/64" f	1/32" f	f	f	f	f	f	f	f	f	f	f	f																			
P	Aciers non alliés Rm < 800 N/mm²	1.0301	C10	AISI 1010	80	120	4xd1	-																																
		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	60	80	4xd1	-																																
		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	40	60	4xd1	-																																	
	1.3355	HS18-0-1	AISI T1 / UNS T12001																																					
	M	Aciers inoxydables ferritiques	1.4016																			X6Cr17	AISI 430 / UNS S43000																	
			1.4105																			X6CrMoS17	AISI 430F																	
			1.4034																			X46Cr13	AISI 420C																	
			1.4112																			X90CrMoV18	AISI 440B																	
Aciers inoxydables martensitiques		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																																				
Aciers inoxydables austénitiques		1.4441	X2CrNiMo 18-15-3	AISI 316LM																																				
		1.4539	X1NiCrMoCu 25-20-5	AISI 904L																																				
		K	Fonte grise	0.6020	GG20	ASTM 30	100	150	4xd1	-																														
				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	150	220	4xd1	-																																
		3.4365	AlZnMgCu1.5	ASTM 7075																																				
	Fonte d'aluminium	3.2163	GD-AlSi9Cu3	ASTM A380	150	200	4xd1	-																																
		3.2381	GD-AlSi10Mg	UNS A03590																																				
	Cuivre	2.0040	Cu-OF / CW008A	UNS C10100	80	120	1.5xd1	1xd1																																
		2.0065	Cu-ETP / CW004A	UNS C11000																																				
	Laiton sans plomb	2.0321	CuZn37 CW508L	UNS C27400	100	150	1.5xd1	1xd1																																
		2.0360	CuZn40 CW509L	UNS C28000																																				
	Laiton, Bronze Rm < 400 N/mm²	2.0401	CuZn39Pb3 / CW614N	UNS C38500	70	100	1.5xd1	1xd1																																
		2.1020	CuSn6	UNS C51900																																				
	Bronze Rm < 600 N/mm²	2.0966	CuAl10Ni5Fe4	UNS C63000	70	100	4xd1	-																																
		2.0960	CuAl9Mn2	UNS C63200																																				
S ₁	Super alliages	2.4856		Inconel 625	20	40	1xd1	0.25xd1																																
		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	20	40	1xd1	0.25xd1																																
		3.7065	Gr.4	ASTM B348 / F68																																				
S ₃	Alliages de titane	3.7165	TiAl6V4	ASTM B348 / F136	20	40	1xd1	0.3xd1																																
		9.9367	TiAl6Nb7	ASTM F1295																																				
H ₁	Aciers trempés < 55 HRC	1.2510	100MnCrMoW4	AISI O1	15	30	4xd1	-																																
		1.2379	X153CrMoV12	AISI D2																																				