

SCIE CIRCULAIRE, DENTURE FINE  
KREISSÄGE, FEINVERZAHNT  
SLITTING SAW, FINE PITCH

25500A-20-1.2

Version du  
15.06.2020



HIS

$\lambda = 0^\circ$   
 $\gamma = 6^\circ$

Compatibilité outil / matière  
Werkzeug / Werkstoffverträglichkeit  
Tool / Material compatibility

- 1/3
- 2/3
- 3/3

HIS - ALPHA

Gruppe Vc [m/min]



ESHOP / EZI CUT

		Gruppe	Vc [m/min]	
ACIERS ALLIÉS ET NON ALLIÉS UNLEGIERTE STÄHLE NON-ALLOYED STEELS	Rm < 450 N/mm <sup>2</sup>	1a	260	●
	Rm 450 - 700 N/mm <sup>2</sup>	1b	150	●
	Rm 700 - 900 N/mm <sup>2</sup>	1c	125	●
	Rm < 1200 N/mm <sup>2</sup>	1d	80	●
ACIERS INOX ROSTFREIE STÄHLE STAINLESS STEELS	Rm < 650 N/mm <sup>2</sup>	2a	150	●
	Rm 650 - 950 N/mm <sup>2</sup>	2b	150	●
	Rm > 950 N/mm <sup>2</sup>	2c	125	●
ACIERS TREMPÉS GEHÄRTETE STÄHLE HARDENED STEELS	44 - 56 HRC	3a		
	57 - 67 HRC	3b		
MATÉRIAUX EXOTIQUES EXOTISCHE WERKSTOFFE EXOTIC MATERIALS	< 32 HRC	4a	35	●
	> 32 HRC	4b	20	●
GRAPHITE		5	180	●
FONTES GUSS CAST IRON	< 32 HRC	6a	80	●
	> 32 HRC	6b	65	●
TITANE TITAN	Rm < 800 N/mm <sup>2</sup>	7a	70	●
	800 < Rm N/mm <sup>2</sup>	7b	65	●
ALLIAGES NICKEL NICKEL NICKEL ALLOYS	Rm < 1000 N/mm <sup>2</sup>	8a	35	●
	1000 < Rm N/mm <sup>2</sup>	8b	25	●
CUIVRE, LAITON, BRONZE KUPFER, MESSING, BRONZE COPPER, BRASS, BRONZE	Rm < 850 N/mm <sup>2</sup>	9a	400	●
	850 < Rm N/mm <sup>2</sup>	9b	350	●
ALUMINIUM	Si < 0.5%	10a	400	●
	0.5% < Si < 5%	10b	320	●
	Si > 5%	10c	185	●
MATIÈRES SYNTHÉTIQUES KUNSTSTOFFE SYNTHETIC MATERIALS	Thermoplast	11a	150	●
	Duraplast	11b	120	●
MATIÈRES COMPOSITES FASERVERST. MATERIALEN COMPOSITE MATERIALS	Fibre de verre	12a	130	●
	Fibre de carbone	12b	90	●
MÉTAUX PRÉCIEUX EDELMETALLE PRECIOUS MATERIALS	Or • Gold	13a	260	●
	Platine	13b	35	●



D (h10)	20
d (h6)	5
L	
l1	
l3	
d3	
R	
e	1.20
Z	40
Chanfrein	
K	
w° collision	