

**21031-0.7**

E25  
UF

$\lambda = 35^\circ$   
 $\gamma = 10^\circ$

angle  
vif



$l_1$   
1.5xD



Compatibilité outil / matière  
 Werkzeug / Werkstoffverträglichkeit  
 Tool / Material compatibility



ESHOP / EZI CUT

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

**E25UF**  
 Groupe Vc [m/min]

| ACIERS ALLIÉS ET NON ALLIÉS<br>UNLEGIERTE STÄHLE<br>NON-ALLOYED STEELS     | Rm < 450 N/mm <sup>2</sup>     | 1a  | 140 | ● |
|--|--------------------------------|-----|-----|---|
|  | Rm 450 - 700 N/mm <sup>2</sup> | 1b  | 110 | ● |
|  | Rm 700 - 900 N/mm <sup>2</sup> | 1c  | 90  | ● |
|  | Rm < 1200 N/mm <sup>2</sup>    | 1d  |     |   |
| ACIERS INOX<br>ROSTFREIE STÄHLE<br>STAINLESS STEELS                        | Rm < 650 N/mm <sup>2</sup>     | 2a  | 60  | ● |
|  | Rm 650 - 950 N/mm <sup>2</sup> | 2b  | 50  | ● |
|  | Rm > 950 N/mm <sup>2</sup>     | 2c  |     |   |
| ACIERS TREMPÉS GEHÄRTETE<br>STÄHLE HARDENED STEELS                         | 44 - 56 HRC                    | 3a  |     |   |
|  | 57 - 67 HRC                    | 3b  |     |   |
| MATÉRIAUX EXOTIQUES<br>EXOTISCHE WERKSTOFFE<br>EXOTIC MATERIALS            | < 32 HRC                       | 4a  |     |   |
|  | > 32 HRC                       | 4b  |     |   |
| GRAPHITE   |                                | 5   | 180 | ● |
| FONTES GUSS CAST IRON  | < 32 HRC                       | 6a  |     |   |
|  | > 32 HRC                       | 6b  |     |   |
| TITANE TITAN   | Rm < 800 N/mm <sup>2</sup>     | 7a  | 60  | ● |
|  | 800 < Rm N/mm <sup>2</sup>     | 7b  | 40  | ● |
| ALLIAGES NICKEL<br>NICKEL<br>NICKEL ALLOYS                                 | Rm < 1000 N/mm <sup>2</sup>    | 8a  |     |   |
|  | 1000 < Rm N/mm <sup>2</sup>    | 8b  |     |   |
| CUIVRE, LAITON, BRONZE<br>KUPFER, MESSING, BRONZE<br>COPPER, BRASS, BRONZE | Rm < 850 N/mm <sup>2</sup>     | 9a  | 320 | ● |
|  | 850 < Rm N/mm <sup>2</sup>     | 9b  | 200 | ● |
| ALUMINIUM  | Si < 0.5%                      | 10a | 300 | ● |
|  | 0.5% < Si < 5%                 | 10b | 250 | ● |
|  | Si > 5%                        | 10c |     |   |
| MATIÈRES SYNTHÉTIQUES<br>KUNSTSTOFFE<br>SYNTHETIC MATERIALS                | Thermoplast                    | 11a | 170 | ● |
|  | Duraplast                      | 11b | 120 | ● |
| MATIÈRES COMPOSITES<br>FASERVERST. MATERIALEN<br>COMPOSITE MATERIALS       | Fibre de verre                 | 12a | 130 | ● |
|  | Fibre de carbone               | 12b | 90  | ● |
| MÉTAUX PRÉCIEUX<br>EDELMETALLE<br>PRECIOUS MATERIALS                       | Or • Gold                      | 13a | 320 | ● |
|  | Platine                        | 13b |     |   |



|              |       |
|--------------|-------|
| D (0/- 0.01) | 0.7   |
| d (h5)       | 3     |
| L            | 38    |
| l1           | 1.05  |
| l3           |       |
| d3           |       |
| R            |       |
| e            |       |
| Z            | 2     |
| Chanfrein    |       |
| K            |       |
| w° collision | 11.1° |