

FRAISE Z4
FRÄSER Z4
ENDMILL Z4

21102-9-10

Version du
12.06.2020



Compatibilité outil / matière
Werkzeug / Werkstoffverträglichkeit
Tool / Material compatibility



ESHOP / EZI CUT

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

Gruppe E2 Vc [m/min]

		Gruppe	E2	Vc [m/min]	
ACIERS ALLIÉS ET NON ALLIÉS UNLEGIERTE STÄHLE NON-ALLOYED STEELS	Rm < 450 N/mm ²	1a		140	●
	Rm 450 - 700 N/mm ²	1b			
	Rm 700 - 900 N/mm ²	1c			
	Rm < 1200 N/mm ²	1d			
ACIERS INOX ROSTFREIE STÄHLE STAINLESS STEELS	Rm < 650 N/mm ²	2a			
	Rm 650 - 950 N/mm ²	2b			
	Rm > 950 N/mm ²	2c			
ACIERS TREMPÉS GEHÄRTETE STÄHLE HARDENED STEELS	44 - 56 HRC	3a			
	57 - 67 HRC	3b			
MATÉRIAUX EXOTIQUES EXOTISCHE WERKSTOFFE 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 ²	7a			
	800 < Rm N/mm ²	7b			
ALLIAGES NICKEL NICKEL NICKEL ALLOYS	Rm < 1000 N/mm ²	8a			
	1000 < Rm N/mm ²	8b			
CUIVRE, LAITON, BRONZE KUPFER, MESSING, BRONZE COPPER, BRASS, BRONZE	Rm < 850 N/mm ²	9a		320	●
	850 < Rm N/mm ²	9b		250	●
ALUMINIUM	Si < 0.5%	10a		300	●
	0.5% < Si < 5%	10b		250	●
	Si > 5%	10c			
MATIÈRES SYNTHÉTIQUES KUNSTSTOFFE SYNTHETIC MATERIALS	Thermoplast	11a		180	●
	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		320	●
	Platine	13b			



D (h10)	9
d (h6)	10
L	72
l1	19
l3	
d3	
R	
e	
Z	4
Chanfrein	0.1
K	
w° collision	1.4°