

**FRAISE Z4 HÉLICES DIFFÉRENTES  
FRÄSER Z4 MIT UNTERSCHIEDLICHEM DRALLWINKEL  
ENDMILL Z4 WITH DIFFERENT HELIX**

**21112D-10**

Version du  
12.06.2020



E2

$\lambda = 35^\circ - 38^\circ$   
 $Y = 10^\circ$

angle vif

$l_1$   
 $2.2 \times D$

$\lambda_2$   
 $\lambda_1$

Compatibilité outil / matière  
Werkzeug / Werkstoffverträglichkeit  
Tool / Material compatibility

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

**EZI – DIAM**  
Groupe Vc [m/min]



ESHOP / EZI CUT

|  |                                |     |   |
|--|--------------------------------|-----|---|
| ACIERS ALLIÉS ET NON ALLIÉS<br>UNLEGIERTE STÄHLE<br>NON-ALLOYED STEELS     | Rm < 450 N/mm <sup>2</sup>     | 1a  |   |
|  | Rm 450 - 700 N/mm <sup>2</sup> | 1b  |   |
|  | Rm 700 - 900 N/mm <sup>2</sup> | 1c  |   |
|  | Rm < 1200 N/mm <sup>2</sup>    | 1d  |   |
| ACIERS INOX<br>ROSTFREIE STÄHLE<br>STAINLESS STEELS                        | Rm < 650 N/mm <sup>2</sup>     | 2a  |   |
|  | Rm 650 - 950 N/mm <sup>2</sup> | 2b  |   |
|  | 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 <span style="color: green;">●</span>  |
| FONTES GUSS CAST IRON  | < 32 HRC                       | 6a  |   |
|  | > 32 HRC                       | 6b  |   |
| TITANE TITAN   | Rm < 800 N/mm <sup>2</sup>     | 7a  |   |
|  | 800 < Rm N/mm <sup>2</sup>     | 7b  |   |
| 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  | 300 <span style="color: green;">●</span>  |
|  | 850 < Rm N/mm <sup>2</sup>     | 9b  | 250 <span style="color: green;">●</span>  |
| ALUMINIUM  | Si < 0.5%                      | 10a | 400 <span style="color: orange;">●</span> |
|  | 0.5% < Si < 5%                 | 10b | 300 <span style="color: green;">●</span>  |
|  | Si > 5%                        | 10c | 250 <span style="color: green;">●</span>  |
| MATIÈRES SYNTHÉTIQUES<br>KUNSTSTOFFE<br>SYNTHETIC MATERIALS                | Thermoplast                    | 11a |   |
|  | Duraplast                      | 11b |   |
| MATIÈRES COMPOSITES<br>FASERVERST. MATERIALEN<br>COMPOSITE MATERIALS       | Fibre de verre                 | 12a | 260 <span style="color: green;">●</span>  |
|  | Fibre de carbone               | 12b | 200 <span style="color: green;">●</span>  |
| MÉTaux PRÉCIEUX<br>EDELMETALLE<br>PRECIOUS MATERIALS                       | Or • Gold                      | 13a | 280 <span style="color: orange;">●</span> |
|  | Platine                        | 13b | 40 <span style="color: green;">●</span>   |



- |              |    |
|--------------|----|
| D (h10)      | 10 |
| d (h6)       | 10 |
| L            | 72 |
| l1           | 22 |
| l3           |    |
| d3           |    |
| R            |    |
| e            |    |
| Z            | 4  |
| Chanfrein    |    |
| K            |    |
| w° collision |    |