

FRAISE DE SUPERFINITION MULTIDENTS
 SUPERSCHLICHTFRÄSER MEHRLIPPIG
 SUPERFINISHING MULTI-FLUTES ENDMILL

21143-8

Version du
 12.06.2020



E2
 $\lambda = 45^\circ$
 $\gamma = 8^\circ$
 $\begin{matrix} \varnothing \leq 6 & \varnothing > 6 \\ 90^\circ & 45^\circ \end{matrix}$

 l_1
1.5xD
 l_3

Compatibilité outil / matière
 Werkzeug / Werkstoffverträglichkeit
 Tool / Material compatibility



ESHOP / EZI CUT

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

Gruppe **E2**
 Vc [m/min]

| | | Gruppe | 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 | 110 | ● |
| | 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 | 70 | ● |
| | > 32 HRC | 6b | 55 | ● |
| TITANE TITAN | Rm < 800 N/mm ² | 7a | 60 | ● |
| | 800 < Rm N/mm ² | 7b | 40 | ● |
| 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 | 200 | ● |
| ALUMINIUM | Si < 0.5% | 10a | 300 | ● |
| | 0.5% < Si < 5% | 10b | 250 | ● |
| | Si > 5% | 10c | | |
| MATIÈRES SYNTHÉTIQUES KUNSTSTOFFE SYNTHETIC MATERIALS | Thermoplast | 11a | 170 | ● |
| | 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 | 30 | ● |



| | |
|--------------|------|
| D (h10) | 8 |
| d (h6) | 8 |
| L | 63 |
| l1 | 12 |
| l3 | 26 |
| d3 | 7.40 |
| R | |
| e | |
| Z | 6 |
| Chanfrein | 0.1 |
| K | |
| w° collision | |