

FRAISE D'ÉBAUCHE Z3 POUR ALUMINIUM
 SCHRUPPFÄSER Z3 FÜR ALUMINIUM
 ROUGHING ENDMILL Z3 FOR ALUMINIUM

21603H-12

Version du
 12.06.2020



E2
 $\lambda = 40^\circ$
 $\gamma = 18^\circ$
45°
 l_1
2.2xD
 l_3

Compatibilité outil / matière
 Werkzeug / Werkstoffverträglichkeit
 Tool / Material compatibility



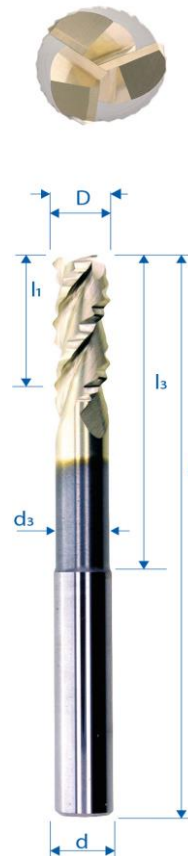
ESHOP / EZI CUT

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

AL - EZI

Gruppe Vc [m/min]

	Rm [N/mm ²]	Gruppe	Vc [m/min]
ACIERS ALLIÉS ET NON ALLIÉS UNLEGIERTE STÄHLE NON-ALLOYED STEELS	Rm < 450 N/mm ²	1a	
	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	
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	400 ●
	850 < Rm N/mm ²	9b	300 ●
ALUMINIUM	Si < 0.5%	10a	520 ●
	0.5% < Si < 5%	10b	400 ●
	Si > 5%	10c	280 ●
MATIÈRES SYNTHÉTIQUES KUNSTSTOFFE SYNTHETIC MATERIALS	Thermoplast	11a	
	Duraplast	11b	
MATIÈRES COMPOSITES FASERVERST. MATERIALEN COMPOSITE MATERIALS	Fibre de verre	12a	
	Fibre de carbone	12b	
MÉTALUX PRÉCIEUX EDELMETALLE PRECIOUS MATERIALS	Or • Gold	13a	
	Platine	13b	



D (h10)	12
d (h6)	12
L	110
l1	26
l3	64
d3	11.00
R	
e	
Z	3
Chanfrein	0.6
K	
w° collision	