

SCIE CIRCULAIRE, DENTURE FINE
KREISSÄGE, FEINVERZAHNT
SLITTING SAW, FINE PITCH

25500-20-1.2

Version du
15.06.2020



HIS

$\lambda = 0^\circ$
 $\gamma = 6^\circ$

Compatibilité outil / matière
Werkzeug / Werkstoffverträglichkeit
Tool / Material compatibility



ESHOP / EZI CUT

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

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

		Gruppe	HIS	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	90	●	
	Rm 700 - 900 N/mm ²	1c	70	●	
	Rm < 1200 N/mm ²	1d	55	●	
ACIERS INOX ROSTFREIE STÄHLE STAINLESS STEELS	Rm < 650 N/mm ²	2a	65	●	
	Rm 650 - 950 N/mm ²	2b	65	●	
	Rm > 950 N/mm ²	2c	50	●	
ACIERS TREMPÉS STÄHLE GEHÄRTETE 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	55	●	
	> 32 HRC	6b	40	●	
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	250	●	
ALUMINIUM	Si < 0.5%	10a	400	●	
	0.5% < Si < 5%	10b	320	●	
	Si > 5%	10c	150	●	
MATIÈRES SYNTHÉTIQUES KUNSTSTOFFE SYNTHETIC MATERIALS	Thermoplast	11a	180	●	
	Duraplast	11b	120	●	
MATIÈRES COMPOSITES FASERVERST. MATERIALIEN COMPOSITE MATERIALS	Fibre de verre	12a	130	●	
	Fibre de carbone	12b	90	●	
MÉTALUX PRÉCIEUX EDELMETALLE PRECIOUS MATERIALS	Or • Gold	13a	320	●	
	Platine	13b			



D (h10)	20
d (h6)	5
L	
l1	
l3	
d3	
R	
e	1.20
Z	40
Chanfrein	
K	
w° collision	