

25500A-25-0.6

Version du
15.06.2020



HIS

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

Compatibilité outil / matière
Werkzeug / Werkstoffverträglichkeit
Tool / Material compatibility

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

H1S - ALPHA

Gruppe Vc [m/min]



ESHOP / EZI CUT

| | | Gruppe | Vc [m/min] | |
|--|--------------------------------|--------|------------|---|
| ACIERS ALLIÉS ET NON ALLIÉS UNLEGIERTE STÄHLE NON-ALLOYED STEELS | Rm < 450 N/mm ² | 1a | 260 | ● |
| | Rm 450 - 700 N/mm ² | 1b | 150 | ● |
| | Rm 700 - 900 N/mm ² | 1c | 125 | ● |
| | Rm < 1200 N/mm ² | 1d | 80 | ● |
| ACIERS INOX ROSTFREIE STÄHLE STAINLESS STEELS | Rm < 650 N/mm ² | 2a | 150 | ● |
| | Rm 650 - 950 N/mm ² | 2b | 150 | ● |
| | Rm > 950 N/mm ² | 2c | 125 | ● |
| ACIERS TREMPÉS GEHÄRTETE STÄHLE HARDENED STEELS | 44 - 56 HRC | 3a | | |
| | 57 - 67 HRC | 3b | | |
| MATÉRIAUX EXOTIQUES EXOTISCHE WERKSTOFFE EXOTIC MATERIALS | < 32 HRC | 4a | 35 | ● |
| | > 32 HRC | 4b | 20 | ● |
| GRAPHITE | | 5 | 180 | ● |
| FONTES GUSS CAST IRON | < 32 HRC | 6a | 80 | ● |
| | > 32 HRC | 6b | 65 | ● |
| TITANE TITAN | Rm < 800 N/mm ² | 7a | 70 | ● |
| | 800 < Rm N/mm ² | 7b | 65 | ● |
| ALLIAGES NICKEL NICKEL NICKEL ALLOYS | Rm < 1000 N/mm ² | 8a | 35 | ● |
| | 1000 < Rm N/mm ² | 8b | 25 | ● |
| CUIVRE, LAITON, BRONZE KUPFER, MESSING, BRONZE COPPER, BRASS, BRONZE | Rm < 850 N/mm ² | 9a | 400 | ● |
| | 850 < Rm N/mm ² | 9b | 350 | ● |
| ALUMINIUM | Si < 0.5% | 10a | 400 | ● |
| | 0.5% < Si < 5% | 10b | 320 | ● |
| | Si > 5% | 10c | 185 | ● |
| MATIÈRES SYNTHÉTIQUES KUNSTSTOFFE SYNTHETIC MATERIALS | Thermoplast | 11a | 150 | ● |
| | Duraplast | 11b | 120 | ● |
| MATIÈRES COMPOSITES FASERVERST. MATERIALEN COMPOSITE MATERIALS | Fibre de verre | 12a | 130 | ● |
| | Fibre de carbone | 12b | 90 | ● |
| MÉTALUX PRÉCIEUX EDELMETALLE PRECIOUS MATERIALS | Or • Gold | 13a | 260 | ● |
| | Platine | 13b | 35 | ● |



| | |
|--------------|------|
| D (h10) | 25 |
| d (h6) | 8 |
| L | |
| l1 | |
| l3 | |
| d3 | |
| R | |
| e | 0.60 |
| Z | 64 |
| Chanfrein | |
| K | |
| w° collision | |