

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

25500A-80-1

Version du  
21.01.2025



HIS

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

Compatibilité outil / matière  
Werkzeug / Werkstoffverträglichkeit  
Tool / Material compatibility

● 1/3  
● 2/3  
● 3/3

H1S - ALPHA

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  | 260 | ● |
|                                                                            | Rm 450 - 700 N/mm <sup>2</sup> | 1b  | 150 | ● |
|                                                                            | Rm 700 - 900 N/mm <sup>2</sup> | 1c  | 125 | ● |
|                                                                            | Rm < 1200 N/mm <sup>2</sup>    | 1d  | 80  | ● |
| ACIERS INOX<br>ROSTFREIE STÄHLE<br>STAINLESS STEELS                        | Rm < 650 N/mm <sup>2</sup>     | 2a  | 150 | ● |
|                                                                            | Rm 650 - 950 N/mm <sup>2</sup> | 2b  | 150 | ● |
|                                                                            | Rm > 950 N/mm <sup>2</sup>     | 2c  | 125 | ● |
| 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  | 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 <sup>2</sup>     | 7a  | 70  | ● |
|                                                                            | 800 < Rm N/mm <sup>2</sup>     | 7b  | 65  | ● |
| ALLIAGES NICKEL<br>NICKEL<br>NICKEL ALLOYS                                 | Rm < 1000 N/mm <sup>2</sup>    | 8a  | 35  | ● |
|                                                                            | 1000 < Rm N/mm <sup>2</sup>    | 8b  | 25  | ● |
| CUIVRE, LAITON, BRONZE<br>KUPFER, MESSING, BRONZE<br>COPPER, BRASS, BRONZE | Rm < 850 N/mm <sup>2</sup>     | 9a  | 400 | ● |
|                                                                            | 850 < Rm N/mm <sup>2</sup>     | 9b  | 350 | ● |
| ALUMINIUM                                                                  | Si < 0.5%                      | 10a | 400 | ● |
|                                                                            | 0.5% < Si < 5%                 | 10b | 320 | ● |
|                                                                            | Si > 5%                        | 10c | 185 | ● |
| MATIÈRES SYNTHÉTIQUES<br>KUNSTSTOFFE<br>SYNTHETIC MATERIALS                | Thermoplast                    | 11a | 150 | ● |
|                                                                            | Duraplast                      | 11b | 120 | ● |
| MATIÈRES COMPOSITES<br>FASERVERST. MATERIALEN<br>COMPOSITE MATERIALS       | Fibre de verre                 | 12a | 130 | ● |
|                                                                            | Fibre de carbone               | 12b | 90  | ● |
| MÉTAUX PRÉCIEUX<br>EDELMETALLE<br>PRECIOUS MATERIALS                       | Or • Gold                      | 13a | 260 | ● |
|                                                                            | Platine                        | 13b | 35  | ● |



|              |      |
|--------------|------|
| D (h10)      | 80   |
| d (h6)       | 22   |
| L            |      |
| l1           |      |
| l3           |      |
| d3           |      |
| R            |      |
| e            | 1.00 |
| Z            | 100  |
| Chanfrein    |      |
| K            |      |
| w° collision |      |